



# KELTEK

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### Calibration Instructions for Keltek Breakover Preset Torque Wrenches (6 and 8-inch long, 5/8-inch diameter handles with plastic grip)

Wrenches can be recalibrated at the factory or by following these instructions.

- 1) Mark metal tubing at the point where the plastic grip ends.
- 2) Remove plastic grip by twisting and pulling. If grip is glued in place, slide a knife between the open end of the grip and the handle and release it.
- 3) Align plastic grip with its previous position on the handle and mark the metal tubing at the point that lines up with the middle of the raised portion of the plastic grip.
- 4) Remove the back screw in the end of the handle with a 1/8" hex key wrench if there is one. If there is only one screw, it is the set-screw and the wrench head will get loose immediately.
- 5) Work wrench through torque breakover several times on a test fitting and then place wrench on a suitable torque tester (tester must be accurate to within 1% in the range being tested).
- 6) Apply force directly on the mark that was made in step 3.
- 7) Increase force smoothly, not exceeding 1 inch pound per second when approaching torque breakover. When breakover begins, torque reading should not increase further as handle pivots through its 17 degree range of motion.
- 8) Adjust torque breakover by turning set-screw in end of handle with a 1/8" hex key wrench.
- 9) Recheck after 24 hours by repeating steps 5 through 7.
- 10) If there were two screws in step 4, install the second locking screw.
- 11) Put plastic grip back in place such that raised portion of grip is located where the force will be applied.
- 12) Recheck torque breakover by applying force directly in the center of the raised portion of the grip.
- 13) Glue grip in place.

Note: Accuracy of torque reading should be within plus or minus 5 percent of desired setting.

