



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	63-00-0612	Screw	1	46	63-IS100-524	Valve Seat	1
2	63-I100-201	Pulse Unit Housing	1	47	63-00-41127	O-Ring	2
3	63-I100-202	Bushing	1	48	63-IS100-312	Washer	1
4	63-I100-424	Washer	1	49	63-00-3824	Steel Ball	1
5	63-I100-401	Pulse Cylinder Seat	1	50	63-IS100-313	Spring	1
6	63-00-41106	O-Ring	2	51	63-IS100-311	Valve	1
7	63-00-3426	Spring Pin	2	52	63-IS100-518	Seat	1
8	63-I100-408	Front Plate	1	53	63-IS100-101	Motor Housing	1
9	63-I100-410	Greasing Screw	1	54	63-I40S-108	Bushing	4
10	63-00-4153	O-Ring	2	55	63-IS100-609	Screw	1
11	63-I100-411	Valve Screw	1	56	63-I40S-102	Hanger	1
12	63-I100-409	Back Up Ring	1	57	63-00-41166	O-Ring	1
13	63-00-2601	X-Ring	1	58	63-I100-104	Nut	1
14EB	63-I100-405-B	Anvil	1	59	63-I130-504	Trigger	1
15B	63-I100-406-B	Drive Blade	2	60	63-00-3354	Spring Pin	1
16	63-I100-407	Spring	2	61	63-00-0505	Screw	2
17B	63-I100-452	Roller	2	62	63-I100-503	Regulator Knob	1
19EA	63-IS100-412-B	Valve	1	63EA	63-IS100-505B	Valve Stem	1
20	63-00-4101	O-Ring	2	65EA	63-I100-508B	Bushing	1
21	63-00-3813	Steel Ball	2	66EA	63-00-41199	O-Ring	1
22D	63-IS100-425-B	Spring	1	67EA	63-I100-507B	Spring	1
23	63-00-3432	Pin	4	68	63-I100-506	Spring	1
24C	63-I100-404-B	Pulse Cylinder	1	69	63-IS100-502	F/R Valve	1
25	63-00-3441	Pin	1	70	63-I100-501	Valve Sleeve	1
26EA	63-IS100-415-B	Rear Plate	1	71	63-00-41111	O-Ring	2
27C	63-00-41173	O-Ring	2	72	63-00-4158	O-Ring	1
28C	63-IS40S-421	Pressure Valve	2	73EB	63-I70-601	Muffler	1
29	63-IS100-314	Shut Off Stem	1	74	63-I100-603	Exhaust Deflector	1
30EA	63-IS150-317	Spring	1		63-I100-604A	Air Inlet 1/4"-19PF	
31	63-I100-423	Washer	1	75	63-I100-604B	Air Inlet 1/4"-19PT	1
32	63-I100-402	Lock Nut	1		63-I100-604C	Air Inlet 1/4"-18NPT	
33	63-I100-306	Lock Nut	1	76	63-I100-511	Pin	1
34	63-00-2345	Ball Bearing	1	77C	63-I100-453	Spring	1
35	63-00-3324	Spring Pin	1	78C	63-I40S-454	Block Cap	1
36	63-I100-302	Cylinder	1	79C	63-IS100-456	Spring fixed Pin	1
37	63-00-3339	Spring Pin	1	80EB	63-I100-103	Housing Rubber	1
38	63-I100-303	Rotor	1	81	63-IS40-450	Block Valve	1
39	63-I100-304	Rotor Blade	9	×	63-I100-109FL	Tool Cover	1
40	63-I100-305	Rear Plate	1	×	63-IS100SK-MZ	Service kit :Index No-	
41	63-00-2358	Ball Bearing	1			8;15B(2);17B(2); 26EA; 39(9);	
42	63-00-41138	O-Ring	1			50; 65EA; 66EA; 67EA	
43	63-IS100-307	Rear Cover	1	×	63-IS100RK-MZ	Repair kit :Index No-	
44	63-00-41116	O-Ring	2			6(2);10(2);12;13;16(2);20;27C(2)	
45	63-00-41113	O-Ring	2	×	63-I40-451	Impulse Oil	
×	63-IS100-400ASM	Pulse unit : Index No- 5,6,7,8,9,10,11,12,13,14EB,15B,16,17B, 19EA,20,21,22D,23,24C,25,26EA,27C,28C,32, 77C, 78C,79C,81					