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GEDORE TOOLS FOR LIFE

# Surubelnita dinamometrica Quickset 0.2 ... 9Nm.

## QUICKSET & QUICKSET MINOR TORQUE SCREWDRIVERS

**DATA SHEET: 004** **Issue No: 4**
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## RECALIBRATION PROCEDURE

It is presumed that the screwdriver has been assembled in accordance with the general assembly drawing for that model and that no thread locking or sealing has been carried out.

## G A REFERENCE LIST

| | |
|---|---|
| QS Minor | C57320 |
| QS 6 | C86710 |
| QS 6 F/Hex | C86710 |
| QS 9 | C86710 |
| QS 9 F/Hex | C86710 |
| QS 5-50 | C86710 |
| QS 5-50 F/Hex | C86710 |
| QS 30-80 | C86710 |
| QS 30-80 F/Hex | C86710 |

## QUICKSET:

1. Commence with the fine adjustment screw (item 17) backed off. Advance this adjustment screw until pressure of the main spring is felt. Then advance the screw a further 1½ turns.

   1.1 First remove wax from Sq Drive situated at rear of handle & from the screws in the scale sleeve.

2. With set screws (items 18) slack, use adjusting grip, (item 9) to adjust the torque screwdriver such that it achieves the lowest major torque value when tested on a calibration device (*).

3. Position the scale sleeve (item 28) such that the torque screwdriver is set at the reading achieved in (2) above. Care must be taken to ensure that the hairspring (item 13) is located in one of the 10 splines of the handle thread (item 26).

4. Nip up the set screws (item 18) until the scale sleeve (item 28) is held firmly.

5. Adjust the torque screwdriver to each of the major readings and check for accuracy against the calibration device (*). Check torque values in ascending order.

6. The screwdriver should be operated a minimum of **Five** times at each setting to ascertain the repeatability of reading.

7. Fine adjustment of the setting can be made using the setscrew (item 17) located in the handle end of the screwdriver.

8. Following checking at the highest value the tool should be reset to the lowest value and rechecked. ISO 6789 states calibration points should be at 20,60 & 100% of calibrated range.

9. Repeat above operations until satisfactory readings are obtained at all settings.

10. Finally tighten and seal set screws (item 18).

11. Seal set screw (item 17).

<u>QUICKSET MINOR:</u>

1. With set screws (item 22) slack use adjusting grip (item 4) to adjust the main scale such that the lowest torque graduation lines up with the bezel (item 2). Ensure that the hair spring (item 14) is located in one of the 10 splines in the handle thread at this position.

2. Rotate the bezel (item 2) until the zero position lines up with the scale line of the adjusting screw (item 29).

3. Nip up the set screws (item 22) until the bezel (item 2) is held firmly.

4. Remove self adhesive label

4.1 Use adjusting screw (item 26) located in the handle end to calibrate the screwdriver to the torque setting as in (1) above. Calibrate the screwdriver using a calibration device (*).

5. Adjust the torque screwdriver to each of the major readings and check for accuracy against the calibration device (*). Check torque values in ascending order.

6. The screwdriver should be operated a minimum of **Five** times at each setting to ascertain the repeatability of reading.

7. Fine adjustment of the setting can be made using the setscrew (item 26) located in the handle end of the screwdriver.

8. Following checking at the highest value the tool should be reset to the lowest value and rechecked.

9. Repeat above operations until satisfactory readings are obtained at all settings.

10. Finally tighten setscrews (item 22) and cover with tool label (item 12).

11. Seal screw (item 26) and cover with self-adhesive label (item 13).

## *CALIBRATION

Torque screwdrivers should be calibrated using either, a Torqueleader MTS analyser and an ISO A test rig of appropriate capacity or electronic analyser with appropriately ranged transducer.

## *Special Tool

Tool ATO 4748 is required to remove the bezel from Quickset Screwdrivers

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