

# FG-IFR PRESET TORQUE SCREWDRIVER OPERATING INSTRUCTIONS

Rev 1.0 (3/5/2021)

The FG-IFR has no external adjustment scale and must be preset using a torque analyzer or torque sensor. If the tool has not been preset to a set torque value, then follow the directions for adjusting the torque setting before using the screwdriver.

## Adjusting the Torque Setting for a Preset Value

1. Use a 5mm hexagonal key and remove end cap with from screwdriver anti-clockwise direction. Also, remove the T-bar (for FG-40i IFR and FG-125i IFR models only)
2. Use a 2.0mm hexagonal key to loosen the adjuster locking screw by 1/4 - 1/3 turn until slightly disengaged. A full turn is too much and will hinder the available hex depth. Insert the 5mm hexagonal key into the adjuster and turn Clockwise. Turn hex key clockwise to increase torque and counter-clockwise to decrease torque. Tighten the locking screw to 10 lbf.in using the 2.0mm hexagonal key once the required torque value is reached. Caution, overtightening the locking screw may damage it or result in the incidental turning of the adjustment screw.
3. Take 10 consistent readings on the Torque Analyzer to confirm the torque setting. Do not adjust torque above or below the recommended torque ranges for the torque screwdriver or torque analyzer. Tighten end-cap back on using a 5mm hexagonal key.

**Note:** Do not adjust the torque setting while the screwdriver is connected to a torque analyzer or torque sensor as you can over-torque and damage the sensor. The FG-8i IFR model does not have a set screw within the adjustment screw.

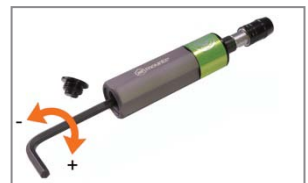
## Applying Torque

1. Tighten fastener or bolt by applying steady twists. The screwdriver should be kept in line with the axis of the bolt during tightening. When pre-set torque is reached, the screwdriver will 'slip.'
2. The screwdriver will automatically reset itself for the next application.
3. With its unique cam-over design, it's impossible to overtighten beyond the preset load.

## Calibrating Torque Screwdrivers

To calibrate torque screwdrivers either use a torque analyzer or torque sensor within the range of the torque screwdriver. For torque screwdrivers calibrate torque in "Peak" mode with a torque tester or torque sensor. Make sure to apply the torque slowly and smoothly.

1. Select a torque tester or torque sensor that covers the torque range of the screwdriver. Connect screwdriver to the torque tester or torque sensor using the appropriate adapters as needed.
2. Apply torque clockwise slowly until screwdriver 'slips' and note reading.
3. Adjust screwdriver to required torque setting as described above.
4. Test and repeat adjustment as necessary to obtain the desired torque value.



5. Recalibrate torque screwdriver at prescribed intervals.

## Maintenance Schedule

Like an automobile, torque screwdrivers contain moving parts that require periodic servicing and lubrication.

## Expected Tool Life

With normal use – 1,000,000 operations

## Period Between Resetting of Torque

20,000 fastening operations. It is acknowledged that some tools may achieve 20,000 operations in a relatively short period of time. Under these circumstances the user may decide, with the benefit of their experience, to increase the period between calibration intervals.

## Routine Maintenance

After 100,000 operations, strip, clean and re-grease the spring, bearings and internal components. Any worn components should be replaced.

**Note:** Any tool that is dismantled during its life must be re-lubricated in accordance with the Mountz recommendations. Do not clean tools by immersing them in a solvent, as this will destroy the internal lubrication and cause the failure of the tool.

## Warranty

We've tested the FG preset torque screwdrivers over two million cycles in our controlled lab environment and we still can't break them!

It's why we have an industry-leading warranty.

- Mountz FG tools are the only cam-over drivers on the market to offer a two-year unlimited warranty. If it breaks in any way, we'll fix it or replace it for free.
- Lifetime guarantee against manufacturing defects. We only make the highest quality products. This driver will not have a defect, we stake our quality reputation on it.
- Warranty includes a free first calibration within the first year (if needed).

## Testing and Servicing

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. Regular torque calibration of a hand screwdriver ensures accuracy, repeatable tool performance, and adherence to international standards.

We recommend a general once a year calibration interval. However, it is the user's organization that must determine suitable intervals based upon equipment performance, application, degree of usage and management objectives.

## Mountz Calibration and 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 two state-of-the-art calibration lab and repair facilities that can calibrate up to 20,000 lbf.ft.

## About Mountz

Mountz, The Torque Tool Specialists<sup>®</sup>, has been a leader in the torque tool industry for more than 50 years. Engineered in the Silicon Valley and serving the globe, Mountz focuses on delivering high-quality torque products, services, and solutions to ensure customers can always proceed with confidence. We are committed to forging a safer world through precision and accuracy and by innovating every day.

### Mountz Service Locations

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