

QUICK GUIDE FOR TORQUE VERIFICATION

- 1) Select the correct air hose and air fittings. Make sure there is no reduction that can strangle the airflow between the air pipeline, the compressor and the air outlet of the pulse tool.

MODELS	AIR HOSE SIZE (I.D.)	AIR FITTING (NPT)
FLEX (S) 30, 40, 50 (P)(PX)(S) (SX)(R) (RX)	¼" (6.5mm)	¼" (6.5mm)
FLEX (S) 60, 70, 90, 100 (P)(PX)(S) (SX)(R) (RX)	3/8" (8mm)	3/8" (8mm)
FLEX (S) 130, 150 (P)	½" (11mm)	½" (11mm)

- 2) Connect the air fitting to the air inlet of the tool and ensure there is not an air leak. Recommend to use Teflon tape or other sealing tape.
- 3) Adjust the air pressure to the proper setting as required for the application (please reference the torque range settings as listed in the product data sheet. The air pressure to be used with the tools are 70PSI or 85PSI.)
Note: if it is a new tool it is highly recommended to pour 2 or 3 drops of lubricant oil into the air inlet of the tool and run the tool for 10 to 30 seconds. Do this 2 or 3 times to lubricate the blades of the air motor.
- 4) For torque verification, must use a static transducer (Recommend either the FLEX-Tester, [PTT Torque Meter](#) with a [BMX Torque Sensor](#) or [LTT Torque Tester](#)). Rundown the tool onto the static transducer (with no rundown adapter or joint simulator).



STATIC Torque Sensor



PTT with BMX

Note: It is highly recommended to use a filter of 1500Hz.

- 5) Make 2 or 3 rundowns before comparing the readings to warm up the oil and allow the oil into the air motor.
- 6) Back the cap screw off on the pulse unit housing to access to the valve screw.
- 7) Rotate the anvil manually; make the valve screw inside the pulse unit align at the hole (where the screw is taken off). Then, use the hex key tool to adjust the torque. Increase torque by turning clockwise and counterclockwise to decrease the torque.
- 8) Adjust the tool to the maximum torque and make 3 to 5 rundowns. Check the readings are repeating and compare with the maximum torque specified in the data sheet. Repeat the same procedure at minimum torque.
- 9) Tighten the cap screw back to the pulse unit housing.

