



IPT PRESET TORQUE WRENCH

Model	Item #	Torque Ranges		Square Drive
		S.I.	American	
IPT 369	280047	100 - 500 N.m	73.8 - 369 lbf.ft	3/4"
IPT 885	280048	240 - 1200 N.m	171.1 - 885.6 lbf.ft	1"

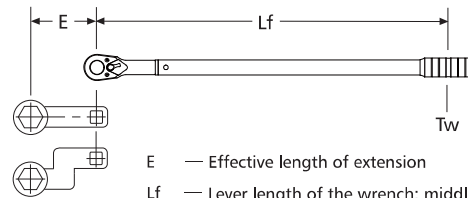
Model	Item #	Length (mm)	Width (mm)	Lf (mm)
IPT 369	280047	865	58	778
IPT 885	280048	1480	72.8	1348

Calibration & Maintenance

Torque wrenches go out of calibration with use. A wrench must be properly calibrated and maintained on a preventative maintenance and calibration schedule. In order to maintain accuracy, it is crucial that a wrench be calibrated regularly using a torque tester.

Calculations For Torque Wrench Extensions

When using extensions, the torque applied to the nut is greater than the setting. To ensure that the correct torque is applied when using extensions, keep the extension "in-line" with the axis of the wrench (as shown in diagram). To calculate the increase, use the formula below:



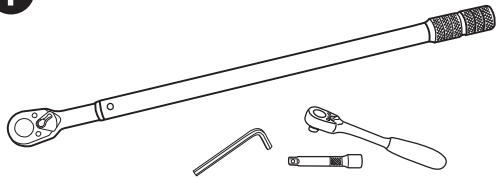
- E — Effective length of extension
 - Lf — Lever length of the wrench: middle of handle to center of square drive
 - Tw — Torque setting on the wrench
 - Ta — Torque applied by the extension to the fastener
- $$Tw \text{ (Torque Setting)} = Ta \times \frac{Lf}{Lf+E}$$

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FOR INDUSTRIAL ASSEMBLY

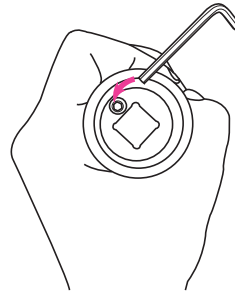
IPT PRESET TORQUE WRENCH

1



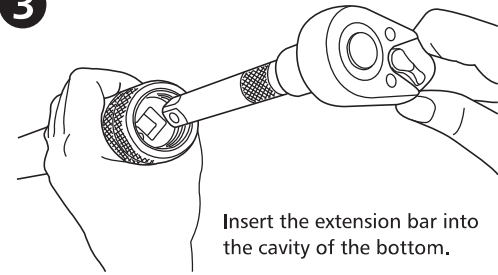
Prepare 1 (ratchet) wrench, 1 extension bar, and 1 allen key.

2



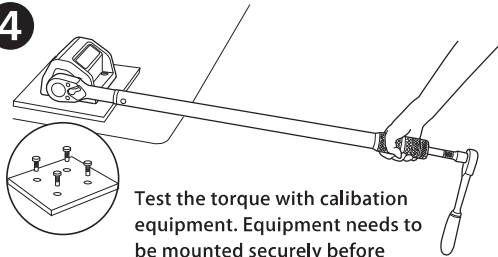
Loosen the screw at the bottom of the IPT preset torque wrench.

3



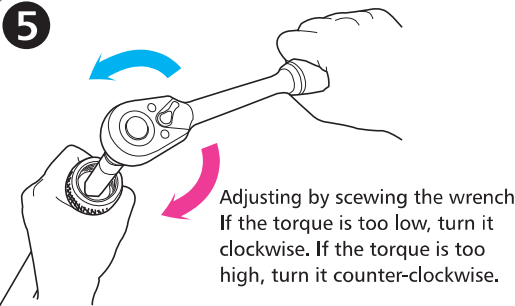
Insert the extension bar into the cavity of the bottom.

4



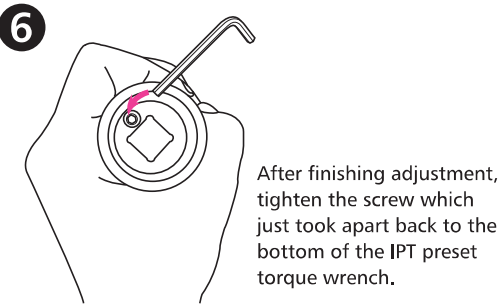
Test the torque with calibration equipment. Equipment needs to be mounted securely before operating.

5



Adjusting by screwing the wrench. If the torque is too low, turn it clockwise. If the torque is too high, turn it counter-clockwise.

6



After finishing adjustment, tighten the screw which just took apart back to the bottom of the IPT preset torque wrench.