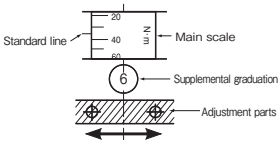
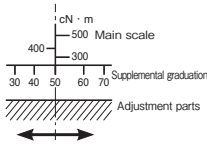
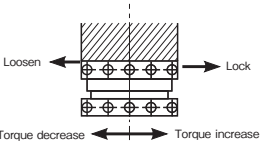


■ Torque setting of power torque tools

Turn the adjustment parts, set the required torque with the main graduation, and finally set the torque accurately with the supplemental graduation.

Setting method	Main scale slide type	Supplemental graduation slide type	Preset type (without graduation)
Adjusting scale			
Set torque	Main scale + Supplemental graduation $30 + 6 = 36$ [N·m]	Main scale + Supplemental graduation $200 + 50 = 250$ [cN·m]	(Operation torque measurement) using a tester
Model	AUR, HAT, AP, DAP, MG, MF, ME, AME, DCME, MC	U, UR, AS12N	AS (Except AS12N)

■ Tightening work

1. Reaction force

When tightening an object with a power torque tool, a reaction force equivalent to the tightening torque generally works on your hand (This is not the case with the semi-automatic A or AC Airtorks, because you manually perform the final tightening, or with the MF, ME, or MC multi-units or the AP or DAP Airtorks, in which the reaction force is absorbed by the machine). Though in most cases, you may not feel reaction force because of inertia when tightening at high speed, you may feel it when low air pressure in the air motor causes insufficient output or when the screw is a soft joint. Therefore, be sure to hold the powered air tool tightly at all times.

2. Automatic stop

TOHNICHI's power torque tools stop automatically when the torque reaches the set value. Confirm that the automatic stop has occurred before releasing the starting lever. If you release the starting lever before the tool has automatically stopped, the set torque will not be reached. In addition, if the tool stalls due to insufficient air pressure or air amount before the automatic stop has been activated, the set torque will not be obtained, so be certain to confirm that the automatic stop device has activated. Press the starting lever fully, then after the automatic stop device has activated, remove the power tool from the screw head before releasing the starting lever (If you do not press the starting lever far enough, a shortage of air will cause the output of the air motor to be insufficient, and the system will be half-clutched). The semi-automatic Airtorks do not have an automatic stop mechanism. When using one of these tools, keep the starting button pressed until the tool stalls. Once it does, tighten manually with the torque wrench, and then release the starting button.

Correct tightening

1. Hold the tool firmly.
2. Press in the starting lever fully.
3. Release the starting lever only after the tool has stopped.

