



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	63-757-026	Anvil Collar	1	43	63-I40-307	Rear Cover	1
2	63-I40SD-419	Hold Spacer	1	44	63-00-41144	O-Ring	2
3	63-I40SD-418	Spring	1	45	63-I60-101	Motor Housing	1
4	63-I40SD-417	Quick change Hold	1	46	63-I40S-108	Bushing	4
5	63-I100-410	Greasing Screw	1	47	63-I40S-102	Hanger	1
6	63-00-4153	O-Ring	1	48	63-00-41146	O-Ring	1
7	63-I60S-201	Pulse Unit Housing	1	49	63-I40-104	Nut	1
8	63-I40S-202	Bushing	1	50	63-I40-504	Trigger	1
9	63-I40S-424	Washer	1	51	63-00-3354	Spring Pin	1
10	63-I60S-401	Pulse Cylinder Seat	1	52	63-00-0505	Screw	2
11	63-00-41127	O-Ring	2	53	63-I100-503	Regulator Knob	1
12	63-I70-410	Greasing Screw	1	54	63-00-4101	O-Ring	1
13	63-00-41113	O-Ring	2	55EA	63-IS40-505B	Valve Stem	1
14	63-00-3318	Spring Pin	2	56EA	63-I100-508B	Bushing	1
15EA	63-I40S-403-B	Front Cover	1	57EA	63-00-41199	O-Ring	1
16	63-00-2602	X-Ring	1	58EA	63-I40-507B	Spring	1
17	63-I40S-408	Front Plate	1	59	63-I100-506	Spring	1
18	63-00-3813	Steel Ball	3	60EB	63-IS40-502	F/R Valve	1
19	63-I60SD-405	Anvil	1	61	63-I40-501	Valve Sleeve	1
20B	63-I60S-452	Roller	2	62	63-00-41111	O-Ring	2
21B	63-I60S-406-B	Drive Blade	2	63	63-I100-511	Pin	1
22	63-I40S-407	Spring	2	64	63-00-41145	O-Ring	1
23EC	63-I80-411	Valve Screw	1	65	63-I40-601	Muffler	1
24C	63-IS60S-412-B	Valve	1	66	63-I40-603	Exhaust Deflector	1
25	63-00-41130	O-Ring	1		63-I40-604A	Air Inlet 1/4"-19PF	
26	63-00-3435	Pin	2	67	63-I40-604B	Air Inlet 1/4"-19PT	1
27C	63-I60S-404-B	Pulse Cylinder	1		63-I40-604C	Air Inlet 1/4"-18NPT	
28	63-00-3407	Pin	2	68C	63-00-41173	O-Ring	1
29	63-00-3436	Pin	1	69C	63-IS40S-421	Pressure Valve	1
30	63-I40S-415	Rear Plate	1	70C	63-I60S-453	Spring	1
31	63-I40S-423	Washer	1	71C	63-I40S-454	Block Cap	1
32	63-I40S-402	Lock Nut	1	72EA	63-I40-409	Back-Up Ring	1
33	63-I40S-306	Lock Nut	1	73EB	63-I60-103	Housing Rubber	1
34	63-00-2348	Ball Bearing	1	74EC	63-I80-422	Back-Up Ring	1
35	63-I60-302	Cylinder	1	•	63-I40-109FL	Tool Cover	1
36	63-00-3324	Spring Pin	1	•	63-I60DSK-MZ	Service kit	
37	63-00-3356	Spring Pin	1			17; 20B(2); 21B(2); 30;	
38	63-I60S-303	Rotor	1			39(9); 56EA; 57EA; 58EA	
39	63-I60S-304	Rotor Blade	9	•	63-I60DRK-MZ	Repair kit :Index No-	
40	63-I40-305	Rear Plate	1			11(2); 13(2) ; 16; 22(2); 25	
41	63-00-2356	Ball Bearing	1			68C; 72EA	
42	00-41135	O-Ring	1	•	I40-451	Impulse Oil	
•	63-I60SD-400ASM	Pulse unit : Index No- 10,11,12,13,14,15EA,16,17,19,20B,21B,22,23EC,24C,25,26,27C,28,29,30,32, 68C,69C,70C,71C,72EA ,74EC					