



### **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	63-747-002	Spring Holder	1	47	63-I70S-306	Lock Nut	1
2	63-I50R-706	Lock Nut	1	48	63-00-2348	Ball Bearing	1
3	63-00-41134	O-Ring	1	49	63-00-3324	Spring Pin	1
4	63-00-2358	Ball Bearing	1	50	63-I70S-302	Cylinder	1
5	63-I50R-711	Washer	1	51	63-I70S-303	Rotor	1
6	63-00-3813	Steel Ball	2	52	63-I70S-304	Rotor Blade	9
7	63-I50RD-705	Shaft Gear	1	53	63-00-3326	Spring Pin	1
8	63-I50R-707	Shaft	1	54	63-I50S-305	Rear End Plate	1
9	63-00-2357	Ball Bearing	1	55	63-00-2356	Ball Bearing	1
10	63-I90-410	Greasing Screw	1	56	63-I40S-310	Airinlet Plate	1
11	63-00-4153	O-Ring	1	57	63-305F-034	Spring	1
12	63-I50R-701	Angle Housing	1	58	63-I40S-502	F/R Valve	1
13	63-00-0605	Set Screw	1	59	63-00-41146	O-Ring	1
14	63-I50R-704	Main Shaft Gear	1	60	63-00-41125	O-Ring	1
15	63-I50R-712	Washer	1	61	63-I40S-309	Seat	1
16	63-00-2352	Ball Bearing	2	62	63-I70S-101	Motor Housing	1
17	63-I50R-709	Lock Nut	1	63	63-00-0507	Screw	1
18	63-I50R-702	Lock Nut	1	64	63-I40S-503	Regulator Knob	1
19	63-I50R-708	Anvil Collar	1	65	63-I40S-102	Hanger	1
20	63-00-3430	Pin	1	66	63-I40S-509	Bushing	1
21	63-I70R-201	Pulse Unit Housing	1	67	63-I40S-510	Pin	1
22	63-I40S-202	Bushing	1	68	63-I40S-504	Trigger	1
23	63-I40S-424	Washer	1	69	63-I40S-108	Bushing	2
24	63-I70-401	Pulse Cylinder Seat	1	70	63-00-3306	Spring Pin	1
25D	63-00-41160	O-Ring	2	71	63-I40S-103	Housing Rubber	1
26	63-00-41113	O-Ring	2	72	63-I40S-508	Bushing	1
27	63-I70-410	Greasing Screw	1	73	63-305C-021	Valve Stem	1
28	63-00-3318	Spring Pin	2	74	63-I40S-507	Spring	1
29	63-I70-403	Front Cover	1	75	63-I40S-601	Muffler	1
30	63-I70-409	Back Up Ring	1	76	63-I40S-603	Exhaust Deflector	1
31	63-00-2602	X-Ring	1		63-I40S-604A	Air Inlet 1/4"PF-19	
32EB	63-I80-411	Valve Screw	1	77	63-I40S-604B	Air Inlet 1/4"PT-19	1
33D	63-IS70-412-B	Valve	1		63-I40S-604C	Air Inlet 1/4"NPT-18	
34	63-00-41130	O-Ring	1	78	63-00-3509	Snap Ring	1
35	63-00-3435	Pin	2	79C	63-00-41173	O-Ring	1
36	63-I70-408	Front Plate	1	80C	63-IS40S-421	Pressure Valve	1
37	63-I70R-405	Anvil	1	81C	63-I70S-453	Spring	1
38B	63-I70-452	Roller	2	82C	63-I40S-454	Block Cap	1
39B	63-I70-406-B	Drive Blade	2	83D	63-00-41127	O-Ring	1
40	63-I70-407	Spring	2	84EB	63-I80-422	Back Up Ring	1
41C	63-I70-404-B	Pulse Cylinder	1	•	63-I70RDSK-MZ	Service kit :Index No-7; 14; 36; 38B(2); 39B(2); 44; 52(9); 72; 73; 74	
42	63-00-3436	Pin	1				
43	63-00-3407	Pin	2				
44	63-I70-415	Rear Plate	1	•	63-I70RDRK-MZ	Repair kit :Index No-25D(2); 26(2); 30; 31; 34; 40(2); 79C	
45	63-I40S-423	Washer	1				
46	63-I70-402	Lock Nut	1	•	63-I40-451	Impulse Oil	
•	63-I70R-400ASM	Pulse unit : Index No-24,25D,26,27,28,29,30,31,32EB,33D,34,35,36,37,38B,39B,40,41C,42,43,44,46,79C,80C,81C,82C,84EB					