

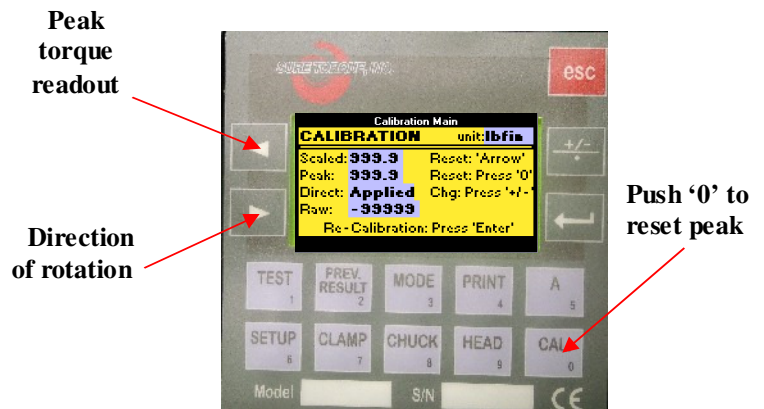
Using SureCheck with ST-120/ST-Lab For Torque Readout Verification

Intent:

The procedure outlined in this document is intended to allow the user to quickly verify the calibration of a SureTorque Model ST-120 or ST-Lab with the SureCheck device. This procedure applies to new or upgraded machines shipped after 7/2011 which include the updated calibration screen.

Procedure:

1. Remove collet from chuck
2. Move clamps or raise head to allow enough clearance to install SureCheck into chuck.
3. Install SureCheck into chuck using quick pin.
4. Navigate to Calibration screen
5. Select the direction by pressing the “+/-” and manually rotate the chuck to the stop in the selected direction (Applied or Release)
6. Press ‘0’ to reset the peak torque to zero.



7. Turn the SureCheck slowly by hand until the breakaway torque occurs*.
8. Note the peak torque reading.
9. If the peak torque reading is not within +/- 0.5 lbfin of the SureCheck’s specified break torque, reset peak and run a new test.
10. If the result is still out of the acceptable range, then check/recalibrate with the dead weight method.
11. Repeat for the opposite direction.

*Note: Turning the SureCheck quickly can provide lower torque readings.

