



Sturtevant Richmond

Global Reach. Local Support.

Sturtevant Richmond Div. of Ryeson Corp.

3203 N. Wolf Road

Franklin Park, IL 60131

Phones: 847/455-8677 800/877-1347

Fax: 847/455-0347

E-mail: CustomerService@sr torque.com

Web: www.srtorque.com

Instruction Sheet

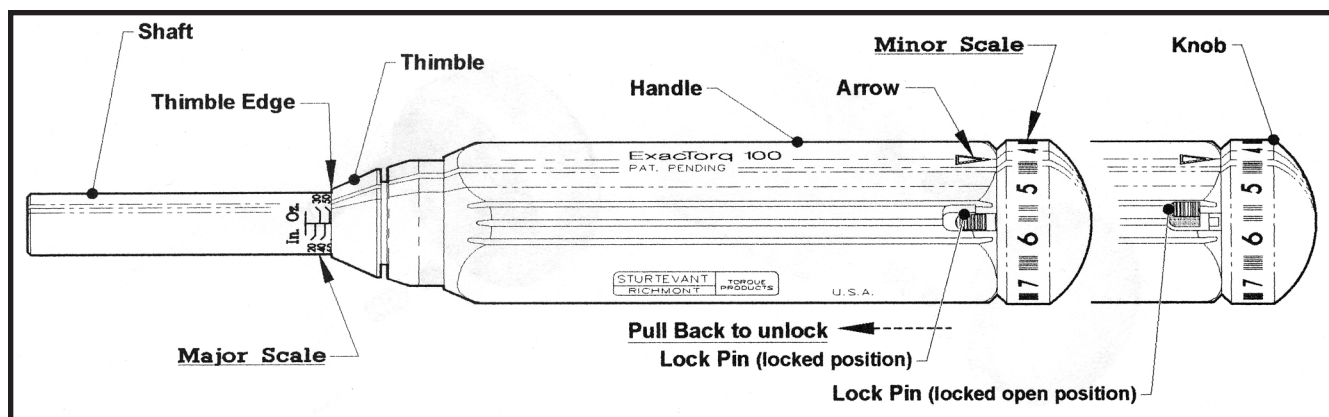
ExacTorq Torque Limiting Screwdrivers - All Models

Cautions

- Always wear appropriate personal safety equipment when working with hand tools.
- Use this tool only for the purpose for which it was designed.
- Do not use this or any other torque tool in excess of its rated capacity.
- Insure the bit is fully seated in the screwdriver and properly engages the fastener before applying force.

ExacTorq Screwdrivers

These tools are designed and manufactured to meet or exceed the requirements of ASME B107.14M and ISO 6789. ExacTorq limits torque in both the clockwise and counter-clockwise directions. See figure below for component nomenclature and use as reference for torque setting instructions.



Torque Setting Procedure

1. Grasp the Handle and retract the Lock Pin. The Lock Pin may be held back or moved to the Locked Open Position. Do not attempt to rotate the Knob without first disengaging the Lock Pin by retracting it to the Open or Locked Open Position.
2. With the other hand, rotate the Knob until the desired torque (largest graduation on Major Scale past Thimble Edge + digit aligned with Arrow on Minor Scale) is attained. Rotate Knob clockwise to increase torque, counter-clockwise to decrease torque.
3. To lock torque setting, allow Lock Pin to return to Locked Position.
4. The torque setting may only be locked in for whole digit increments. It cannot be locked between digits.

Bits, Extensions and Adapters

Use only 1/4" hex shank, in-line bits, extensions or adapters with your ExacTorq. The bits, extensions and adapters should not exceed six inches in length.

ExacTorq Operation

Grasp ExacTorq handle and insert bit into/onto fastener, making sure the fastener drive is fully engaged. Align the axis of the ExacTorq with the axis of the fastener. Rotate the ExacTorq steadily in the direction of tightening until the tool clicks. Further rotation will not increase the applied torque.

Care & Cleaning

When the screwdriver will not be used for a period of time, it should be stored at the lowest torque setting. The screwdriver should be cleaned only with a clean damp cloth.

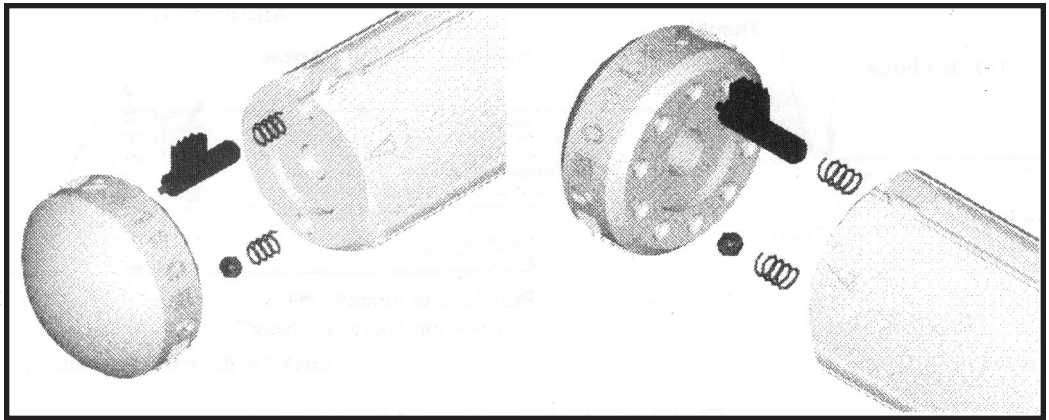
Calibration Instructions

Required Equipment

- Hex key (0.50") for Thimble set screw
- Hex Key (5/64" for Knob set screws
- Torque analyzer of +/- 1% or better I.V. accuracy from 20% to 100% of tool capacity.

Procedure

1. Screwdriver test points should be at 20%, 60% and 100% of tool capacity. The accuracy at each test point should be +/- 6% of the set point. Testing sequence is from lowest to highest test point.
2. Adjust screwdriver to test point. Align screwdriver with torque transducer on analyzer.
3. Test torque. If all checks at all test points are within tolerance, no adjustment is needed and the tool may be returned to service. If not, go to next step.
4. Adjust tool to 20% of capacity. Test. If readings are out of tolerance, disregard markings on shaft of screwdriver and turn Knob until readings are in tolerance at 20% of capacity. If finer adjustment than 1 increment is needed, remove Knob (next step) and adjust.
5. Loosen the Thimble set screw with the hex key. Loosen the Knob set screws with the hex key and remove Knob, making sure not to lose the detent ball, lock pin or springs. Set parts aside. Make any fine adjustments required by rotating Knob stem CW or CCW to obtain required readings at 20% of capacity. Rotate the Thimble until the edge of the Thimble is even with the lowest setting line on the Shaft. Retighten Thimble set screw. Place detent ball, lock pin and springs back in their original installed positions. Reinstall Knob with the "0" mark on the Knob aligned with the Arrow on the Handle so parts next in a detent recess. Hold Knob on handle with sufficient force to keep parts in position and tighten the Knob set screws. Repeat steps 2 & 3.



Factory Repair, Parts & Calibration

Parts are available through your local S/R distributor. Factory repair (warranty & non-warranty) and NIST-traceable calibration and certification are available by sending product to Sturtevant Richmond.