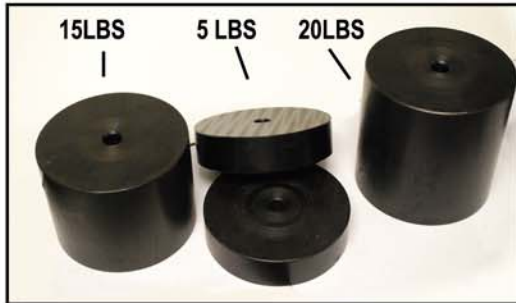




# Recess Torsional Strength Tester

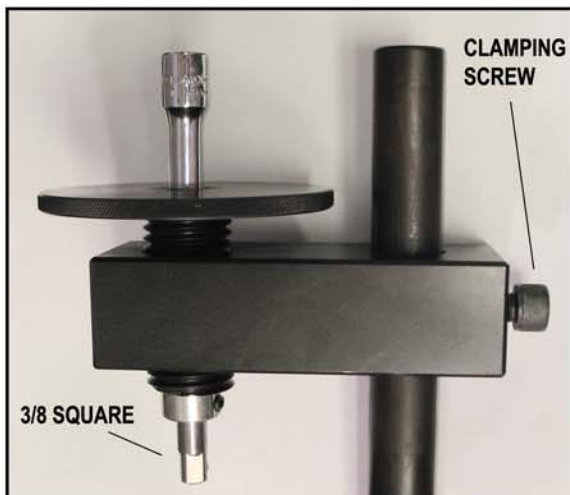
## Model STF-87114

### OPERATING PROCEDURE



1. Select the correct weight for the test to be conducted and place it on the vertical weight holding post on the left end of the lower arm of the test fixture.

2. Place a test screw in the chuck so that the head is in contact with the face of the chuck or as close as possible. Tighten the chuck very tightly using the key, which is provided.

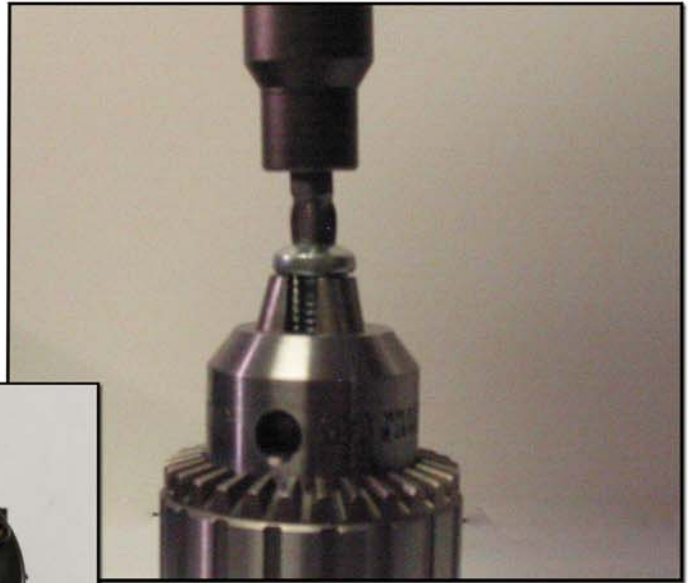


3. Attach the correct driver bit and holder to the 3/8 inch square on the bottom of the center drive shaft of the upper arm assembly.

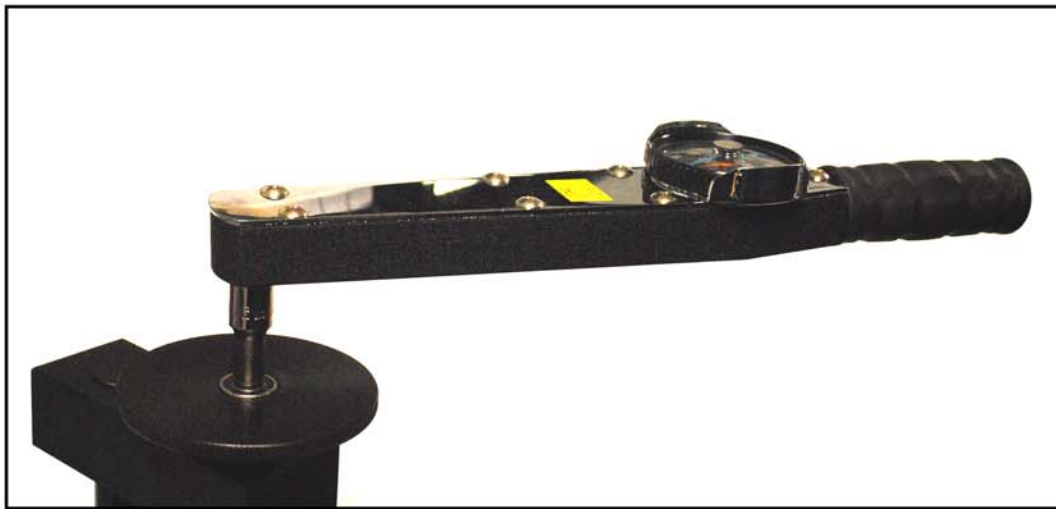
4. Lower the test arm so that the driver bit is close to, but not in contact with, the screw's head. Tighten the upper arm clamping screw so that the arm can not slide

5. Screw the hand wheel in the upper arm down until the driver bit is completely engaged in the screw's recess.

*Critical: Continue to rotate the wheel until the level bubble indicator on the lower arm indicates the level position*



6. Engage a torque wrench in the top of the center drive shaft. Apply the minimum required torque indicated by the specification.



**Acceptance Criteria: If the bit disengages from the recess or the recess is distorted below the minimum required test torque value the recess is UNACCEPTABLE.**

NOTES: (a) The test fixture should be firmly secured to a workbench by fastening it through the 4 holes in the base of the tester. (b) If the screw rotates in the chuck before the recess distorts or disengages grind three flats on the test screws at approximately 120 degrees apart to provide a greater resistance to rotation in the chuck