



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-IS70-307	Rear Cover	1
2	63-00-4153	O-Ring	1	48	63-IS100-524	Valve Seat	1
3	63-I70-201	Pulse Unit Housing	1	49	63-00-41127	O-Ring	2
4	63-I40S-202	Bushing	1	50	63-IS100-312	Washer	1
5	63-I40S-424	Washer	1	51	63-00-3824	Steel Ball	1
6	63-I70-401	Pulse Cylinder Seat	1	52	63-IS100-313	Spring	1
7	63-I70-410	Greasing Screw	1	53	63-IS100-311	Valve	1
8	63-00-41113	O-Ring	4	54	63-IS100-518	Seat	1
9	63-00-3318	Spring Pin	1	55	63-IS90-101	Motor Housing	1
10	63-00-41160	O-Ring	2	56	63-I40S-108	Bushing	4
11	63-I70-403	Front Cover	1	57	63-IS100-609	Screw	1
12	63-I70-409	Back Up Ring	1	58	63-I40S-102	Hanger	1
13	63-00-2602	X-Ring	1	59	63-00-41166	O-Ring	1
14EC	63-I80-411	Valve Screw	1	60	63-I100-104	Nut	1
15	63-00-3435	Pin	2	61	63-I130-504	Trigger	1
16	63-I70-408	Front Plate	1	62	63-00-3354	Spring Pin	1
17EB	63-I70-405-B	Anvil	1	63	63-00-0505	Screw	2
18B	63-I70-406-B	Drive Blade	2	64	63-I100-503	Regulator Knob	1
19B	63-I70-452	Roller	2	65	63-00-4101	O-Ring	1
20	63-I70-407	Spring	2	66EA	63-IS100-505B	Valve stem	1
21B	63-IS40-450	Block Valve	1	68EA	63-I100-508B	Bushing	1
22EA	63-IS70-412-C	Valve	1	69EA	63-00-41199	O-Ring	1
23	63-00-41130	O-Ring	1	70EA	63-I100-507B	Spring	1
24	63-00-3813	Steel Ball	2	71	63-I100-506	Spring	1
25EA	63-IS70-425-C	Spring	1	72	63-IS100-502	F/R Valve	1
26C	63-I70-404-B	Pulse Cylinder	1	73	63-I100-501	Valve Sleeve	1
27	63-00-3436	Pin	1	74	63-00-41111	O-Ring	2
28	63-00-3407	Pin	2	75	63-00-4158	O-Ring	1
29EA	63-IS70-415-C	Rear Plate	1	76	63-I70-601	Muffler	1
30C	63-00-41173	O-Ring	2	77	63-I100-603	Exhaust Deflector	1
31C	63-IS40S-421	Pressure Valve	2		63-I100-604A	Air Inlet 1/4"PF 19	
32	63-IS90-314	Shut Off Stem	1	78	63-I100-604B	Air Inlet 1/4"PT 19	1
33EA	63-IS150-317	Spring	1		63-I100-604C	Air Inlet 1/4"NPT 18	
34	63-I40S-423	Washer	1	79	63-I100-511	Pin	1
35	63-I70-402	Lock Nut	1	80C	63-I70S-453	Spring	1
36	63-I90-306	Lock Nut	1	81C	63-I40S-454	Block Cap	1
37	63-00-2348	Ball Bearing	1	82EB	63-I90-103	Housing Rubber	1
38	63-00-3324	Spring Pin	1	83EC	63-I80-422	Back Up Ring	1
39	63-I70-302	Cylinder	1	•	63-I70-109FL	Tool Cover	1
40	63-00-3339	Spring Pin	1	•	63-IS70SK-MZ	Service kit :Index No-	
41	63-I70-303	Rotor	1			16;18B(2);19B(2); 29EA;	
42	63-I70-304	Rotor Blade	9			42(9);52; 68EA; 69EA; 70EA	
43	63-I70-305	Rear Plate	1	•	63-IS70RK-MZ	Repair kit :Index No-	
44	63-00-2356	Ball Bearing	1			8(2);10(2);12;13;20(2);23;30C(2)	
45	63-00-41181	O-Ring	2	•	63-I40-451	Impulse Oil	
46	63-00-41138	O-Ring	1				
•	63-IS70-400ASM	Pulse unit : Index No- 6,7,8,9,10,11,12,13,14EC,15,16,17EB,18B,19B,20,21B,22EA,23,24,25EA,26C,27,28,29EA,30C,31C, 35,80C,81C,83EC					