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IMPORTANT SAFETY NOTICE

RAD TOOLS ARE SAFE AND RELIABLE. NOT FOLLOWING PRECAUTIONS AND INSTRUCTIONS OUTLINED HERE CAN RESULT IN INJURY TO THE TOOL, OPERATOR AND FELLOW WORKERS.

NEW WORLD TECHNOLOGIES INCORPRATED IS NOT RESPONSIBLE FOR ANY SUCH INJURY.

The intended use of the RAD® Pneumatic Tool System is for commercial and industrial bolting applications.

Do not operate the RAD® Pneumatic Tool System before reading and understanding this user manual and noting the Safety Notices displayed on the RAD® Pneumatic Tool System and throughout this manual.

Only qualified personnel with training in the safe operation of torque tooling and the RAD® Pneumatic Tool System should attempt the installation, operation and diagnosis of the RAD® Pneumatic Tool System.

The RAD® Pneumatic Tool System is connected to high voltage power and consists of external rotating parts. Improper training and use can cause serious or fatal injury.

Do not disassemble or attempt to repair the RAD® Pneumatic Tool System; doing so will void warranty. If breakdown, malfunction or damage occurs and the RAD® Pneumatic Tool System fails to operate correctly, contact New World Technologies Inc. Technical Support (refer to Section 6.0 – Contact Us).

The RAD® Pneumatic Tool System should only be used if environmental storage and operation specifications have been met. Refer to Section 1.2.3 – Environmental Specifications.

Electrical Shock can cause serious or fatal injury. Do not apply power to the RAD® Pneumatic Tool System without verifying the Earth Ground.

Ensure all AC Mains Power wiring to the RAD® Pneumatic Tool System comply with all National and Local Electrical Codes. Improper wiring may result in unsafe conditions for equipment and personnel.

Do not operate the RAD® Pneumatic Tool System in explosive atmospheres, including, but not limited to, the presence of flammable liquids, gases or dust. The RAD® Pneumatic Tool System creates sparks which could ignite these substances.

Do not expose the RAD® Pneumatic Tool System to wet conditions. Water in the RAD® Pneumatic Tool System will cause damage to the tool and increase the risk of electric shock.

While operating the RAD® Pneumatic Tool System, always wear safety goggles and keep all body parts clear of moving parts and the reaction arm contact point.

Never exceed the Maximum Torque of the RAD® Pneumatic Tool System. Failure to comply, will result in void warranty.

The RAD® Pneumatic Tool System has been calibrated by a qualified Calibration Technician. Calibration must be done by a qualified Calibration Technician. Improper calibration can cause damage to the tool and joint.



1.0 General Information

1.1 System Components

The RAD® Pneumatic Tool System is shipped from New World Technologies Inc. in a tool regulator cage with the following parts:

- RAD® Pneumatic Tool (Figure 1.1-1)
- Standard Reaction Arm and Snap Ring (Figure 1.1-2)
- Calibration Certificate
- User Manual
- Computer Based Training CD (CBT)



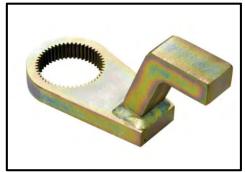


Figure 1.1-1: RAD® Pneumatic Tool

Figure 1.1-2: Standard Reaction Arm

Note: Some distributors may ship additional parts along with the RAD® Pneumatic Tool System.

1.2 Specifications

1.2.1 Metric Specifications

The following table outlines the torque ranges, in Newton-Meters, of each RAD® Pneumatic Tool System:

Tool Model	Torque Range	Noise Level	Vibration
10GX	150 – 950 Nm	80 db	$< 2.5 \text{ m/s}^2$
10GX-R	400 – 950 Nm	80 db	$< 2.5 \text{ m/s}^2$
14GX	275 – 1350 Nm	80 db	$< 2.5 \text{ m/s}^2$
14GX-2	450 – 1350 Nm	80 db	$< 2.5 \text{ m/s}^2$
14GX-NX	275 – 1350 Nm	80 db	$< 2.5 \text{ m/s}^2$
20DX	400 – 2000 Nm	80 db	$< 2.5 \text{ m/s}^2$
20DX-2	700 – 2000 Nm	80 db	$< 2.5 \text{ m/s}^2$
20DX-NX	400 – 2000 Nm	80 db	$< 2.5 \text{ m/s}^2$
34GX	700 – 3400 Nm	85 db	$< 2.5 \text{ m/s}^2$
34GX-2	950 – 3400 Nm	80 db	$< 2.5 \text{ m/s}^2$
46GX	1400 – 4600 Nm	85 db	$< 2.5 \text{ m/s}^2$
80DX	2700 – 8000 Nm	85 db	$< 2.5 \text{ m/s}^2$
115GX	4100 – 11500 Nm	110 db	$< 2.5 \text{ m/s}^2$
475SL	70 – 475 Nm	80 db	$< 2.5 \text{ m/s}^2$
2400NG	700 – 2450 Nm	85 db	<2.5 m/s ²
2400NGX-R	700 – 2450 Nm	85 db	<2.5 m/s ²
6800	2000 – 6800 Nm	85 db	<2.5 m/s ²

Table 1.2.1: Metric Specifications

1.2.2 Environmental Specifications CAUTION!Only operate

Only operate the RAD® Pneumatic Tool System if the following environmental storage and operation specifications have been met.

Temperature Ranges	°C	°F				
Operating Temperature	-20 - 40	-4 - 104				
Storage Temperature	-25 – 70	-13 – 158				
Humidity	10% to 90% non-condensing					
Shock	10G according to DIN IEC 68-2-6/29					
Vibration	1G, 10-150Hz according to DIN IEC 68-2-6/29					
Required Operating Conditions	Non explosive atmosphere					
	Dry location					

Table 1.2.2: Environmental Specifications



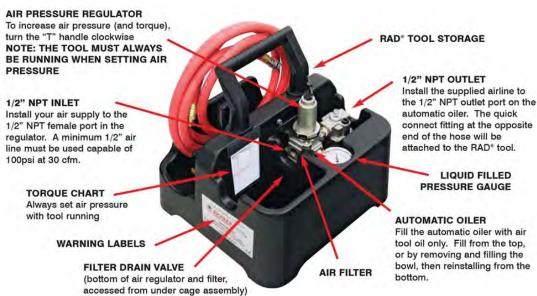
2.0 Tool System

The following sections give a visual and functional description of the Tool Handle and Regulator Cage.

2.1 Tool Handle Description



2.2 Regulator Cage Description





3.0 General Operating Instructions

WARNING!

Only qualified personnel with training in the safe operation of torque tooling and the RAD® Pneumatic Tool System should operate this tool. Refer to the Important Safety Notice for more information.

The RAD® Pneumatic Tool operates in Torque Cycles. The Torque Cycle passes when the Actual Torque reaches the Target Torque and the Cycle fails if it is interrupted and the Actual Torque does not reach the Target Torque.

This section instructs the operator in the assembly of the RAD® Pneumatic Tool, proper use of the Reaction Arm needed for the RAD® Pneumatic Tool operation and how to conduct a Torque Cycle.

3.1 Tool Assembly

- Blow out hoses before connecting.
- Connect the wrench Air Inlet (A) to the outside of the Cage Assembly, observing airflow direction.
- 3. Connect air supply to Inlet side of Cage Assembly using a minimum hose size of ½ inch
- 4. Check oil level in lubricator and fil to correct level.
- 5. Attach Reaction Arm (B) to Spline or Serpentine (C) adjacent to the Output Drive (D) of the wrench and secure with circlip.

3.2 Reaction Arm WARNING!

Always keep body parts clear of the Reaction Arm when the RAD® Pneumatic Tool System is in use. Serious injury could occur.

CAUTION!

Ensure the Reaction Arm has a solid contact point before operating the RAD® Pneumatic Tool System.

3.2.1 Installing the Reaction Arm

Ensure the reaction arm and snap ring are installed securely to hold the reaction arm in place. Make sure the reaction arm is in contact with a solid reaction point before you operate the tool. Keep your body parts clear of the reaction arm when the tool is in operation.

When the tool is in operation the Reaction Arm rotates in the opposite direction to the Output Square Drive and must be allowed to rest squarely against a solid object or surface adjacent to the bolt to be tightened (Figure 3.2.1-1).

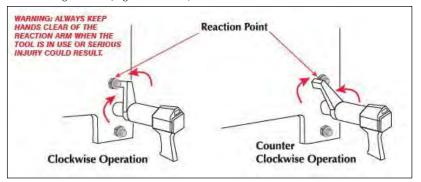


Figure 3.2.1-1: Reaction Point



CAUTION!

Keep your hand and body parts clear of the Reaction Arm and barrel when the tool is in operation.



Figure 3.2.1-2: Incorrect Placement of Hand/Body Parts During Operation

3.2.2 Reaction Arm Height

Ensure the height of the socket is even with the height of the Reaction Arm as seen below in Figure 3.2.2-1. The height of the socket cannot be shorter or higher than the height of the Reaction Arm as seen below in Figure 3.2.2-2.

CORRECT: The Reaction Arm and socket are even height.

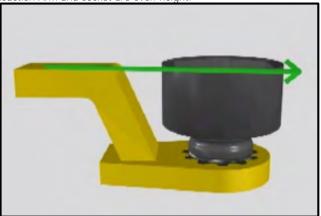


Figure 3.2..2-1: Correct Height

INCORRECT: The leg of the Reaction Arm is too short on the left side, and too long on the right side.

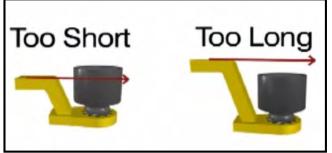


Figure 3.2.2-2: Incorrect Height IMPROPER REACTION WILL VOID WARRANTY AND CAN CAUSE PREMATURE TOOL FAILURE.

3.2.3 Reaction Arm Foot

Ensure the foot of the Reaction Arm aligns with the length of the nut as seen in Figure 3.2.3-1. The length of the foot cannot be shorter or longer than the nut as seen in Figure 3.2.3-2.



CORRECT: The foot of the Reaction Arm aligns with the length of the nut.

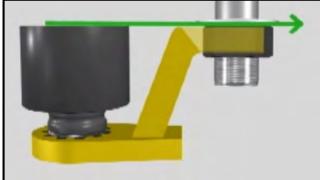


Figure 3.2.3-1: Correct Length

INCORRECT: The foot of the Reaction Arm is too short on the left side, and too long on the right side.

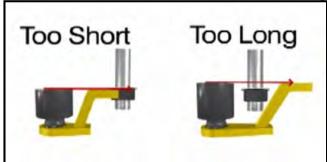


Figure 3.2.3-2: Incorrect Length

Please contact New World Technologies Inc or your local RAD Authorized distributor for custom Reaction Arms.

3.2.4 Reaction Points

Ensure the Reaction Arm reacts off the middle of the foot as seen in Figure 3.2.4-1. Do not react off the heel of the reaction foot as seen in Figure 3.2.4-2.

CORRECT: Reaction Arm is reacting off the middle of the Reaction Arm's foot.



Figure 3.2.4-1: Correct Reaction Point



INCORRECT: Reaction Arm is reacting off the heel of the reaction arm. This can cause premature tool failure.



Figure 3.2.4-2: Incorrect Reaction Point

3.3 Setting Torque for Bolt Tightening

Every RAD® Torque Wrench is supplied with a Torque Chart which relates output to air pressure. Set the torque as follows:

- 1. Ensure the Forward/Reverse switch (E) is set to the Forward position.
- 2. Establish the air pressure required using the Torque Chart.
- 3. Adjust the regulator until the correct pressure is shown on the gauge.

CAUTION!

Do not exceed maximum air pressure setting on the Torque Chart.

IMPORTANT!

The wrench must be free running while adjusting the air pressure to give the correct setting.

3.4 Setting Torque for Bolt Loosening

- 1. Ensure the Forward/Reverse switch (E) is set to the Reverse position.
- 2. Establish maximum air pressure from the Torque Chart and set the air pressure the same as with tightening.

WARNING!

Exceeding the maximum air pressure will overload the wrench and may cause serious damage.

3.5 Operating the Wrench

- 1. Fit the wrench with the correct size impact socket to suit the bolt to be tightened.
- 2. Check the Forward/Reverse switch is in the correct position.
- 3. Rotate the handle to a convenient position relative to the Reaction Arm.
- 4. Fit the tool to the bolt to be tightened with the Reaction Arm adjacent to the Reaction Point (Figure 3.2.1-1)
- 5. Squeeze the Trigger (F) partially to bring the Reaction Arm into contact with the Reaction Point.

WARNING!

Keep hands clear of the Reaction Arm.

WARNING!

In use this tool must be supported at all times in order to prevent unexpected release in the event of a fastener or component failure.

- 6. Fully depress the Trigger and keep fully depressed until wrench stalls. If the Trigger is released before the wrench stalls, full torque will not be applied to the bolt.
- 7. Release the Trigger and remove the tool from the bolt.

4.0 Error IMPORTANT!

Disassembling or attempting repair will void warranty

If breakdown, malfunction or error occurs, contact New World Technologies Inc. Technical Support (refer to Section 5.0 – Contact Us).



5.0 CONTACT US

New World Technologies Inc.

30580 Progressive Way Abbotsford, BC, V2T 6Z2 Canada



Toll Free: 1-800-983-0044

Fax: 604-852-0269

Email: info@radtorque.com

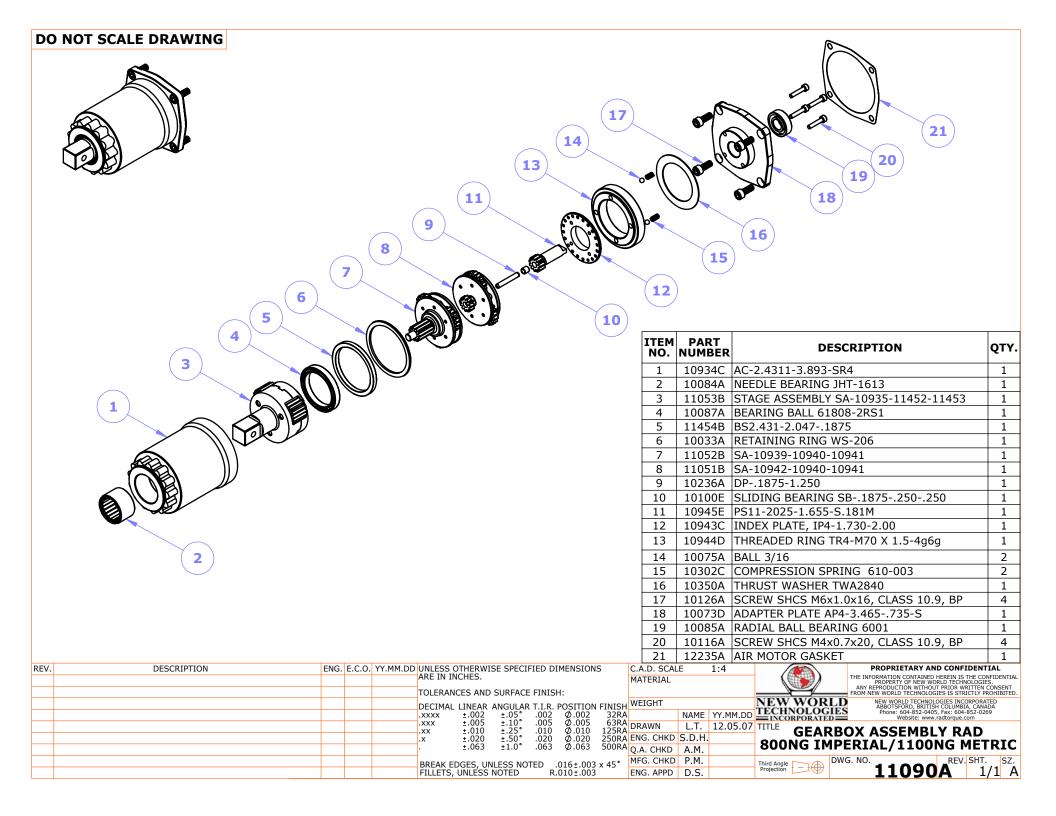
Web: www.radtorque.com

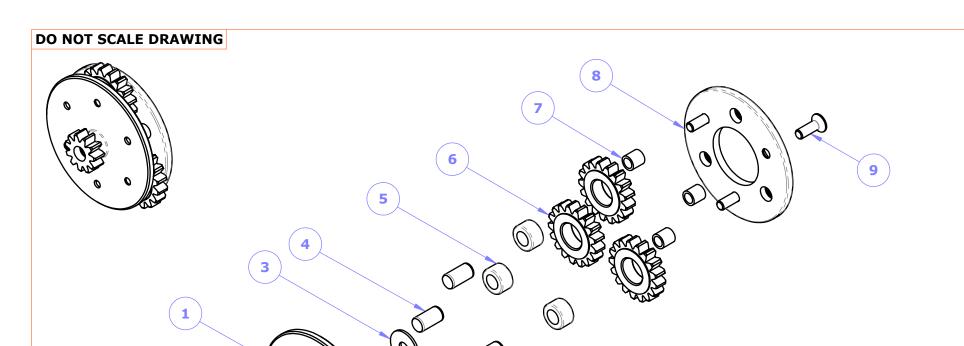
New World Technologies Inc. Technical Support: 1-800-983-0044

(Ext. 227)

Email: eradsupport@radtorque.com



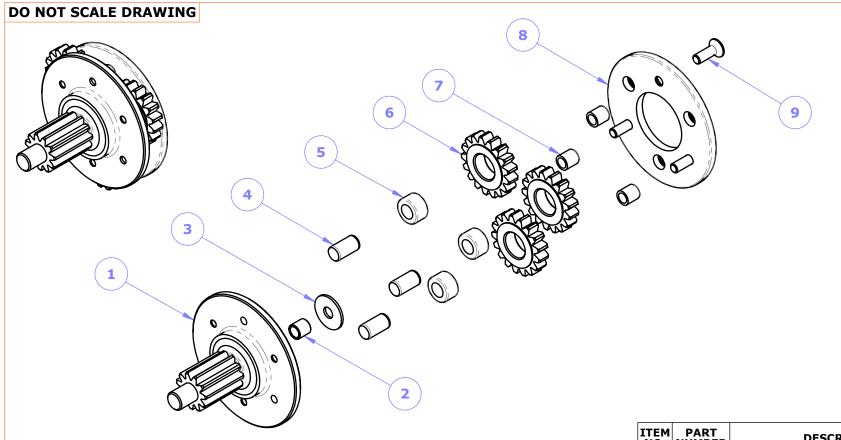




		ASSEMBLY SEQUEN	ICE		
STEPS	OPERATION	CONDITIO	ONS		TOOLS
S1	PRESS 2 INTO 1.	ENSURE BEARING IS FLUSH		1	L TON PRESS
S2	INSERT 3 INTO 1.	USE GREASE NWT#: 10152			
S3	PRESS 4 INTO 8.			1	L TON PRESS
S4	PRESS 5 INTO 6.	PRESS BEARING FROM THE	ONLY 1	L TON PRESS	
S5	SLIDE (5,6) ONTO 4.	USE GREASE NWT#: 10152			
S6	LOCATE 7 ONTO 1.				
S7	PRESS (4,8) INTO 1.			1	L TON PRESS
S9	FASTEN 9.	USE LOCTITE 242. HAND TI	GHT	3.0	mm HEX KEY
REV.	DESCRIPT	TON ENG.	E.C.O. YY.MM.DD UN	LESS OTHERN	WISE SPECIFIED DIM

ITEM PART DESCRIPTION							
1	10942C	OUTPUT CARRIER OC3-1.550520-11	1				
2	10102E	SLIDING BEARING SB1875252375	1				
3	3 10347A THRUST WASHER AS0515						
4 10223E DOWEL PIN DP250460							
5	10079A	NEEDLE BEARING B-44	3				
6	10940C	PLANET GEAR PG19-20252104375	3				
7	14806B	SPACER SC250177260	3				
8	10941C	TP3-1.550-0.130	1				
9	10115A	SCREW FHCS M4x0.7x12, CLASS 10.9, BP	3				

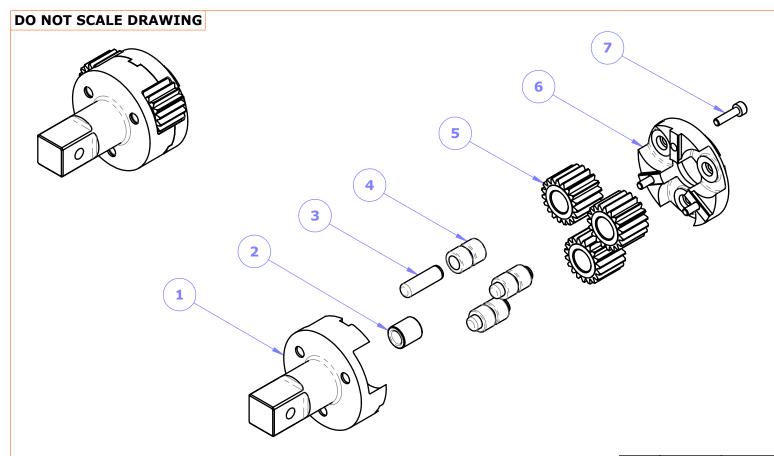
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				xxxx ±	.002 ±.05°	.002	Ø.002	32RA		NAME	YY.MM.DD	TECHNOLOGIES =INCORPORATED=	Phone: 604-852-0405, Fax: 604-852-0269 Website: www.radtorque.com
					:.005 ±.10° :.010 ±.25°	.005 .010	Ø.005 Ø.010	63RA 25RA	DRAWN	L.T.	12.05.07	TITLE	
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	ASSEMBLY SEQUENCE											
STEPS	OPERATION	CONDITIONS	TOOLS									
S1	PRESS 2 INTO 1.	ENSURE BEARING IS FLUSH	1 TON PRESS									
S2	INSERT 3 INTO 1.	USE GREASE NWT#: 10152										
S3	PRESS 4 INTO 8.		1 TON PRESS									
S4	PRESS 5 INTO 6.	PRESS BEARING FROM THE STAMPED END ONLY	1 TON PRESS									
S5	SLIDE (5,6) ONTO 4.	USE GREASE NWT#: 10152										
S6	LOCATE 7 ONTO 1.											
S7	PRESS (4,8) INTO 1.		1 TON PRESS									
S9	FASTEN 9.	USE LOCTITE 242. HAND TIGHT	3.0 mm HEX KEY									
	1											

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	10939C	OC3-1.55-1.675-11	1
2	10100E	SLIDING BEARING SB1875252250	1
3	10347A	THRUST WASHER AS0515	1
4	10223E	DOWEL PIN DP250460	3
5	10079A	NEEDLE BEARING B-44	3
6	10940C	PLANET GEAR PG19-20252104375	3
7	14806B	SPACER SC250177260	3
8	10941C	TP3-1.550-0.130	1
9	10115A	SCREW FHCS M4x0.7x12, CLASS 10.9, BP	3

REV.	DESCRIPTION	ENG. E.C.C	. YY.MM.DE	DD UNLESS OTHERWISE SPECIFIED DIMENSIONS C.A.D. SCALE 2:3 ARF IT IN INCHES.
				MATERIAL PROPERTY OF NEW WORLD TECHNOLOGIES AND REPRODUCTION WITHOUT PRIOR WRITTEN CONSENT
				TOLERANCES AND SURFACE FINISH:
				DECIMAL LINEAR ANGULAR T.I.R. POSITION FINISH WEIGHT NEW WORLD ABBOTSFORD, BRITISH COLUMBIA, CANADA TECHNOLOGIES PRODE 00.3 4.05° 00.3 230.4 0.03 230.4 0
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				.X ±.020 ±.50° .020 Ø.020 250RA ENG. CHKD S.D.H.
				±.063 ±1.0° .063 Ø.063 500RA Q.A. CHKD A.M. 800NG IMPERIAL/1100NG METRIC
				BREAK EDGES, UNLESS NOTED .016±.003 x 45° MFG. CHKD P.M. Third Angle DWG. NO. 11052 REV. SHT. SZ.
				FILLETS, UNLESS NOTED R.010 ± .003 ENG. APPD D.S. Projection 11052B 1/1 A



	ASSEMBLY SEQUENCE											
STEPS	OPERATION	CONDITIONS	TOOLS									
S1	PRESS 2 INTO 1.	ENSURE BEARING IS FLUSH.	1 TON PRESS									
S2	PRESS 3 INTO 6.		1 TON PRESS									
S3	PRESS 4 INTO 5.	PRESS BEARING FROM THE STAMPED END ONLY.	1 TON PRESS									
S4	SLIDE (4,5) ONTO 3.	USE GREASE NWT#: 10152										
S5	PRESS (3,6) INTO 1.		1 TON PRESS									
S6	FASTEN 7.	USE LOCTITE 242. HAND TIGHT.	3.0 mm HEX KEY									

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	10935C	OC3-1.550-2.55075SQ	1
2	10106A	BUSHING IRA-5	1
3	10233B	DOWEL PIN 5/16 DIA x 1.00 LONG	3
4	10080A	NEEDLE BEARING B-55	6
5	11452B	PG19-25780472	3
6	11453B	TP3-1.550760	1
7	10143A	SCREW SHCS M4x0.7x16, CLASS 10.9, BP	3

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				.xxxx ±	.002 ±	±.05° .0	002	$\emptyset.002$	32RA		NAME	YY.MM.DD	TECHNOLOGIES = INCORPORATED=	Phone: 604-852-0405, Fax: 604-852-0 Website: www.radtorque.com	0269
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				FILLETS, UN				10±.003		ENG. APPD	D.S.		Projection	11053B	1/1 A

Certificate No.: 10701_Rev.1





Certificate of Conformity

For

New World Technologies Inc.

30580 Progressive Way Abbotsford, British Columbia V2T 6Z2, Canada

For Compliance of:

Equipment: Pneumatic Torque Wrenches

Imperial Model Nos.: RAD350SL, RAD50, RAD60DX, RAD1800NG-2,

RAD15DX, RAD15DX-2, RAD7GX-R, RAD350SL-2, RAD550SL,

RAD550SL-2, RAD800NG, RAD800NG-2, RAD1400NG, RAD1400NG-2,

RAD1800NG, RAD7GX, RAD10GX, RAD25GX, RAD34GX,

RAD1400NGX-R, RAD1800NGX-R, RAD30, RAD2000, RAD2000-2 and

RAD30-2

Metric Model Nos.: RAD4000; RAD6800; RAD10GX; RAD1100NG; RAD1100NG-2;

RAD14GX; RAD1900NG; RAD1900NG-2; RAD1900NGX-R; RAD2400NG; RAD2400NG-2; RAD2400NGX-R; RAD34GX; RAD4000-2; RAD46GX; RAD475SL; RAD475SL-2; RAD750SL;

RAD750SL-2; RAD20DX; RAD20DX-2; RAD10GX-R;

RAD80DX:

Rated: 100psi max Report No.: 8773-1.0

To the following Directive(s):

➤ 2006/42/EC – Machinery Safety Directive

To the following standard(s):

EN 792-12 (2000) + A1 (2008)

Project No.: 10701 Issued by:

Kavinder Dhillon, Eng.I

Issue Date:

February 21, 2012

Certification Manager