



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-I70RH-706	Lock Nut	1	47	63-00-3324	Spring Pin	1
2	63-00-41192	O-Ring	1	48	63-I80S-302	Cylinder	1
3	63-00-2353	Ball Bearing	1	49	63-I80S-303	Rotor	1
5	63-I80RH-705	Shaft Gear	1	50	63-I80S-304	Rotor Blade	9
6	63-I70RH-707	Shaft	1	51	63-00-3326	Spring Pin	1
7	63-00-2357	Ball Bearing	1	52	63-I80S-305	Rear Plate	1
8	63-I90-410	Greasing Screw	1	53	63-00-2332	Ball Bearing	1
9	63-00-4153	O-Ring	1	54	63-I80S-310	Air Inlet Plate	1
10	63-I70RH-701	Angle Housing	1	55	63-00-3813	Steel Ball	1
11	63-00-0605	Set Screw	1	56	63-305F-034	Spring	1
12	63-I70RH-704	Main Shaft Gear	1	57	63-I80S-502	F/R Valve	1
13	63-I70RH-712	Washer	1	58	63-00-41160	O-Ring	1
14	63-00-2376	Ball Bearing	2	59	63-00-41125	O-Ring	1
15	63-I70RH-709	Lock Nut	1	60	63-I40S-309	Seat	1
16	63-I70RH-702	Lock Nut	1	61	63-00-0507	Screw	1
17	63-I70RH-708	Anvil Collar	1	62	63-I40S-503	Regulator Knob	1
18	63-00-3448	Pin	1	63	63-I80S-101	Motor Housing	1
19	63-I70RH-201	Pulse Unit Housing	1	64	63-I80S-509	Bushing	1
20	63-I40S-202	Bushing	1	65	63-I40S-510B	Pin	1
21	63-I40S-424	Washer	1	66	63-I40S-504	Trigger	1
22	63-I70-401	Pulse Cylinder Seat	1	67	63-00-3306	Spring Pin	1
23	63-00-41160	O-Ring	2	68	63-I40S-102	Hanger	1
24	63-I70-410	Greasing Screw	1	69	63-I40S-108	Bushing	2
25	63-00-41113	O-Ring	2	70	63-I80S-103	Housing Rubber	1
26	63-00-3318	Spring Pin	2	71	63-00-41127	O-Ring	1
27	63-I70-403	Front Cover	1	72	63-I40S-508	Bushing	1
28	63-I70-409	Back Up Ring	1	73	63-305C-021	Valve Stem	1
29	63-00-2602	X-Ring	1	74	63-I40S-507	Spring	1
30	63-I40S-411	Valve Screw	1	75	63-I40S-601	Muffler	1
31	63-IS70-412-B	Valve	1	76	63-I40S-603	Exhaust Deflector	1
32	63-00-41130	O-Ring	1		63-I40S-604A	Air Inlet 1/4"PF	
33	63-00-3435	Pin	2	77	63-I40S-604B	Air Inlet 1/4"PT	1
34	63-I70-408	Front Plate	1		63-I40S-604C	Air Inlet 1/4"NPT	
35	63-I70RH-405	Anvil	1	78	63-00-3509	Snap Ring	1
36	63-I70-452	Roller	2	79	63-00-41173	O-Ring	1
37	63-I70-406-B	Drive Blade	2	80	63-IS40S-421	Pressure Valve	1
38	63-I70-407	Spring	2	81	63-I70S-453	Spring	1
39	63-I70-404-B	Pulse Cylinder	1	82	63-I40S-454	Block Cap	1
40	63-00-3436	Pin	1	※	63-I80RHRK-MZ	Repair kit :Index No- 23(2);25(2);28;29;32;38(2);79	
41	63-00-3407	Pin	2				
42	63-I70-415	Rear Plate	1	※	63-I80RHSK-MZ	Service kit :Index No- 5;12;34;36(2);37(2); 42; 50(9); 72; 73; 74	
43	63-I40S-423	Washer	1				
44	63-I70-402	Lock Nut	1				
45	63-I70S-306	Lock Nut	1	※	63-I40-451	Impulse Oil	
46	63-00-2348	Ball Bearing	1				
※	63-I70RH-400ASM	Pulse unit :Index No- 22,23,24,25,26,27,28,29,30,31,32,33,34,35,36,37,38,39,40,41,42,44,79,80,81,82					