

MMTB (Miniature Break-Over Wrench) Operating Instructions

Rev 1.0

Ref. Item # 500295

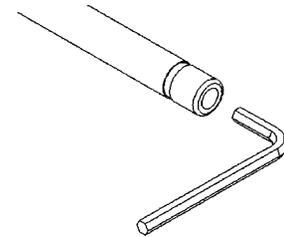
MMTB “Break-Over” Wrenches

These small production wrenches ‘break-over’ once reaching preset torque setting. Compact and well balanced, these wrenches have a fixed head attached to it and are ideally suited for low torque settings or applications with tight space restrictions.

Calibrating Torque Wrenches

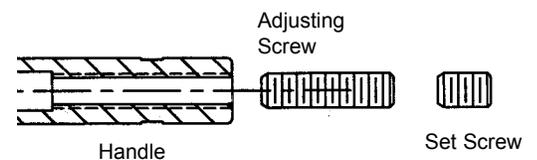
To calibrate torque wrenches either use a torque analyzer or torque transducer within the range of the torque wrench. For break-over torque wrenches calibrate torque in “Peak” mode with a digital analyzer or transducer. Make sure to apply the torque slowly and smoothly at the “Load Point Line” near end of the handle.

1. Select a torque analyzer or transducer that covers the torque range of the MMTB wrench. Connect wrench to the torque analyzer or transducer using the appropriate adapters as needed (not supplied).
2. Apply torque clockwise slowly until wrench ‘breaks-over’ and note reading.
3. Adjust wrench to required torque setting as described below.
4. Test and repeat adjustment as necessary to obtain desired value.
5. Recalibrate torque wrench at prescribed intervals.



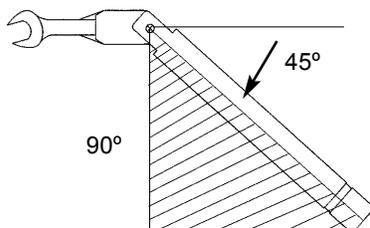
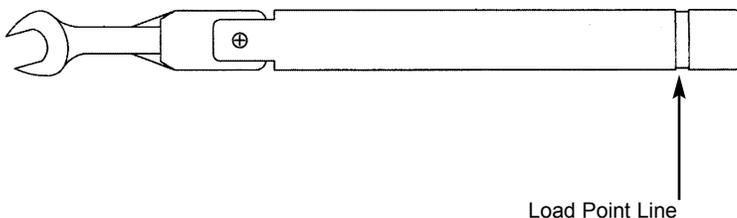
Adjusting Torque Setting

1. Remove set screw from the handle with 10/32 Hex Key.
2. Insert 10/32 hex key into adjusting screw and turn clockwise to increase torque and counter clockwise to decrease torque. Do not adjust torque above or below the recommended torque ranges. Tighten set screw back on.



Applying Torque

1. Toward the end of the wrench is the “Load Point Line.” Grab handle at that “Load Point” end to apply torque. (If you grab handle closer toward head, then you will apply more torque than what the wrench is set for. The wrench is a length dependent tool).
2. 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.’ Stop pulling once 45° break angle is achieved.
2. Reset the wrench for the next application.
3. With its unique design, it’s impossible to over tighten beyond the preset load.





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