



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 recommend 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	48	63-00-41145	O-Ring	2
2	63-00-4153	O-Ring	1	49	63-IS40S-312	Washer	1
3	63-I80H-201	Pulse Unit Housing	1	50	63-00-3824	Steel Ball	1
4	63-I140S-202	Bushing	1	51	63-IS40S-313	Spring	1
5	63-I100-424	Washer	1	52	63-IS40S-311	Valve	1
6	63-I80-401	Pulse Cylinder Seat	1	53	63-IS40-518	Seat	1
7	63-I70-410	Greasing Screw	1	54	63-IS80-101	Motor Housing	1
8	63-00-41113	O-Ring	4	55	63-I40S-108	Bushing	4
9	63-00-3325	Spring Pin	2	56	63-IS100-609	Screw	1
10	63-00-41212	O-Ring	2	57	63-I40S-102	Hanger	1
11	63-I80-408	Front Cover	1	58	63-00-41146	O-Ring	1
12	63-00-2602	X-Ring	1	59	63-00-4169	O-Ring	1
13	63-I80-411	Valve Screw	1	60	63-I40-104	Nut	1
14	63-00-3407	Pin	4	61	63-I40-504	Trigger	1
16	63-I80-405	Anvil	1	62	63-00-3354	Spring Pin	1
17	63-I80-406	Drive Blade	2	63	63-00-0512	Screw	2
18	63-I90-452	Roller	2	64	63-I100-503	Regulator Knob	1
19	63-I80-407	Spring	2	65	63-00-4101	O-Ring	1
20	63-IS40-450	Block Valve	1	66	63-IS40-505B	Valve Stem	1
21	63-IS80-412	Valve	1	67	63-I100-508B	Bushing	1
22	63-00-41162	O-Ring	1	68	63-00-41199	O-Ring	1
23	63-00-3813	Steel Ball	2	69	63-I40-507B	Spring	1
24	63-IS80-425	Spring	1	70	63-I100-506	Spring	1
25	63-I80-404	Pulse Cylinder	1	71	63-IS40-502	F/R Valve	1
26	63-00-3436	Pin	1	72	63-I40-501	Valve Sleeve	1
28	63-IS80-415	Rear Plate	1	73	63-00-4121	O-Ring	2
29	63-00-41173	O-Ring	2	74	63-I40-601	Muffler	1
30	63-IS40S-421	Pressure Valve	2	75	63-I40-603	Exhaust Deflector	1
31	63-IS80-314	Shut Off Stem	1		63-I40-604A	Air Inlet 1/4"-19PF	
32	63-IS150-317	Spring	1	76	63-I40-604B	Air Inlet 1/4"-19PT	1
33	63-I40S-423	Washer	1		63-I40-604C	Air Inlet 1/4"-18NPT	
34	63-I80-402	Lock Nut	1	77	63-I100-511	Pin	1
35	63-I80-306	Lock Nut	1	78	63-I90-453	Spring	1
36	63-00-2348	Ball Bearing	1	79	63-I40S-454	Block Cap	1
37	63-00-3324	Spring Pin	1	80	63-I100-409	Back Up Ring	1
38	63-I80-302	Cylinder	1	81	63-I60-103	Housing Rubber	1
39	63-00-3356	Spring Pin	1	82	63-I80-422	Back Up Ring	1
40	63-I80S-303	Rotor	1	83	63-00-41117	O-Ring	1
41	63-I80S-304	Rotor Blade	9	84	63-00-41244	O-Ring	1
42	63-I80-305	Rear Plate	1	•	63-IS80RK-MZ	Repair kit :Index No-	
43	63-00-2332	Ball Bearing	1			8(2);10(2);12;19(2);22;29(2);80;82	
44	63-00-41213	O-Ring	2	•	63-IS80SK-MZ	Service kit :Index No-	
45	63-00-41214	O-Ring	1			17(2);18(2);28; 41(9); 51;67;68	
46	63-IS80-307	Rear Cover	1			69;83	
47	63-IS40-524	Valve Seat	1	•	63-I40S-451	Impulse Oil	
•	63-IS80H-400ASM	Pulse unit : Index No- 6,7,8,9,10,11,12,13,14 ,16,17,18,19,20,21, 22, 23, 24,25,26,28,29,30,34,78,79,80,82,83					