

# ATB (Break-Over Wrench) Operating Instructions

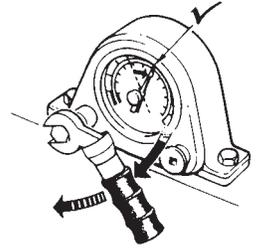
Rev 2.6 (4/10/17)

## ATB “Break-Over” Wrenches

These production wrenches break-over once reaching preset torque and reset automatically. The ATB models break-over at 20°. When the torque wrench achieves torque, the head breaks-over signaling to the operator to stop applying torque to the fastener or bolt. The versatile wrench is available with different head configuration options, like open, box, flare, hex key or ratchet head.

## Calibrating Torque Wrenches

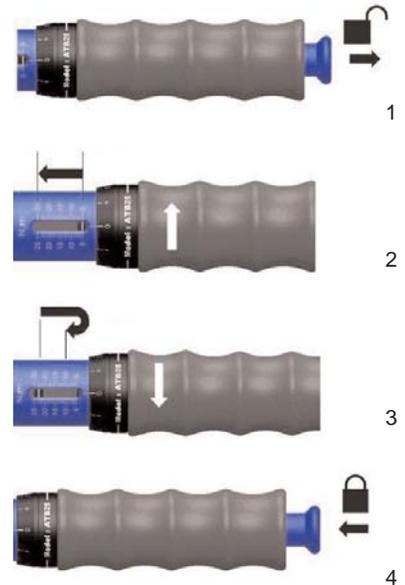
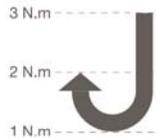
To calibrate torque wrenches either use a torque tester or torque sensor within the range of the torque wrench. For break-over torque wrenches calibrate torque in “Peak” mode with a digital torque tester or torque sensor. Make sure you apply the torque slowly and smoothly at the center of the hand grip.



1. Select a torque tester or torque sensor that covers the torque range of the ATB wrench. Connect wrench to the torque tester or torque sensor using the appropriate adapters as needed (not supplied).
2. Test tool through full range. Make scale adjustments, if required, as described in steps 2 - 5. If wrench is nonlinear, contact Mountz for technical repair service.
3. Adjust tool to 20% of full scale setting. Remove set screw and locking knob at end of handle.
4. Turn exposed torque adjustment screw CW to increase torque and CCW to decrease torque to proper setting. Test tool on torque analyzer to ensure correct adjustment to 20% of setting was made. Repeat as necessary.
5. Replace adjusting sleeve onto tool ensuring to align zero on the micrometer scale. Lock set screws, replace locking knob and tighten set screw. Replace rubber grip.
6. Recalibrate torque wrench at prescribed intervals. Every 12 Months or 5000 cycles (minimum)

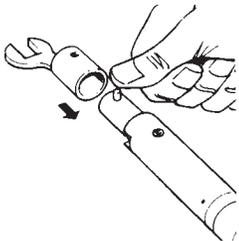
## Adjusting Torque Setting

1. Unlock the adjustment mechanism by pulling the Locking Knob outward at the end of the handle.
2. **Increase Torque Setting:** Rotate the hand grip clockwise until the required torque is selected on the calibrated scale.
3. **Reduce Torque Setting:** When adjusting, always approach the required torque from a lower setting. Rotate the hand grip anti-clockwise past your setting, then increase torque to the required value.
4. **Lock Torque Settings:** Lock the adjustment mechanism by pushing the Locking Knob back in at the end of the handle.



## Placing Heads on Wrench

Slide “head” on to the end of wrench. Align the pin with the head’s pin slot.



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### Applying Torque

1. Tighten nut or bolt by applying a steady even pull. Wrench should be kept at 90 degrees to axis of bolt during tightening. When pre-set torque is reached, the wrench will 'break.'
2. At the set torque, the handle moves through an angle of 20° before resetting.
3. After use, set the wrench at the lowest setting on the scale.



### Mountz Calibration & Repair Services

Mountz Inc. features an experienced calibration and repair staff. Our trained technicians can calibrate and repair most any tool. Mountz provides rapid service with quality that you can trust as we offer three state-of-the-art calibration lab and repair facilities that can calibrate up to 20,000 lbf.ft.

Since 1965, Mountz Inc. has proven its in-depth knowledge of torque and torque solutions by consistently developing, producing, marketing and servicing highly sophisticated, cutting-edge tools. We perform calibrations in accordance with ANSI/NCSL-Z540. Mountz is dedicated solely to the manufacturing, marketing and servicing of high quality torque tools.

### Tool Service & Repair Capability

- Torque Wrench Calibration: Click Wrench, Dial Torque Wrench, Beam Wrench, Cam-Over & Break-Over Wrench
- Torque Screwdrivers: Dial, Micrometer, Preset & Adjustable
- Torque Analyzers/Sensors: All brands
- Electric Screwdrivers: All brands
- Air Tools: All brands  
Impact Wrenches, Drills, Pulse Tools, Grinders, Percussive Tools, Air Screwdrivers, Nutrunners, DC Controlled Nutrunners
- Torque Multipliers: All brands

### Mountz Torque Testers and Calibration Equipment

Torque tools go out of calibration with use. Calibrating a torque tool is a fine-tuning process of bringing the tool back within its tolerance. Torque testers can also be used for quick tools tests on the line or in the lab to determine whether torque tools are holding a given setting.

A regular torque tool calibration and re-calibration guarantees the operator repeatable accuracy and adherence to international standards. Torque testing also ensures torque equipment is operating to peak performance and can highlight potential tooling problems before they arise perhaps due to tool wear or broken components.

Controlling torque is essential for companies to ensure their product's quality, safety and reliability isn't compromised. The failure of a three-cent fastener that isn't properly tightened can lead to catastrophic or latent failures. Fasteners that are insufficiently torqued can vibrate loose and excessive torque can strip threaded fasteners. Using a quality torque tool has become increasingly important for many companies to ensure that proper torque is being applied and maintains gauge requirements associated with the ISO 9001 Quality Standard. Look for the Mountz hexagon logo - it's a stamp for quality tools, service and knowledge in the field of torque control.

### Mountz Service Locations

#### Eastern Service Center

19051 Underwood Rd.  
Foley, AL 36535  
Phone: (251) 943-4125  
Fax: (251) 943-4979

#### Western Service Center

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San Jose, CA 95112  
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Fax: (408) 292-2733

[www.mountztorque.com](http://www.mountztorque.com)  
[sales@mountztorque.com](mailto:sales@mountztorque.com)



Twitter: @mountztorque

Download a "Service Form" and include a copy when you send the tools in to be serviced.

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