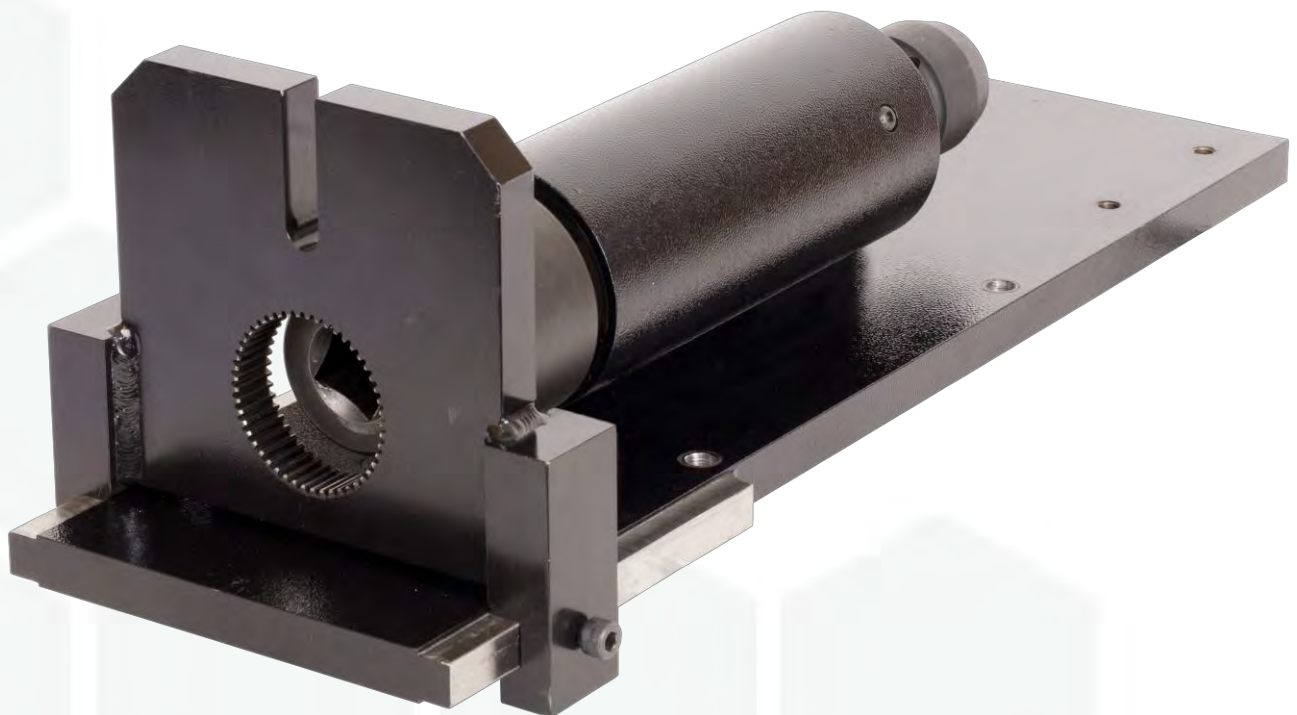


**POWER TOOL TEST FIXTURE FOR
TRUCHECK™ PLUS 2000**



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INTRODUCTION

The power tool test fixture acts as a repeatable bolted joint to enable the consistency of non-impact power torque tools to be measured. This manual covers a Norbar Power Tool Test Fixture 50774 and Joint Simulator Rundown Assembly 50775 that has been designed to be used in conjunction with a Norbar TruCheck™ Plus 2000 (43245) and the following range of Pneutorque® wrenches:

- PT 72 series
- PTM-72 series

The joint simulator uses disc-springs to control the joint rate. The springs are designed to cope with repetitive testing at rated capacity, so the performance remains consistent over the product life.

Parts Included

Description	Picture	Description	Picture
Joint Simulator (50775)		27 A/F - 1" Drive Socket (29403)	
Base Plate (62249)		Circlip Retaining Ring (265114)	
Reaction Plate (62235)		60 A/F - 1" Drive Socket (29324)	

FEATURES AND FUNCTIONS

- A consistent joint for power tool testing.
- Directly compatible with Norbar PTs (specified above) and Norbar TruCheck™ Plus 2000.
- For clockwise testing of power tools.

SET UP INSTRUCTIONS

NOTE: If the equipment is used in a manner not specified by the manufacturer, the protection provided by the equipment may be impaired.

1. Base

Secure base plate (62249) to a suitable surface using 4 x M10 socket head cap screws (minimum grade 8.8).

NOTE: Screws are not supplied.

Ensure there is sufficient overhang to slide reaction plate onto base plate.

Torque tighten screws to a value of 45-50 N·m (33-37 lbf·ft).



2. TruCheck™

Mount the TruCheck™ Plus onto the base plate.

Set-up the instrument as specified in the TruCheck™ manual.

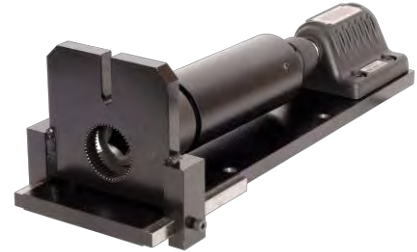
Ensure TruCheck™ Plus is in “dIAL” mode.



3. Power Tool Test Fixture

Position the joint simulator (50775) onto the TruCheck™ Plus instrument using the 27 A/F – 1” drive socket supplied (29403).

Slide reaction plate (62235) onto bed.



4. Tool

Connect up power tool as detailed in power tool manual.



WARNING: DO NOT USE IMPACT/IMPULSE TOOLS.

Ensure torque setting on power tool is not above maximum rating for transducer.
Ensure torque setting on power tool is not above maximum rating for joint simulator.

Engage tool with reaction plate, either via splined location or blade reaction location. Secure in place using retaining ring. (265114)

Fit required drive socket(s) (29324/29403) to fix power tool to joint simulator and reaction.

OPERATING INSTRUCTIONS

NOTE: Exceeding maximum torque will result in permanent damage to disc-springs.

Tightening

Run tool in to joint simulator in CLOCKWISE direction.


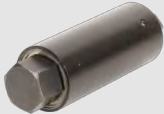
Read torque value from measurement instrument.

Releasing

To release joint simulator rotate the hexagonal bolt in an ANTI-CLOCKWISE direction.

Reset measurement instrument as required.

SPECIFICATIONS

Part Number	Picture	Capacity	Overall Dimensions (Approx.)	Weight	Hexagonal Bolt A/F	Interface to Transducer
50774		2000 N·m (1480 lbf·ft)	210 x 190 x 550	33.4 Kg	60mm	27mm A/F to 1" Sq.
50775		2000 N·m (1480 lbf·ft)	240mm x Ø90mm	11 Kg	60mm	27mm A/F to 1" Sq.

Operating Temperature Range: 0°C to +50°C.

Storage Temperature Range: -20°C to +70°C.

Maximum Operating Humidity: 85% Relative Humidity @30°C.

Environment: Indoor use within a light industrial environment.

NOTE: Due to continuous improvement all specifications are subject to change without prior notice.

MAINTENANCE

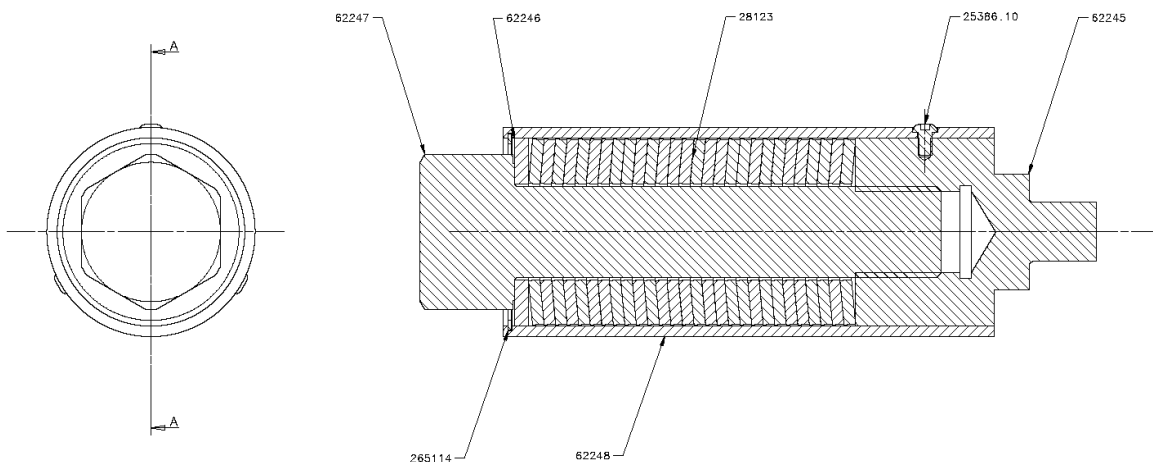
NOTE: Always complete maintenance tasks on a clean work area.
Always wear suitable gloves for your protection.

Service / Repair

To service or repair the joint simulator, complete the following steps:

1. Remove joint simulator from TruCheck™ Plus.
2. Unscrew M39 hexagonal bolt (62247) in an anti-clockwise direction.

The M39 hexagonal bolt is the item most prone to wear. It is recommended to grease this item regularly with Rocol M204 G Graphite grease or Rocol Tufgear 85. Replace hexagonal bolt when worn.



3. To access the spring(s):
 - Remove the 3 x M6 button head screws that retain the drive shaft (62245).
 - Slide out the drive shaft to reveal the disc-spring stack.

TIP: It is important to note the orientation of the spring(s) ready for reassembly.

4. Clean spring(s) or replace with new spring(s).
Grease springs with Rocol M204 G Graphite grease or Rocol Tufgear 85.
5. Replace disc-spring stack paying careful attention to arrangement.
6. Replace drive shaft and retain with 3 x M6 button head screws.
7. Grease and replace M39 hexagonal bolt.

Cleaning

Do not use abrasives or solvent based cleaners.

Disposal (Recycling Considerations)

Component	Material
Joint Simulator Housing	Steel
M39 Hexagonal Bolt	Steel
Base Plate/Side Runners	Aluminium/Steel
Reaction Plate	Steel
Reaction Adaptor	Steel
Hardened Washer	Steel

For up to date disposal information, see our web site www.norbar.com.

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