

CALIBRATION VERIFICATION SHURE STAKE[®] TOOL CAT. NO. WT145C

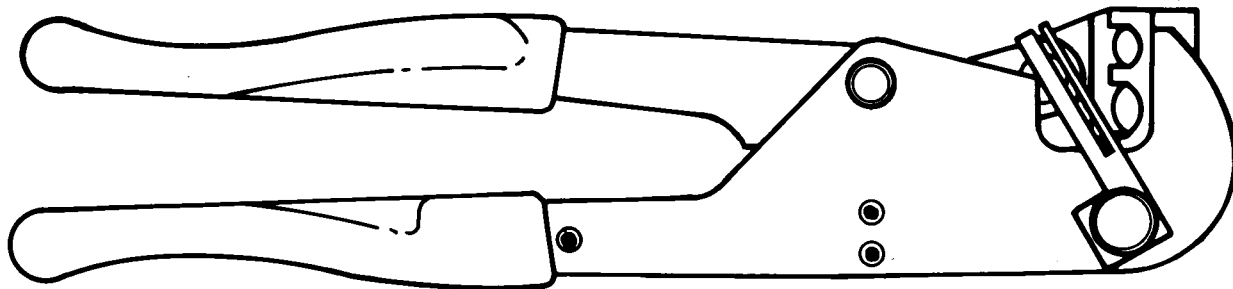


FIGURE 1

NOTE: Calibration verification procedure should be performed at least every 30 days and whenever damage or suspected damage has occurred or as often as operating conditions warrant.

STEP I — VISUAL INSPECTION

1. Tool must be free of cracks, sharp edges and other obvious imperfections that may affect performance of the tool. Nest area must be free of burrs, dents or scratches.

NOTE: Wipe dies before proceeding with Steps II & III.

STEP II — SHURE STAKE[®] MECHANISM CHECK

1. Squeeze handles until jaws are fully closed but before SHURE STAKE[®] mechanism releases.
2. Gradually apply a force 1-1/4" from end of handles until SHURE STAKE[®] mechanism releases (see Figure 2).

Example of force gage John Chatillion & Sons, Kew Gardens, N.Y., N.Y. 11415, Gage Model No. DDPH 100, Stand Model No. HTC.

3. The force required to release the SHURE STAKE[®] mechanism should be 10 lbs. minimum.

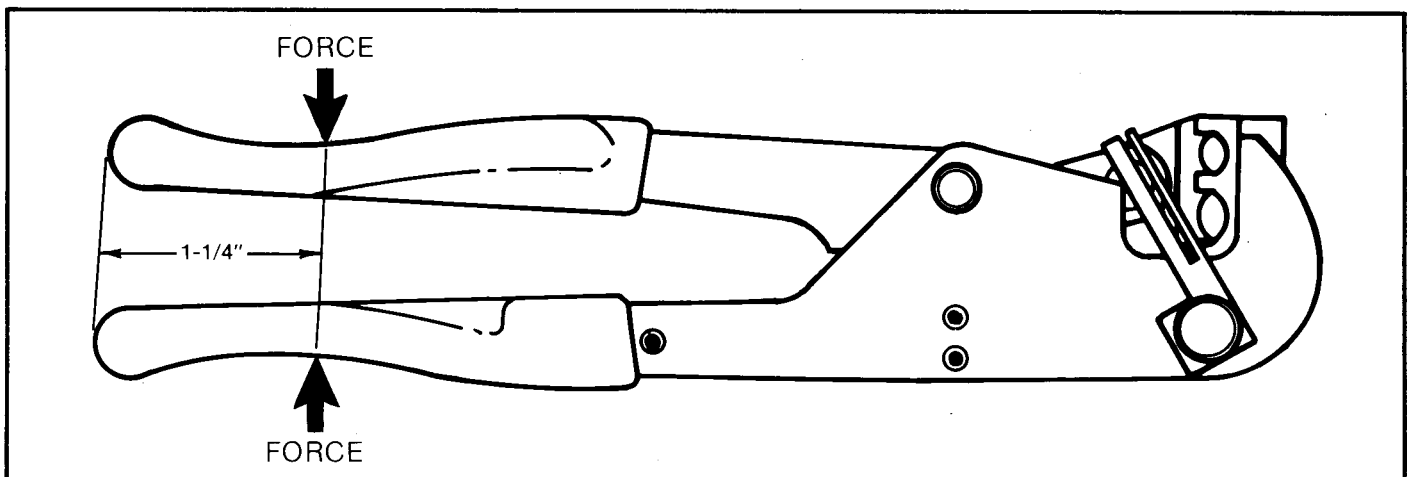


FIGURE 2

STEP III — GAGING PROCEDURE

WARNING: This tool is equipped with the SHURE STAKE® full stroke compelling mechanism. Keep fingers clear of die nests during gaging procedure.

1. Swing locator away from nest. (Gages are to be inserted on this side.)
2. Squeeze the handles until the lower die butts against the upper die (5-10 pound force on handle as shown in Figure 2).
3. The GO gage should enter the nest freely. The NO-GO gage may enter partially, but not pass completely through the length of the nest area.

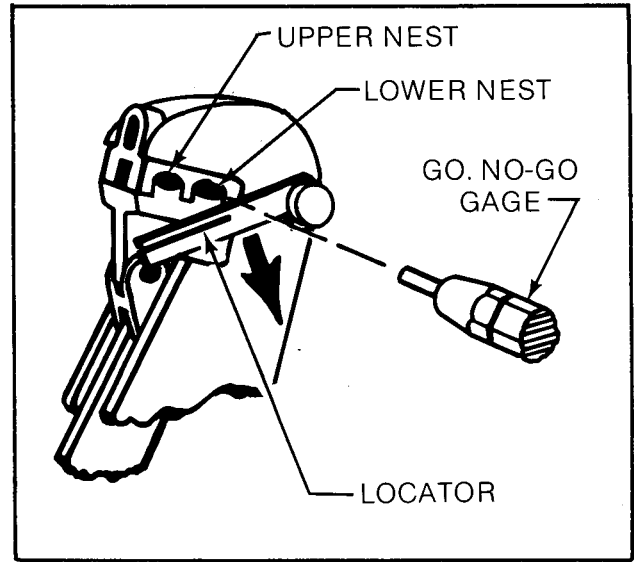


FIGURE 3

GAGING REQUIREMENTS		
Nest	Gaging Min. - Max.	GO, NO-GO Gage Pt No.
UPPER	.118 - .122	683-G-1195
LOWER	.169 - .173	683-G-1196

UPON SUCCESSFUL COMPLETION OF THE ABOVE PROCEDURE, THE PREVIOUS CALIBRATION OF THE TOOL IS VERIFIED.

NOTICE: If tool fails any of the above tests, do not attempt repair or adjustment. Call nearest T&B tool service center to arrange for repair service. Any change, modification or alteration of the tool or use by the customer in a manner other than as specified by T&B shall void all warranties express or implied and the customer shall, therefore, assume all liability for any damage or injury caused by said changed, modified or altered tool or improper usage of such tool.

For parts or service contact the nearest tool service center.

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