

# ATB (Break-Over Wrench) Operating Instructions

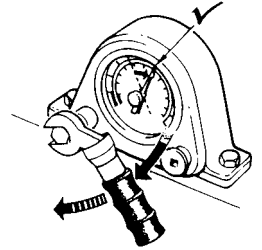
Rev 1.0

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



1. Select a torque analyzer or transducer that covers the torque range of the ATB wrench. Connect wrench to the torque analyzer or transducer 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)



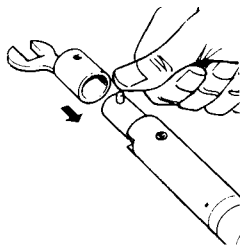
## Adjusting Torque Setting

1. Unlock the adjustment mechanism by pulling the Locking Knob 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 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.



## 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.

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