



SPC-P-6-2ST 2-SPEED PRECISION CLUTCH PISTOL DRIVER

SETUP INSTRUCTIONS

OVERVIEW

The **SPC-P-6-2ST** offers the user the ability to automatically downshift the tool RPM during rundown at a predetermined snug torque. This shift to a lower, finishing RPM enables the tool to approach finish torque at a precise rate which is especially beneficial on very soft joints. **Hose clamps, rubberized joints, and the fastening of soft materials are applications which will benefit greatly from use of this patented technology.** The precision *Signature Series* Clutch completes the tightening event with great accuracy. Setting up the tool, takes just a few moments using existing buttons on the tool, used in special sequence. Shift points as low as 1 Nm can be set and Final Torque Speed as low as 60-160 RPM are adjustable in an incremental range.

1. Programming Snug Point/Downshift Point

- Remove Battery from Tool
- Press and hold one of the One Touch Reverse buttons (shown at right)
- Attach Tool Battery while pressing either of the One Touch Reverse buttons.
- Solid **Red** LED will illuminate and **Green** LED blinks.
- Press Tool Trigger "on" shortly and release → **Programming Snug Point/Downshift Torque Mode** is now activated.
- The Snug Point/Downshift Torque is set using one of the One Touch Reverse buttons as follows:
 - ⇒ Press and hold one of the One Touch Reverse buttons until a long audible signal is heard. This sets the Snug Point/Downshift Torque at the tool's lowest setting which is 1Nm.
 - ⇒ Pressing and releasing one of the One Touch Reverse buttons will increase the Snug Point/Downshift Torque by .3 Nm. A short audible signal will be heard for each increase of .3 Nm in snug point/downshift torque.
 - Example:** To set the tool to shift down at approximately 2 Nm, one of the One Touch Reverse Buttons on the tool must be pressed and released 4 times (.3 Nm times 4 = 1.2 Nm above 1NM or 2.2NM total). Snug Torque/Downshift Torque target setting must be a multiple of .3 Nm to be set.
 - ⇒ If a mistake is made during this process, pressing and holding one of the One Touch Reverse buttons until a long audible sound is heard will reset the Snug Point/Downshift point back to a close to 0 setting and the process can be repeated.
- Once the Snug Point/Downshift Torque has been set, Remove and Reattach the Battery to complete programming of the Snug Point/Downshift Point.



It is recommended to perform a test run of the tool on a simulated joint prior to running under production conditions.

2. Programming Final Torque Speed

- Remove Battery from Tool
- Press and Hold one of the One Touch Reverse buttons
- Attach Tool Battery while pressing either one of the One Touch Reverse buttons
- Solid **Red** LED will illuminate and Green LED blinks
- Press either One Touch Reverse Push button once
- **Green** LED will blink rapidly
- Hold Tool Trigger "**On**" Constantly → **Programming Final Torque Speed Mode** is now activated and Tool will be Running Slowly (**be sure to keep holding Tool Trigger "ON"**).
- Final Torque Speed is adjusted with either One Touch Reverse button
 - ⇒ Press and hold either One Touch Reverse button to insure that Final Torque Speed is set to its lowest level (Approx 60 RPM).
 - ⇒ Pressing and releasing either One Touch Reverse Button will increase Final Torque Speed by approximately 10-15 RPM.
- Once the Final Torque Speed has been set, Remove and Re-attach the Battery to complete programming of the Final Torque Speed.

It is recommended to perform a test run of the tool on a simulated joint prior to running under production conditions.