



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	63-00-0610	Set Screw	1	48	63-00-41144	O-Ring	2
2	63-I30S-201	Pulse Unit Housing	1	49	63-00-41135	O-Ring	1
3	63-I40S-202	Bushing	1	50	63-IS40-307	Rear Cover	1
4	63-I40S-424	Washer	1	51	63-IS40-524	Valve Seat	1
5	63-I30S-401	Pulse Cylinder Seat	1	52	63-00-41145	O-Ring	2
6	63-I30S-410	Greasing Screw	1	53	63-IS40S-312	Washer	1
7	63-00-41173	O-Ring	3	54	63-00-3824	Steel Ball	1
8	63-00-3318	Spring Pin	2	55	63-IS40S-313	Spring	1
9	63-00-41110	O-Ring	2	56	63-IS40S-311	Valve	1
10	63-I30S-403	Front Cover	1	57	63-IS40-518	Seat	1
11	63-00-2604	X-Ring	1	58	63-IS40-101	Motor Housing	1
12	63-00-41113	O-Ring	3	59	63-I40S-108	Bushing	4
13	63-I40S-411	Valve Screw	1	60	63-IS100-609	Screw	1
14	63-00-3435	Pin	2	61	63-I40S-102	Hanger	1
15	63-I30S-408	Front Plate	1	62	63-00-41146	O-Ring	1
16EB	63-I30-405-B	Anvil	1	63	63-00-4169	O-Ring	1
20	63-I30S-406-B	Drive Blade	2	64	63-I40-104	Nut	1
21	63-I40S-452	Roller	2	65	63-I40-504	Trigger	1
22	63-I30S-407	Spring	2	66	63-00-3354	Spring Pin	1
23	63-IS40-450	Block Valve	1	67	63-00-0505	Screw	2
24	63-IS40S-412-C	Valve	1	68	63-I100-503	Regulator Knob	1
25	63-00-41130	O-Ring	1	69	63-00-4101	O-Ring	1
26	63-00-3813	Steel Ball	2	70EA	63-IS40-505B	Valve Stem	1
27	63-IS30S-425	Spring	1	71EA	63-I100-508B	Bushing	1
28	63-I30S-404-B	Pulse Cylinder	1	72EA	63-00-41199	O-Ring	1
29	63-00-3436	Pin	1	73EA	63-I40-507B	Spring	1
30	63-IS40S-421	Pressure Valve	2	74	63-I100-506	Spring	1
31	63-I40S-453	Spring	1	75	63-IS40-502	F/R Valve	1
32	63-I40S-454	Block Cap	1	76	63-I40-501	Valve Sleeve	1
33	63-00-3407	Pin	2	77	63-00-41111	O-Ring	2
34	63-IS30S-415-C	Rear Plate	1	78	63-I40-601	Muffler	1
35	63-IS40-314	Shut Off Stem	1	79	63-I40-603	Exhaust Deflector	1
36	63-IS40S-317	Spring	1		63-I40-604A	Air Inlet 1/4"-19PF	
37	63-I40S-423	Washer	1	80	63-I40-604B	Air Inlet 1/4"-19PT	1
38	63-I30S-402	Lock Nut	1		63-I40-604C	Air Inlet 1/4"-18NPT	
39	63-I40S-306	Lock Nut	1	81	63-I100-511	Pin	1
40	63-00-2348	Ball Bearing	1	82EB	63-I40-103	Housing Rubber	1
41	63-00-3324	Spring Pin	1		360182	Tool Cover	1
42	63-I40-302	Cylinder	1		63-IS30SK-MZ	Service kit :Index No-	
43	63-00-3356	Spring Pin	1			15;20(2);21(2); 34; 45(9);	
44	63-I40S-303	Rotor	1			55; 71EA; 72EA; 73EA	
45	63-I40S-304	Rotor Blade	9		63-IS30RK-MZ	Repair kit :Index No-	
46	63-I40-305	Rear Plate	1			7(3); 9(2); 11; 12; 22(2); 25	
47	63-00-2356	Ball Bearing	1		63-Pulse Tool Fluid, 125ml	Pulse Tool Fluid, 125ml	