

**ITEMS NEEDED FOR CALIBRATION:**

For best results, we recommend the RUSSTECH RTFTS-50 Digital Test Center™. This includes all necessary fixtures and adaptors to verify all of the various RUSSTECH retention test tool platform styles.

As an option, you can use any calibrated force gage with a peak hold feature, capable of measuring forces from 0 to 30 pounds, and a fixture to accept the probe end of the retention tool.

A device to hold the force gage in a way that it can be moved toward the retention tool while maintaining axial alignment of ± 5 degrees throughout the test. (An arbor press, drill press, or similar type device.)

- SAFETY GLASSES!**                      • ALWAYS WEAR PROPER EYE PROTECTION •

**TEST PROCEDURE:**

Adjust the position of the force meter so that the tool slides under the meter and the end of the adaptor is 1/8" - 1/4" above the tool probe.

Place the tool to be checked in the test stage, handle down.

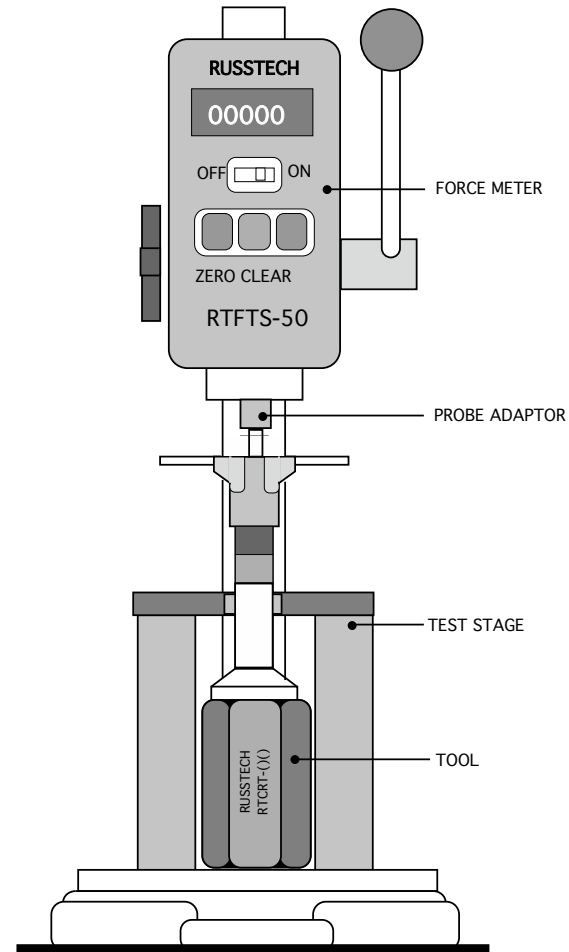
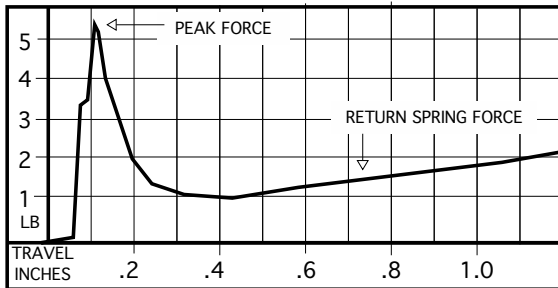
Slide the test stage under the meter carefully aligning the adapter to the tool to be tested.

Slowly bring the meter in contact with the tool probe. Continue moving the force meter towards the tool until the tool cycles, always maintaining ± 5° axial alignment.

Read the peak value. Repeat this test 3 times to get an average value. Please note that the peak test force of the tool occurs with the first 1/4 inch of probe travel as shown in the profile below. Also note that these tools are affected somewhat by cold and work best at room temperature.

We recommend these tools be placed on a 90 day recall cycle.

**TYPICAL RTCRT TEST PROFILE**



The RUSSTECH RTFTS-50 Digital Test Center shown with a typical RTCRT tool set up for calibration.

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| SCALE:   | NONE                    | CALIBRATION INSTRUCTIONS<br>CONTACT RETENTION TOOLS<br>AND DERIVATIVES |          |
| BY   | Don Fieberg<br>11/17/05 | DRAWING NO.  | REV.     |
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