

SureTorque Models ST-120S Manual Gold Bottle Verification Guide

Manufacturer Name and Address

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Gold Bottle Verification - Manual

Equipment Required:

- Calibrated Gold Bottle



Procedure

1. Power Up: Connect the power cord to the AC power adaptor and attaching it to the mini power jack at the rear panel. Power the unit up using the Mini rocker switch also at the rear panel. The PLC screen powers up, and the manufacturer and software version information (as shown) is shown on the first “splash” screen during the boot-up procedure. You will see an error message stating insufficient or low air supply, connect the unit to house air supply and adjust the regulator to 80psi.
2. Select the Calibration Icon in the Main Menu.
 - a. If asked for a password, standard password on a new machine is 1113.
3. Remove clamps to allow for sufficient space to grasp and turn Gold Bottle
4. Lock the shaft by pressing Lock or Unlock shaft
 - a. Insure Shaft Status displays “Locked”
5. Insert the cap of the Gold Bottle into the chuck
 - a. A min of 60% of the closure should be inserted
6. Press the Chuck On/Off to close the chuck around the cap
7. While the Gold Bottle is stationary, press the Reset Peak and Zero Offset buttons
 - a. Peak Torque reading should display 0.000
8. Slowly turn the Gold Bottle clockwise until the peak reading is displayed
 - a. Record peak reading
9. While the Gold Bottle is stationary, press the Reset Peak and Zero Offset buttons
 - a. Peak Torque reading should display 0.000
10. Slowly turn the Gold Bottle counter-clockwise until the peak reading is displayed
 - a. Record peak reading

11. Check verification rating on the Gold Bottle
 - a. Verify peak readings are within specified tolerance
 - i. See specifications table
 - b. If peak readings are not in specified tolerance, Repeat Test
 - i. If verification fails a second test, a calibration should be done
12. While holding the Gold Bottle, release the chuck by pressing Chuck On/Off
13. Unlock the shaft by pressing Lock or Unlock shaft
 - a. Insure Shaft Status displays “Unlocked”
14. Return to main screen by pressing the Back button
15. Re-attach clamps

Video Tutorial:

A video of this verification can be found at the following link:

- [ST-120S Manual Gold Bottle Verification Video](#)

Specifications

Small	
Torque Range:	.5 – 4 in-lbs
Gold Bottle Tolerance:	+/- 0.2 in-lbs
ST-120S Machine Tolerance:	+/- 0.5 in-lbs
Standard	
Torque Range:	3 – 16 in-lbs
Gold Bottle Tolerance:	+/- 0.2 in-lbs
ST-120S Machine Tolerance:	+/- 0.5 in-lbs
Large	
Torque Range:	8 – 43 in-lbs
Gold Bottle Tolerance:	+/- 0.2 in-lbs
ST-120S Machine Tolerance:	+/- 0.5 in-lbs

