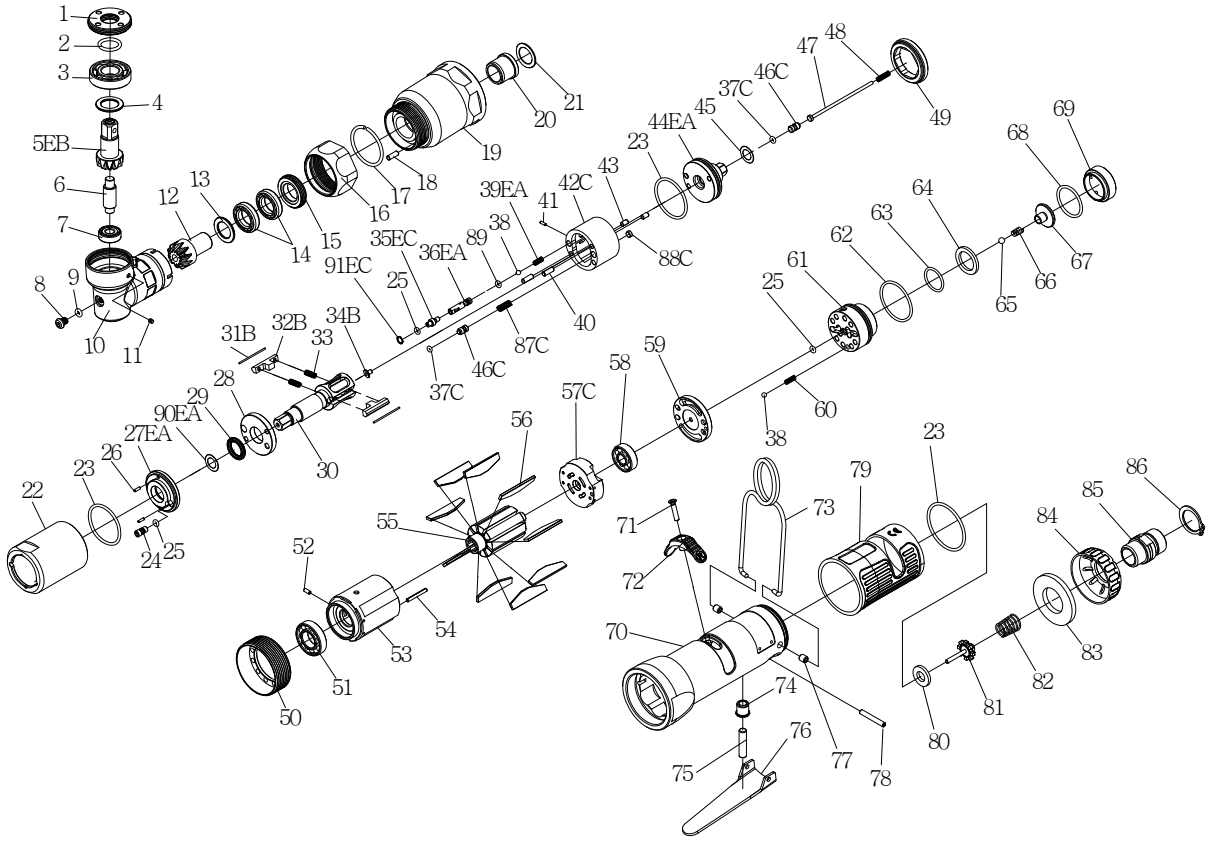


Recommendations for Maintenance:

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, which either one occurs first. The tool's performance should be evaulated. 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.

Pulsing Seconds ÷ Total of Pulsing Time = 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 pulses-sec ÷ 2 sec = 125,000 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*7) = 59	59 days

Index No.	Part No.	Description	Q'ty	Index No.	Part No.	Description	Q'ty
1	63-I50R-706	Lock Nut	1	51	63-00-2348	Ball Bearing	1
2	63-00-41134	O-Ring	1	52	63-00-3324	Spring Pin	1
3	63-00-2358	Ball Bearing	1	53	63-I60S-302	Cylinder	1
4	63-I50R-711	Washer	1	54	63-00-3326	Spring Pin	1
5EB	63-I50R-705-B	Shaft Gear	1	55	63-I60S-303	Rotor	1
6	63-I50R-707	Shaft	1	56	63-I60S-304	Rotor Blade	9
7	63-00-2357	Ball Bearing	1	57C	63-I60R-305	Rear Plate	1
8	63-I90-410	Greasing Screw	1	58	63-00-2356	Ball Bearing	1
9	63-00-4153	O-Ring	1	59	63-I40S-310	Air inlet Plate	1
10	63-I50R-701	Angle Housing	1	60	63-305F-034	Spring	1
11	63-00-0605	Set Screw	1	61	63-IS40S-502	F/R Valve	1
12	63-I50R-704	Main Shaft Gear	1	62	63-00-41146	O-Ring	1
13	63-I50R-712	Washer	1	63	63-00-4121	O-Ring	1
14	63-00-2352	Ball Bearing	2	64	63-IS40S-312	Valve Washer	1
15	63-I50R-709	Lock Nut	1	65	63-00-3824	Steel Ball	1
16	63-I50R-702	Lock Nut	1	66	63-IS40S-313	Spring	1
17	63-I50R-708	Anvil Collar	1	67	63-IS40S-311	Valve	1
18	63-00-3430	Pin	1	68	63-00-41125	O-Ring	1
19	63-I60R-201	Pulse Unit Housing	1	69	63-I40S-309	Seat	1
20	63-I40S-202	Bushing	1	70	63-I60S-101	Motor Housing	1
21	63-I40S-424	Washer	1	71	63-00-0507	Screw	1
22	63-I60S-401	Pulse Cylinder Seat	1	72	63-I40S-503	Regulator Knob	1
23	63-00-41127	O-Ring	3	73	63-I40S-102	Hanger	1
24	63-I70-410	Greasing Screw	1	74	63-I40S-509	Bushing	1
25	63-00-41113	O-Ring	3	75	63-IS40S-510	Pin	1
26	63-00-3318	Spring Pin	2	76	63-I40S-504	Trigger	1
27EA	63-I40S-403-B	Front Cover	1	77	63-I40S-108	Bushing	2
28	63-I40S-408	Front Plate	1	78	63-00-3306	Spring Pin	1
29	63-00-2602	X-Ring	1	79	63-I40S-103	Rubber	1
30	63-I60R-405	Anvil	1	80	63-I40S-508	Bushing	1
31B	63-I60S-452	Roller	2	81	63-305C-021	Valve Stem	1
32B	63-I60S-406-B	Drive Blade	2	82	63-I40S-507	Spring	1
33	63-I40S-407	Spring	2	83	63-I40S-601	Muffler	1
34B	63-IS40-450	Block Valve	1	84	63-I40S-603	Exhaust Deflector	1
35EC	63-I80-411	Screw	1		63-I40S-604A	Air Inlet 1/4”PF-19	
36EA	63-IS60S-412-C	Valve	1	85	63-I40S-604B	Air Inlet 1/4”PT-19	1
37C	63-00-41173	O-Ring	2		63-I40S-604C	Air Inlet 1/4”NPT-18	
38	63-00-3813	Steel Ball	2	86	63-00-3509	Snap Ring	1
39EA	63-IS60R-425-C	Spring	1	87C	63-I60S-453	Spring	1
40	63-00-3435	Pin	2	88C	63-I40S-454	Block cap	1
41	63-00-3436	Pin	1	89	63-00-41130	O-Ring	1
42C	63-I60S-404-B	Pulse Cylinder	1	90EA	63-I40-409	Back Up Ring	1
43	63-00-3407	Pin	2	91EC	63-I80-422	Back Up Ring	1
44EA	63-IS40S-415-C	Rear Plate	1	•	63-IS60RSK-MZ	Service kit :Index No-	
45	63-I40S-423	Washer	1			5EB; 12; 28; 31B(2); 32B(2) ;	
46C	63-IS40S-421	Pressure Valve	2			44EA ; 56(9); 66; 80; 81; 82	
47	63-IS60S-314	Shut Off Stem	1	•	63-IS60RRK-MZ	Repair kit :Index No-	
48	63-IS40S-317	Spring	1			23(2);25(2);29,33(2);37C(2);89;90EA	
49	63-I40S-402	Lock Nut	1	•	63-I40-451	Impulse Oil	
50	63-I40S-306	Lock Nut	1				
•	63-IS60R-400ASM	Pulse unit : Index No- 22,23,24,25,26,27EA,28,29,30,31B,32B,33,34B,35EC,36EA, 88C,89,90EA,91EC					