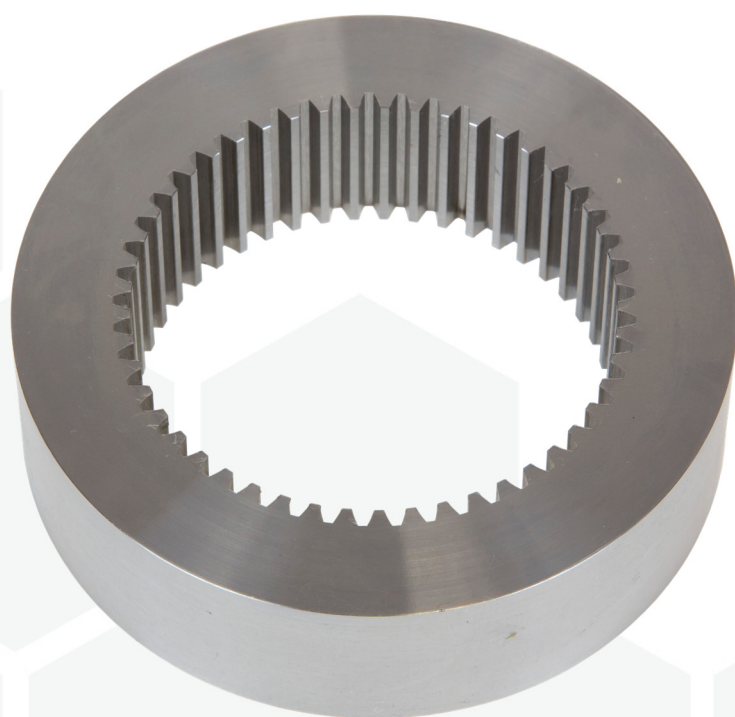


WELDING INSTRUCTIONS



REACTION WELD RING



PART NUMBERS COVERED BY THIS MANUAL

Part Number	For Use With
18694	PTM-52
19784	PTM-68
18695	PTM-72
18696	PTM-92
18697	PTM-119
19871	EBT-C-750
19784	EBT-C-1100

SAFETY

IMPORTANT: DO NOT USE THIS PRODUCT BEFORE READING THESE INSTRUCTIONS. FAILURE TO DO SO MAY RESULT IN PERSONAL INJURY OR DAMAGE.

This product is intended to provide a means of attaching, by welding, a custom steel torque reaction arm to a Norbar Torque tool. Any other use is not recommended.

Welding can be dangerous for those unfamiliar with it.
Only trained and experienced personnel should perform the welding operation.

Torque reaction arms must only be designed and engineered by suitably qualified personnel with an understanding of the forces generated and how these should safely be transmitted to the tool.

Welding must be performed in a suitable environment and using suitable safety / protective equipment.

Do not use the product if there is any doubt about weld integrity.

Welding must be performed prior to fitting the Reaction Weld Ring to the Norbar tool.

Isolate all power supplies to the tool prior to fitting the Reaction Weld Ring / Reaction Arm assembly to the tool.

The Reaction Weld Ring must be fitted to the tool utilising the original equipment external circlip supplied with Norbar tools. Replacement parts can be obtained from Norbar Torque Tools Ltd.

Do not make any modifications to the product other than welding of torque reaction arm as described herein.

Refer to the Norbar tool operator's manual before operating the tool with Reaction weld ring / torque arm assembly fitted.

Keep these instructions available for whenever necessary.

WELDING INSTRUCTIONS

Due to the high carbon content of the material used in this product, extreme care must be taken when welding to Torque reaction arms.

The following points must be observed when welding in order to reduce the risk of hydrogen or 'cold' cracking during cooling:

1. Use low hydrogen welding rods when using Shielded Metal Arc Welding (SMAW) technique.
2. Pre-heat all components prior to welding to 150° to 200° C and allow to cool naturally.
3. Hydrogen cracks can show themselves anything up to 72 hours after welding.
4. Ensure welding is carried out by a competent individual.
5. Inspect welding for any possible flaws.

Welding bead sizes must be calculated with regard to the forces to be applied to the Weld Ring / Torque Arm assembly.

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