



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 is involve on the operation to calculate the accurate pulsing time. Here is an example:

Pulsing Time = 2 seconds

Pulses- seconds recommended = 250,000

$$250,000 \text{ pulses-sec} \div 2 \text{ sec} = 125,000 \text{ cycles}$$

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-I40S-108	Bushing	4
2	63-00-4153	O-Ring	1	42	63-I40S-102	Hanger	1
3	63-I40S-201	Pulse Unit Housing	1	43	63-00-41146	O-Ring	1
4	63-I40S-202	Bushing	1	44	63-I40-104	Nut	1
5	63-I40S-424	Washer	1	45	63-I40-504	Trigger	1
6	63-I40S-401	Pulse Cylinder Seat	1	46	63-00-3354	Spring Pin	1
7	63-00-41127	O-Ring	2	47	63-00-0505	Screw	2
8	63-I70-410	Greasing Screw	1	48	63-I100-503	Regulator Knob	1
9	63-00-41113	O-Ring	2	49	63-00-4101	O-Ring	1
10	63-00-3318	Spring Pin	2	50EA	63-IS40-505B	Valve Stem	1
11EA	63-I40S-403-B	Front Cover	1	51EA	63-I100-508B	Bushing	1
12	63-00-2602	X-Ring	1	52EA	63-00-41199	O-Ring	1
13	63-I40S-408	Front Plate	1	53EA	63-I40-507B	Spring	1
14EB	63-I40S-405-B	Anvil	1	54	63-00-3813	Steel Ball	1
15	63-I40S-407	Spring	2	55	63-I100-506	Spring	1
16B	63-I40S-406-B	Drive Blade	2	56EB	63-IS40-502	F/R Valve	1
17B	63-I40S-452	Roller	2	57	63-I40-501	Valve sleeve	1
18EC	63-I80-411	Valve Screw	1	58	63-00-41111	O-Ring	2
19C	63-IS40S-412-B	Valve	1	59	63-00-41145	O-Ring	1
20	63-00-41130	O-Ring	1	60	63-I40-601	Muffler	1
21	63-00-3435	Pin	2	61	63-I40-603	Exhaust Deflector	1
22C	63-I40S-404-B	Pulse Cylinder	1		63-I40-604A	Air Inlet 1/4"PF	
23	63-00-3436	Pin	1	62	63-I40-604B	Air Inlet 1/4"PT	1
24	63-00-3407	Pin	2		63-I40-604C	Air Inlet 1/4"NPT	
25	63-I40S-415	Rear Plate	1	63	63-I100-511	Pin	1
26	63-I40S-423	Washer	1	64C	63-00-41173	O-Ring	1
27	63-I40S-402	Lock Nut	1	65C	63-IS40S-421	Pressure Valve	1
28	63-I40S-306	Lock Nut	1	66C	63-I40S-453	Spring	1
29	63-00-2348	Ball Bearing	1	67C	63-I40S-454	Block Cap	1
30	63-I40-302	Cylinder	1	68EA	63-I40-409	Back-Up Ring	1
31	63-00-3324	Spring Pin	1	69EB	63-I60-103	Housing Rubber	1
32	63-00-3356	Spring Pin	1	70EC	63-I80-422	Back-Up Ring	1
33	63-I40S-303	Rotor	1	•	63-I40-109FL	Tool Cover	1
34	63-I40S-304	Rotor Blade	9	•	63-I40SK-MZ	Service kit :Index No- 13; 16B(2); 17B(2); 25;	
35	63-I40-305	Rear Plate	1			34(9); 51EA; 52EA; 53EA	
36	63-00-2356	Ball Bearing	1			Repair kit :Index No-	
37	63-00-41135	O-Ring	1	•	63-I40RK-MZ	7(2); 9(2) ; 12; 15(2); 20; 64C; 68EA	
38	63-I40-307	Rear Cover	1			Impulse Oil	
39	63-00-41144	O-Ring	2	•	63-I40-451		
40	63-I40-101	Motor Housing	1				
•	63-I40S-400ASM	Pulse unit : Index No- 6,7,8,9,10,11EA,12,13,14EB,15,16B,17B,18EC,19C,20,21,22C,23,24,25,27,64C,65C,66C,67C,68EA,70EC					