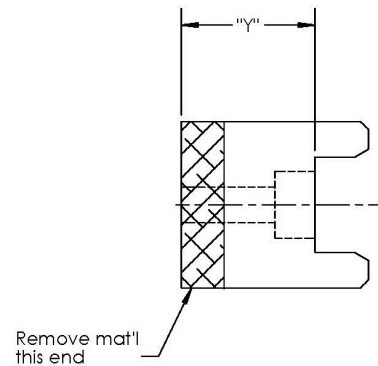


Torque Bar Driver Installation Instructions

1. Mount Stop Block to machine spindle face

- A. Length of Stop Block as well as bolt hole size may need to be altered before installation due to variations in spindle configurations.
- B. Remove the spindle nose bolt where the Stop Block will be installed. **Make sure to choose a bolt location where the Stop Block will not interfere with tool changer arm.**
- C. Remove retention knob from Torque Bar Driver.
- D. Insert Torque Bar Driver into machine spindle.
- E. Measure the distance from the machine spindle face where the Stop Block will be mounted to the face of the Connector Pin on the Torque Bar Driver. This will be distance "X".
- F. Add .175" to distance "X". The result is what you must make distance "Y" shown at right.
- G. Machine Stop Block to proper "Y" length.
- H. Install Stop Block to spindle face using existing screw. Make sure slot in Stop Block is parallel to the radius of the spindle. Bolt hole in Stop Block may need to be opened up. Longer than original screw may need to be used.



2. Install Torque Bar Driver

- A. Verify that the Connector Pin offset distance ("R") shown at right matches the bolt circle radius on the machine spindle face.
- B. Remove retention knob from shank.
- C. Loosen the three set screws that lock the Orientation Ring in place so that the complete housing and Connector Pin can rotate freely.
- D. Insert Torque Bar Driver into machine spindle and rotate the housing assembly until the Connector Pin meets up with the Stop Block.
- E. Tighten the three Orientation Ring set screws.
- F. Verify that the Connector Pin is being compressed by the Stop Block and that it is fully disengaged. The shank and spindle should be able to rotate freely.
- G. Verify that the Connector Pin is not being over compressed as there is a limited amount of travel.
- H. Install retention knob back into shank and install Autofacer into Torque Bar Driver.
- I. Make sure Torque Rod coming off Autofacer goes in between the two Driver Rods on Torque Bar Driver.

