



KELTEK

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Calibration Instructions for Keltek Heavy Duty Breakover Preset Torque Wrenches (8 and 12-inch long, 1-inch diameter handles with knurled grip)

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

- 1) Remove low melting point sealer (if any) in end of wrench with heat gun.
- 2) 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).
- 3) Apply force directly to the middle of the knurled section of the handle.
- 4) 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.
- 5) Adjust torque breakover by turning set screw in end of handle with a large screwdriver.
- 6) Recheck after 24 hours by repeating steps 3 through 5.
- 7) Reseal with low melting point metal.

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

