



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-I90-410	Greasing Screw	2	46	63-00-41138	O-Ring	1
2	63-00-4153	O-Ring	4	47	63-IS130-312	Washer	2
3	63-I130-201	Pulse Unit Housing	1	48	63-00-3824	Steel Ball	1
4	63-I100-202	Bushing	1	49	63-IS130-313	Spring	1
5	63-I100-424	Washer	1	50	63-IS130-311	Valve	1
6	63-I130-401	Pulse Cylinder Seat	1	51	63-IS130-518	Seat	1
7	63-00-41181	O-Ring	2	52	63-IS130-101	Motor Housing	1
8	63-00-3426	Pin	2	53	63-I40S-108	Bushing	4
9	63-I130-408	Front Plate	1	54	63-IS100-609	Screw	1
10	63-I130-431	Back-Up Ring	1	55	63-I40S-102	Hanger	1
11	63-I130-411	Valve Screw	1	56D	63-00-41194	O-Ring	1
12	63-I100-409	Back-Up Ring	1	57	63-I130-104	Nut	1
13	63-00-2601	X-Ring	1	58	63-I130-504	Trigger	1
14EB	63-I130-405-B	Anvil	1	59	63-00-3354	Spring Pin	1
15B	63-I130-406-B	Drive Blade	2	60	63-00-0505	Screw	2
16	63-I130-407	Spring	2	61	63-I100-503	Regulator Knob	1
17B	63-I130-452	Roller	2	62	63-00-4101	O-Ring	1
18B	63-IS40-450	Block Valve	1	63EA	63-IS130-505B	Valve Stem	1
19	63-IS130-412	Valve	1	65EA	63-I100-508B	Bushing	1
20	63-00-3813	Steel Ball	2	66EA	63-00-41199	O-Ring	1
21EA	63-IS130-425-C	Spring	1	67EA	63-I100-507B	Spring	1
22	63-00-3432	Pin	4	68	63-I100-506	Spring	1
23C	63-I130-404-B	Pulse Cylinder	1	69	63-IS130-502	F/R Valve	1
24	63-00-3428	Pin	1	70	63-I130-501	Valve Sleeve	1
25EA	63-IS130-415-C	Rear Plate	1	71	63-00-41145	O-Ring	1
26	63-00-41173	O-Ring	1	72	63-I130-511	Pin	1
27	63-IS40S-421	Pressure Valve	1	73	63-00-4158	O-Ring	1
28	63-IS130-314	Shut Off Stem	1	74EB	63-I70-601	Muffler	1
29EA	63-IS40S-317	Spring	1	75	63-I100-603	Exhaust Deflector	1
30	63-I100-423	Washer	1	76	63-00-41111	O-Ring	1
31	63-I130-402	Lock Nut	1		63-I100-604A	Air Inlet 1/4"-19PF	
32	63-I130-306	Lock Nut	1	77	63-I100-604B	Air Inlet 1/4"-19PT	1
33	63-00-2353	Ball Bearing	1		63-I100-604C	Air Inlet 1/4"-18NPT	
34	63-00-3324	Spring Pin	1	78C	63-I130-453	Spring	1
35	63-I130-302	Cylinder	1	79C	63-I130-454	Block Cap	1
36	63-00-3361	Spring Pin	1	80C	63-I130-455	Pressure Valve	1
37	63-I130-303	Rotor	1	81EB	63-I130-103	Housing Rubber	1
38	63-I130-304	Rotor Blade	9	×	63-I130-109FL	Tool Cover	1
39	63-I130-305	Rear Plate	1	×	63-IS130SK-MZ	Service kit :Index No-9; 15B(2);17B(2); 25EA;	
40	63-00-2345	Ball Bearing	1			38(9); 49; 65EA; 66EA; 67EA	
41	63-00-41182	O-Ring	2				
42D	63-00-4135	O-Ring	1	×	63-IS130RK-MZ	Repair kit :Index No-2(2);7(2); 10; 12; 13;	
43	63-IS130-307	Rear Cover	1			16(2);26;44C	
44C	63-00-41113	O-Ring	3	×	63-I40-451	Impulse Oil	
45	63-IS130-524	Valve Seat	1				
×	63-IS130-400ASM	Pulse unit : Index No-1,2,6,7,8,9,10,11,12,13,14EB,15B,16,17B,18B,19,20,21EA,22,23C,24,25EA,26,27,31,44C,78C, 79C, 80C					