



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	41	63-00-2356	Ball Bearing	1
2	63-00-4153	O-Ring	1	42	63-00-41135	O-Ring	1
3	63-I70X-201	Pulse Unit Housing	1	43	63-I40-307	Rear Cover	1
4	63-I40S-202	Bushing	1	44	63-00-41210	O-Ring	2
5	63-I40S-424	Washer	1	45	63-I70X-101	Motor Housing	1
6	63-I70-401	Pulse Cylinder Seat	1	46	63-I40S-108	Bushing	4
7	63-00-41160	O-Ring	2	47	63-I40S-102	Hanger	1
8	63-I70-410	Greasing Screw	1	48	63-00-41146	O-Ring	1
9	63-00-41113	O-Ring	2	49	63-I40-104	Nut	1
10	63-00-3318	Spring Pin	2	50	63-I40-504	Trigger	1
11	63-I70-403	Front Cover	1	51	63-00-3354	Spring Pin	1
12	63-I70-409	Back Up Ring	1	52	63-00-0505	Screw	2
13	63-00-2602	X-Ring	1	53	63-I100-503	Regulator Knob	1
14	63-I70-408	Front Plate	1	54	63-00-4101	O-Ring	1
15	63-I70-405-B	Anvil	1	55	63-IS40-505B	Valve Stem	1
16	63-I70-407	Spring	2	56	63-I100-508B	Bushing	1
17	63-I70-406-B	Drive Blade	2	57	63-00-41199	O-Ring	1
18	63-I70-452	Roller	2	58	63-I40-507B	Spring	1
19EA	63-I80-411	Valve Screw	1	59	63-00-3813	Steel Ball	1
20	63-IS65-412	Valve	1	60	63-I100-506	Spring	1
21	63-00-41130	O-Ring	1	61	63-IS40-502	F/R Valve	1
22	63-00-41173	O-Ring	1	62	63-I40-501	Valve sleeve	1
23	63-IS40S-421	Pressure Valve	1	63	63-00-41111	O-Ring	2
24	63-I70S-453	Spring	1	64	63-00-41145	O-Ring	1
25	63-00-3435	Pin	2	65	63-I40-601	Muffler	1
26	63-I70-404-B	Pulse Cylinder	1	66	63-I40-603	Exhaust Deflector	1
27	63-00-3436	Pin	1		63-I40-604A	Air Inlet 1/4"PF	
28	63-00-3407	Pin	2	67	63-I40-604B	Air Inlet 1/4"PT	1
29	63-I40S-454	Block Cap	1		63-I40-604C	Air Inlet 1/4"NPT	
30	63-I70-415	Rear Plate	1	68	63-I100-511	Pin	1
31	63-I40S-423	Washer	1	69	63-I60-103	Housing Rubber	1
32	63-I70-402	Lock Nut	1	70EA	63-I80-422	Back Up Ring	1
33	63-I70X-306	Lock Nut	1	•	63-I70X-109FL	Tool Cover	1
34	63-00-2348	Ball Bearing	1	•	63-I65SK-MZ	Service kit :Index No- 14;17(2);18(2);30;39(9); 56EA;57EA;58EA	
35	63-I65-302	Cylinder	1				
36	63-00-3324	Spring Pin	1	•	63-I65RK-MZ	Repair kit :Index No- 7(2);9(2);12;13;16(2);21;22	
37	63-00-3356	Spring Pin	1	•	63-I40-451	Impulse Oil	
38	63-I70S-303	Rotor	1				
39	63-I70S-304	Rotor Blade	9				
40	63-I70X-305	Rear Plate	1				
•	63-I65-400ASM	Pulse unit : Index No- 6,7,8,9,10,11,12,13,14,15,16,17,18,19EA,20,21,22,23,24,25,26,27,28,29,30,32,70EA					