



### 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	51	63-I70-402	Lock Nut	1
2	63-00-41192	O-Ring	1	52	63-I70S-306	Lock Nut	1
3	63-00-2353	Ball Bearing	1	53	63-00-2348	Ball Bearing	1
5	63-I80RH-705	Shaft Gear	1	54	63-00-3324	Spring Pin	1
6	63-I70RH-707	Shaft	1	55	63-I80S-302	Cylinder	1
7	63-00-2357	Ball Bearing	1	56	63-00-3326	Spring Pin	1
8	63-I90-410	Greasing Screw	1	57	63-I80S-303	Rotor	1
9	63-00-4153	O-Ring	1	58	63-I80S-304	Rotor Blade	9
10	63-I70RH-701	Angle Housing	1	59	63-I80S-305	Rear Plate	1
11	63-00-0605	Set Screw	1	60	63-00-2332	Ball Bearing	1
12	63-I70RH-704	Main Shaft Gear	1	61	63-I80S-310	Air Inlet Plate	1
13	63-I70RH-712	Washer	1	62	63-305F-034	Spring	1
14	63-00-2376	Ball Bearing	2	63	63-IS80S-502	F/R Valve	1
15	63-I70RH-709	Lock Nut	1	65	63-00-4121	O-Ring	1
16	63-I70RH-702	Lock Nut	1	66	63-IS40S-312	Valve Washer	1
17	63-I70RH-708	Anvil Collar	1	67	63-00-3824	Steel Ball	1
18	63-00-3448	Pin	1	68	63-IS40S-313	Spring	1
19	63-I70RH-201	Pulse Unit Housing	1	69	63-IS40S-311	Valve	1
20	63-I40S-202	Bushing	1	70	63-00-41125	O-Ring	1
21	63-I40S-424	Washer	1	71	63-I40S-309	Seat	1
22	63-I70-401	Pulse Cylinder Seat	1	72	63-00-0507	Screw	1
23	63-00-41160	O-Ring	3	73	63-I40S-503	Regulator Knob	1
24	63-00-41113	O-Ring	3	74	63-I80S-101	Motor Housing	1
25	63-I70-410	Greasing Screw	1	75	63-I40S-102	Hanger	1
26	63-00-3318	Spring Pin	2	76	63-I80S-509	Bushing	1
27	63-I70-403	Front Cover	1	77	63-IS80S-510	Pin	1
28	63-I70-409	Back Up Ring	1	78	63-I40S-504	Trigger	1
29	63-00-2602	X-Ring	1	79	63-I40S-108	Bushing	2
30	63-I70-408	Front Plate	1	80	63-00-3306	Spring Pin	1
31	63-I70RH-405	Anvil	1	81	63-I80S-103	Housing Rubber	1
32	63-I70-452	Roller	2	82	63-00-41127	O-Ring	1
33	63-I70-406-B	Drive Blade	2	83	63-I40S-508	Bushing	1
34	63-I70-407	Spring	2	84	63-305C-021	Valve Stem	1
35	63-IS40-450	Block Valve	1	85	63-I40S-507	Spring	1
36EA	63-I80-411	Valve Screw	1	86	63-I40S-601	Muffler	1
37	63-IS70-412-C	Valve	1	87	63-I40S-603	Exhaust Deflector	1
38	63-00-3813	Steel Ball	2		63-I40S-604A	Air Inlet 1/4"PF	
39	63-IS80RH-425	Spring	1	88	63-I40S-604B	Air Inlet 1/4"PT	1
40	63-00-3436	Pin	1		63-I40S-604C	Air Inlet 1/4"NPT	
41	63-I70-404-B	Pulse Cylinder	1	89	63-00-3509	Snap Ring	1
42	63-00-41130	O-Ring	1	90	63-I70S-453	Spring	1
43	63-00-3435	Pin	2	91	63-I40S-454	Block Cap	1
44	63-00-3407	Pin	2	92EA	63-I80-422	Back Up Ring	1
45	63-IS70-415-C	Rear Plate	1	×	63-IS80RHRK-MZ	Repair kit kit :Index No-23(2); 24(2); 28;29; 34(2);47(2)	
46	63-I40S-423	Washer	1				
47	63-00-41173	O-Ring	2	×	63-IS80RHSK-MZ	Service kit :Index No-5; 12; 30; 32(2);33(2) 45;58(9); 68; 83; 84; 85	
48	63-IS40S-421	Pressure Valve	2				
49	63-IS80RH-314	Shut Off Stem	1				
50	63-IS150-317	Spring	1	×	63-I40-451	Impulse Oil	
×	63-IS80RH-400ASM	Pulse unit includes: Index No : <u>22,23,24,25,26,27,28,29,30,31,32,33,34,35,36EA,37,38,39,40,41,42,43,44,45,47,48,51,90,91,92E</u>					