



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 is involve on the operation to calculate the accurate pulsing time. Here is an example:

Pulsing Time = 2 seconds

Pulses- seconds recommended = 250,000

$$250,000 \text{ pulses-sec} \div 2 \text{ sec} = 125,000 \text{ cycles}$$

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	51	63-I40S-306	Lock Nut	1
2	63-I50R-706	Lock Nut	1	52	63-00-2348	Ball Bearing	1
3	63-00-41134	O-Ring	1	53	63-00-3324	Spring Pin	1
4	63-00-2358	Ball Bearing	1	54	63-I60S-302	Cylinder	1
5	63-I50R-711	Washer	1	55	63-00-3326	Spring Pin	1
6	63-00-3813	Steel Ball	3	56	63-I60S-303	Rotor	1
7	63-I50RD-705	Shaft Gear	1	57	63-I60S-304	Rotor Blade	9
8	63-I50R-707	Shaft	1	58C	63-I60R-305	Rear Plate	1
9	63-00-2357	Ball Bearing	1	59	63-00-2356	Ball Bearing	1
10	63-I90-410	Greasing Screw	1	60	63-I40S-310	Air inlet Plate	1
11	63-00-4153	O-Ring	1	61	63-305F-034	Spring	1
12	63-I50R-701	Angle Housing	1	62	63-IS40S-502	F/R Valve	1
13	63-00-0605	Set Screw	1	63	63-00-41146	O-Ring	1
14	63-I50R-704	Main Shaft Gear	1	64	63-00-4121	O-Ring	1
15	63-I50R-712	Washer	1	65	63-IS40S-312	Valve Washer	1
16	63-00-2352	Ball Bearing	2	66	63-00-3824	Steel Ball	1
17	63-I50R-709	Lock Nut	1	67	63-IS40S-313	Spring	1
18	63-I50R-702	Lock Nut	1	68	63-IS40S-311	Valve	1
19	63-I50R-708	Anvil Collar	1	69	63-00-41125	O-Ring	1
20	63-00-3430	Pin	1	70	63-I40S-309	Seat	1
21	63-I60R-201	Pulse Unit Housing	1	71	63-I60S-101	Motor Housing	1
22	63-I40S-202	Bushing	1	72	63-00-0507	Screw	1
23	63-I40S-424	Washer	1	73	63-I40S-503	Regulator Knob	1
24	63-I60S-401	Pulse Cylinder Seat	1	74	63-I40S-102	Hanger	1
25	63-00-41127	O-Ring	3	75	63-I40S-509	Bushing	1
26	63-I70-410	Greasing Screw	1	76	63-IS40S-510	Pin	1
27	63-00-41113	O-Ring	3	77	63-I40S-504	Trigger	1
28	63-00-3318	Spring Pin	2	78	63-I40S-108	Bushing	2
29EA	63-I40S-403-B	Front Cover	1	79	63-00-3306	Spring Pin	1
30	63-I40S-408	Front Plate	1	80	63-I40S-103	Housing Rubber	1
31	63-00-2602	X-Ring	1	81	63-I40S-508	Bushing	1
32	63-I60R-405	Anvil	1	82	63-305C-021	Valve Stem	1
33B	63-I60S-452	Roller	2	83	63-I40S-507	Spring	1
34B	63-I60S-406-B	Drive Blade	2	84	63-I40S-601	Muffler	1
35	63-I40S-407	Spring	2	85	63-I40S-603	Exhaust Deflector	1
36B	63-IS40-450	Block Valve	1		63-I40S-604A	Air Inlet 1/4"PF-19	
37EB	63-I80-411	Screw	1	86	63-I40S-604B	Air Inlet 1/4"PT-19	1
38EA	63-IS60S-412-C	Valve	1		63-I40S-604C	Air Inlet 1/4"NPT-18	
39	63-00-41130	O-Ring	1	87	63-00-3509	Snap Ring	1
40EA	63-IS60RD-425-C	Spring	1	88C	63-00-41173	O-Ring	2
41	63-00-3435	Pin	2	89C	63-I60S-453	Spring	1
42	63-00-3436	Pin	1	90C	63-I40S-454	Block Cap	1
43C	63-I60S-404-B	Pulse Cylinder	1	91EA	63-I40-409	Back Up Ring	1
44	63-00-3407	Pin	2	92EB	63-I80-422	Back Up Ring	1
45EA	63-IS40S-415-C	Rear Plate	1	×	63-IS60RDSK-MZ	Service kit :Index No-7; 14; 30; 33B(2); 34B(2);	
46	63-I40S-423	Washer	1			45EA; 57(9); 67; 81; 82; 83	
47C	63-IS40S-421	Pressure Valve	2			Repair kit :Index No-25(2);27(2);31;35(2);39;88C(2);91EA	
48	63-IS60S-314	Shut Off Stem	1	×	63-IS60RDRK-MZ		
49	63-IS40S-317	Spring	1			Impulse Oil	
50	63-I40S-402	Lock Nut	1	×	63-I40-451		
×	63-IS60R-400ASM	Pulse unit : Index No-24,25,26,27,28,29EA,30,31,32,33B,34B,35,36B,37EB,38EA,39,40EA,41,42,43C,44,45EA,47C,50,88C,89C,90C,91EA,92EB					