



**Sturtevant
Richmont®**

Torque Measurement Systems

Sturtevant Richmont

The Tools You Trust

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Operating Instructions

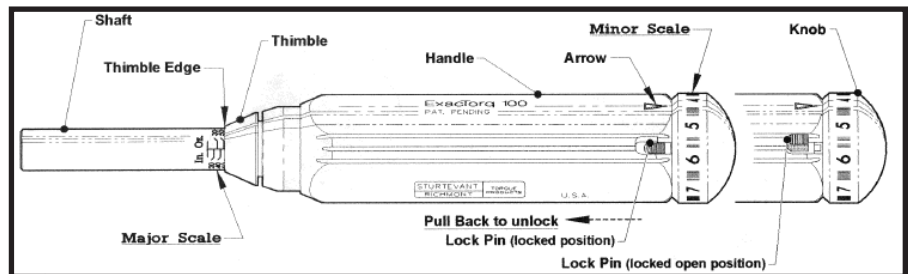
ExacTorq 100 (810045) and ExacTorq 74 (810046) Adjustable Torque Screwdrivers

Sturtevant Richmont adjustable torque screwdrivers are designed and manufactured to provide consistent user-settable torque in high-cycle assembly or maintenance applications. These tools meet or exceed ASME B107.300-2010 and ISO 6789 specifications of $\pm 6\%$ preset value accuracy from 20% to 100% of capacity, and $\pm 1.2\%$ of capacity below 20% of capacity. These tools meet or exceed this requirement in both the clockwise and counter-clockwise directions.

S/R adjustable torque screwdrivers signal the operator that the torque setting has been attained by emitting a distinct audible and tactile impulse (click"). Preset torque screwdrivers do not have graduations and the torque must be set via use of a torque tester of $\pm 1\%$ Indicated Value accuracy or better.

Cautions

- Always wear appropriate safety equipment when using any hand tool.
- Only use hand tools for their intended purpose.
- Never exceed the rated capacity of the tool.



Capacity and Range

810045.....20-100 inch-ounces

81004615-74 cNm

Setting the Torque

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.

Use of Extensions and Adapters

Only in-line extensions and adapters should be used with the screwdriver. The recommended maximum overall extension length is six inches (6").

Operation

1. Insert appropriate fastener engagement device (bit/adaptor/socket) into 1/4" female hex bit holder.
2. Engage fastener and rotate screwdriver until audible/tactile impulse (click) is generated.
3. Stop rotating screwdriver. The set torque has been reached and further rotation will not increase applied torque.

Care & Cleaning

When the tool is not to be used for an extended period, we recommend that it be set to its lowest setting (20% of capacity) prior to storage. Always store screwdriver in a clean, dry environment. Do not immerse screwdriver in cleaning fluids. Clean exterior of screwdriver with damp cloth.

Calibration Instructions

Required Equipment

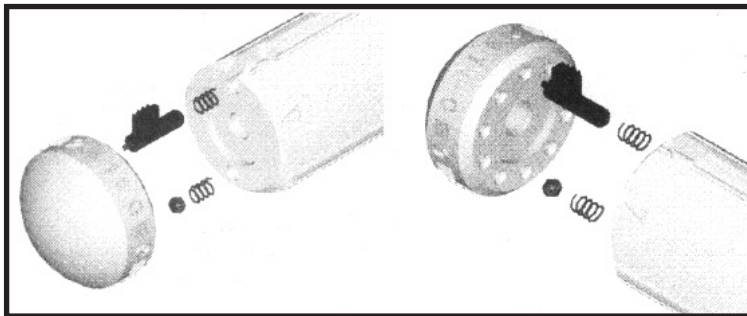
- Hex key (0.50") for Thimble set screw
- Hex Key (5/64" for Knob set screws
- Torque tester of +/- 1% or better I.V. accuracy from 20% to 100% of tool capacity.

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 tester.
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.



Service and Calibration

Repair Parts can be ordered through your local S/R distributor. For the name of a local S/R distributor, please contact us using the information on the front of this document. Factory repair and calibration in our ISO/IEC 17025 Accredited Calibration Laboratory can be obtained by sending the screwdriver and your instructions to us at the factory.

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