



### **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	47	63-00-41210	O-Ring	2
2	63-00-4153	O-Ring	1	48	63-00-41135	O-Ring	1
3	63-I70X-201	Pulse Unit Housing	1	49	63-IS40-307	Rear Cover	1
4	63-I40S-202	Bushing	1	50	63-IS40-524	Valve Seat	1
5	63-I40S-424	Washer	1	51	63-00-41145	O-Ring	2
6	63-I70-401	Pulse Cylinder Seat	1	52	63-IS40S-312	Washer	1
7	63-I70-410	Greasing Screw	1	53	63-00-3824	Steel Ball	1
8	63-00-41113	O-Ring	4	54	63-IS40S-313	Spring	1
9	63-00-3318	Spring Pin	2	55	63-IS40S-311	Valve	1
10	63-00-41160	O-Ring	2	56	63-IS40-518	Seat	1
11	63-I70-403	Front Cover	1	57	63-IS70X-101	Motor Housing	1
12	63-I70-409	Back Up Ring	1	58	63-I40S-108	Bushing	4
13	63-00-2602	X-Ring	1	59	63-IS100-609	Screw	1
14EA	63-I80-411	Valve Screw	1	60	63-I40S-102	Hanger	1
15	63-00-3435	Pin	2	61	63-00-41146	O-Ring	1
16	63-I70-408	Front Plate	1	62	63-00-4169	O-Ring	1
17	63-I70-405-B	Anvil	1	63	63-I40-104	Nut	1
18	63-I70-406-B	Drive Blade	2	64	63-I40-504	Trigger	1
19	63-I70-452	Roller	2	65	63-00-3354	Spring Pin	1
20	63-I70-407	Spring	2	66	63-00-0505	Screw	2
21	63-IS40-450	Block Valve	1	67	63-I100-503	Regulator Knob	1
22	63-IS65-412	Valve	1	68	63-00-4101	O-Ring	1
23	63-00-41130	O-Ring	1	69	63-IS40-505B	Valve Stem	1
24	63-00-3813	Steel Ball	2	70	63-I100-508B	Bushing	1
25	63-IS65-425	Spring	1	71	63-00-41199	O-Ring	1
26	63-I70-404-B	Pulse Cylinder	1	72	63-I40-507B	Spring	1
27	63-00-3436	Pin	1	73	63-I100-506	Spring	1
28	63-00-41173	O-Ring	2	74	63-IS40-502	F/R Valve	1
29	63-IS40S-421	Pressure Valve	2	75	63-I40-501	Valve Sleeve	1
30	63-I70S-453	Spring	1	76	63-00-41111	O-Ring	2
31	63-I40S-454	Block Cap	1	77	63-I40-601	Muffler	1
32	63-00-3407	Pin	2	78	63-I40-603	Exhaust Deflector	1
33	63-IS65-415	Rear Plate	1		63-I40-604A	Air Inlet 1/4"-19PF	
34	63-IS60S-314	Shut Off Stem	1	79	63-I40-604B	Air Inlet 1/4"-19PT	1
35	63-IS40S-317	Spring	1		63-I40-604C	Air Inlet 1/4"-18NPT	
36	63-I40S-423	Washer	1	80	63-I100-511	Pin	1
37	63-I70-402	Lock Nut	1	81	63-I60-103	Housing Rubber	1
38	63-I70X-306	Lock Nut	1	82EA	63-I80-422	Back Up Ring	1
39	63-00-2348	Ball Bearing	1	•	63-I70X-109FL	Tool Cover	1
40	63-00-3324	Spring Pin	1	•	63-IS65SK-MZ	Service kit :Index No- 16; 18(2); 19(2); 33; 44(9);54; 70EA; 71EA; 72EA	
41	63-I65-302	Cylinder	1				
42	63-00-3356	Spring Pin	1				
43	63-I70S-303	Rotor	1	•	63-IS65RK-MZ	Repair kit :Index No- 8(2);10(2);12;13;20(2);23;28(2)	
44	63-I70S-304	Rotor Blade	9				
45	63-I70X-305	Rear Plate	1	•	63-I40-451	Impulse Oil	
46	63-00-2356	Ball Bearing	1				
•	63-IS65-400ASM	Pulse unit : Index No- 6,7,8,9,10,11,12,13,14EA,15,16,17,18,19,20,21,22,23,24,25,26,27,28,29,30,31,32,33,37,82EA					