



Brief operating instructions for XLCT cassette tools, version December 2008

Connection

Connect the twin hose to the screwdriver and the power unit.

When connecting, first push the coupling halves completely into each other before you tighten the cap nut with your fingers.

Important: After the HYTORC screwing system has been fully connected, perform a short test run without load but at full pressure (700 bars). You can thus ensure that all connections are correct and secure.

Change from TIGHTENING to LOOSING

Turn the tool over to change from TIGHTENING to LOOSING. Be aware that this tool always works in forward stroke.

Reaction bars

The reaction bars are connected with the cassette. Ensure that the locking bolt is always fully inserted.

The necessary torque

For each screw connection there is a torque specified by the design or the screw manufacturer. Ask those people if you do not know the torque.

For each HYTORC screwdriver you will receive a calibrated and/or a standard pressure/torque table where you can find the pressure that corresponds to your required torque.

Screw connection

Pressing the remote control on the hydraulic power unit (1-arrow key) repeatedly takes you to the torque until the tool no longer performs any pre-stroke.

Pressing the remote control on the hydraulic power unit (2-arrow key) once takes you to the torque until the tool no longer performs any pre-stroke.

Afterwards, always make a control stroke to check whether the tool can apply further torque.

Jammed tool

Press the remote control on the hydraulic power unit and, at the same time, press down the latch attached on the front of the cassette to release the tool.

Additional safety instructions

Always bear in mind that you are working at a pressure of up to 700 bars. This is high pressure which can cause serious injuries if hoses, couplings, etc. are defective.

Keep your hands away from the reaction bars when making up or loosening a screw connection. Considerable risk of injury.

Always ensure that your hands are as far away from the reaction point as possible.

Disassembling the system

Prior to opening the couplings, always press the black button on the hydraulic power pack to relieve the pressure.