



ISO 6789:2017 CALIBRATION PROCESS

A guide to performing a calibration to the ISO 6789:2017 international standard procedure.

1.

Exercise Readings

All Torque Tools

Warm the tool up before starting the calibration readings.

Three Readings
at 100% of the nominal torque

2.

Regular Readings

All Torque Tools

Operate the torque tool, adjusting the torque level if appropriate.

Adjustable Tools:
5 readings at 20% or lowest scale
5 readings at 60%
5 readings at 100%

Non Adjustable Tools:
10 readings at 100%

3.

W_{rep}

Type 1, and Type 2 Class A & D Tools Only

Disconnect and reconnect the torque tool from the torque measuring device after each series.

4 Series of 5 Readings

Adjustable Tools:
at 20% of the nominal torque or lowest scale

Non Adjustable Tools:
at 100% of the nominal torque

4.

W_{od}

Torque Tools Without Fixed Output Drive Only

After each series, remove the tool and rotate the output drive round to the next face. Then, reinsert the tool into the torque measuring device.

5 Exercise Readings, followed by...

If the tool's output is square drive
4 Series of 10 Readings

If the tool's output is hex drive
6 Series of 10 Readings

Adjustable Tools:
at 20% of the nominal torque or lowest scale

Non Adjustable Tools:
at 100% of the nominal torque

5.

W_{int}

When Using an Adapter

After each series, remove the adapter and rotate to the next position relative to the transducer before reinserting, paying close attention to not move the tool's head in relation to the adapter.

5 Exercise Readings, then...

If the adapter is square drive
4 Series of 10 Readings

If the adapter is hex drive
6 Series of 10 Readings

Adjustable Tools:
at 20% of the nominal torque or lowest scale

Non Adjustable Tools:
at 100% of the nominal torque

6.

W_l

Torque Wrenches Only

5 Exercise Readings, then...

Move the force loading point 10mm up the handle.

Perform 1 Series of 10 Readings, then...

Move the force loading point 20mm down the handle.

Perform 1 Series of 10 Readings

Adjustable Tools:
at 20% of the nominal torque or lowest scale

Non Adjustable Tools:
at 100% of the nominal torque

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