How to Calibrate a QX Tool using the QCX Controller

1. From the Home screen select the desired Job.
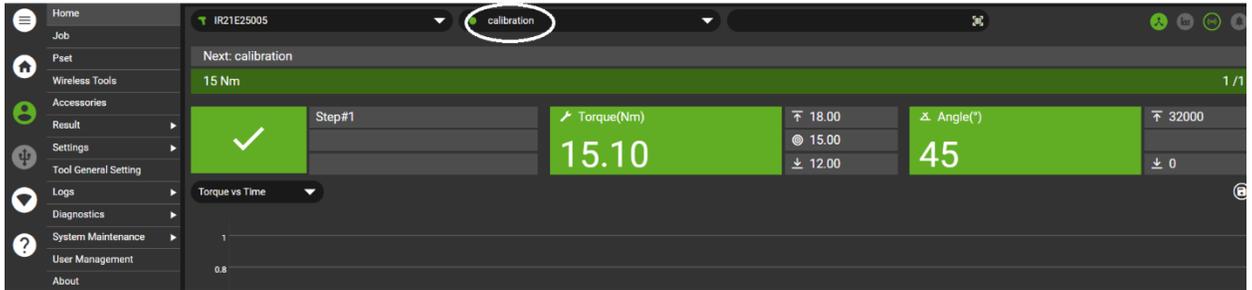
2. Go to System Maintenance and select Tool Calibration.

3. The following screen will populate.
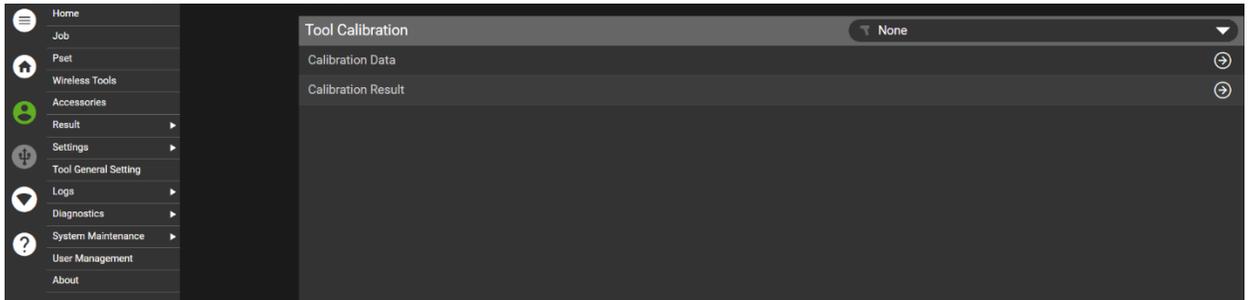
4. Select the tool.
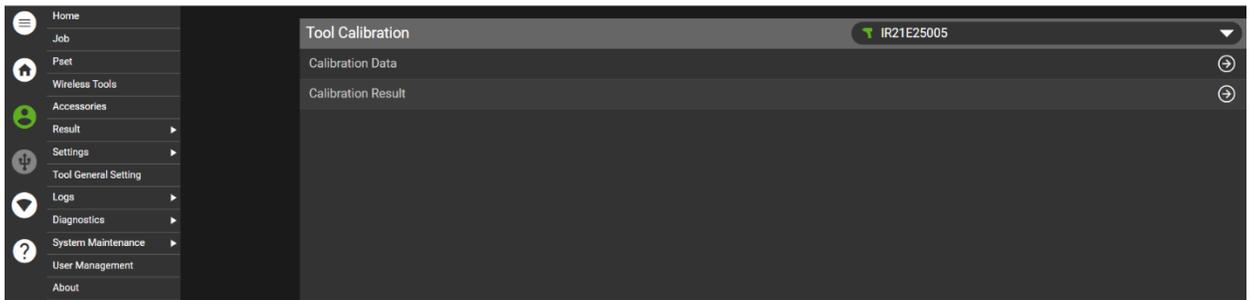
5. Select Calibration Result.
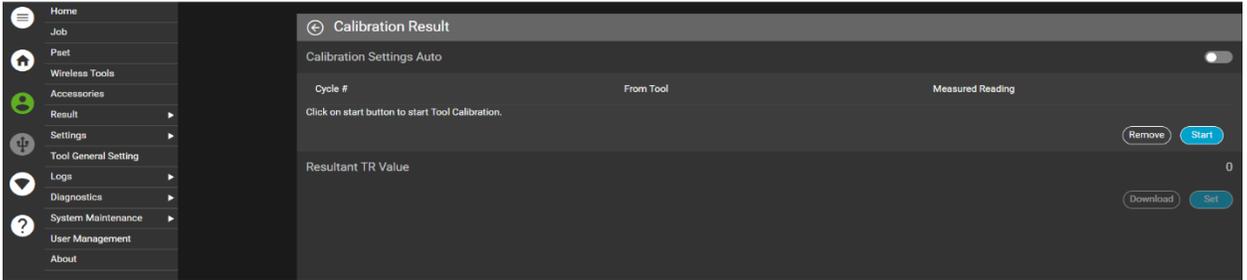
6. For Manual Mode calibration select the Start button and run one cycle. The tool data will populate automatically. Enter the Measured Reading from the external device and press Enter.
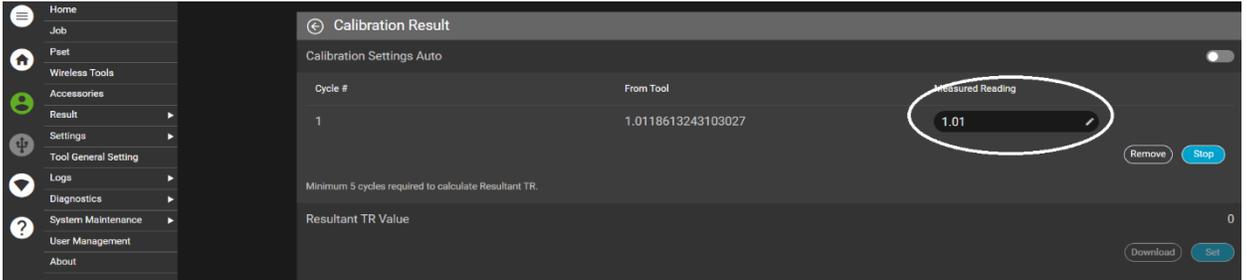
7. Repeat this process for a minimum of 5 cycles (A minimum of 5 readings (30 are recommended) must be collected before a new TR will be calculated).
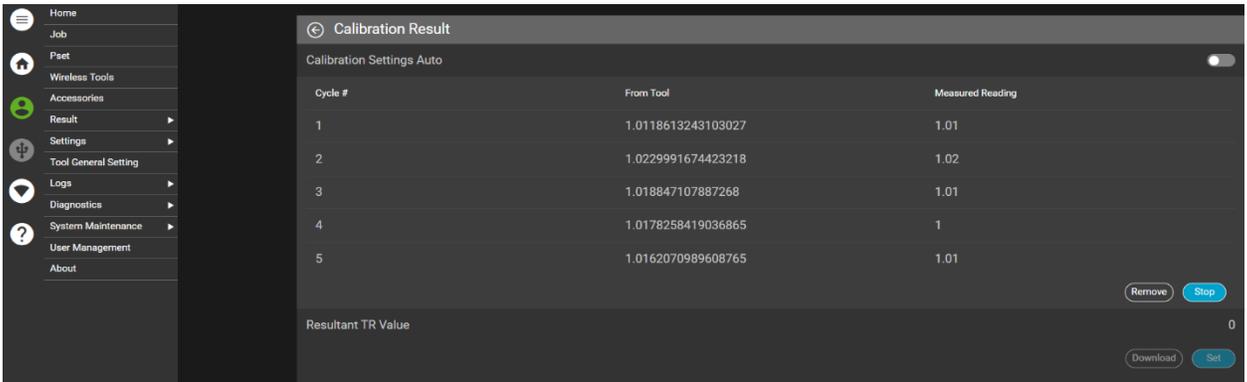
8. Select Stop when the desired number of cycles has been run. A new Resultant TR Value will be populated.
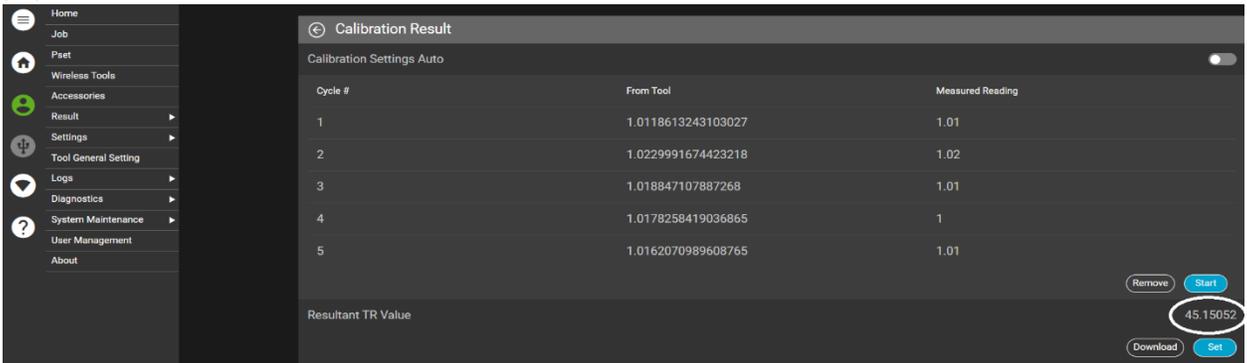
9. Select Download to download the calibration report.

Calibration of Transducer Range(TR) Value

Tool Information

| Tool Serial No | IR21E25005 |
| Tool Model Number | QXXD2PT024ES06 |

Cycle Counter	From Tool	From ETA
1	1.01186132431	1.01
2	1.02299916744	1.02
3	1.01884710789	1.01
4	1.0178258419	1
5	1.01620709896	1.01

| Current Value | 45.4879493713 |
| Resultant TR Value | 45.15052 |

10. Select Set to send the Resultant TR Value to the tool.
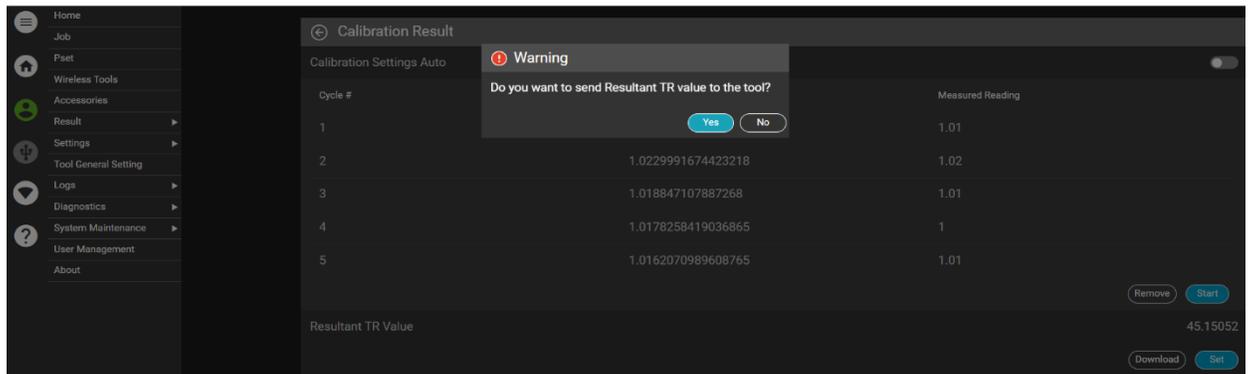
11. Select Yes. You will see the below banner.
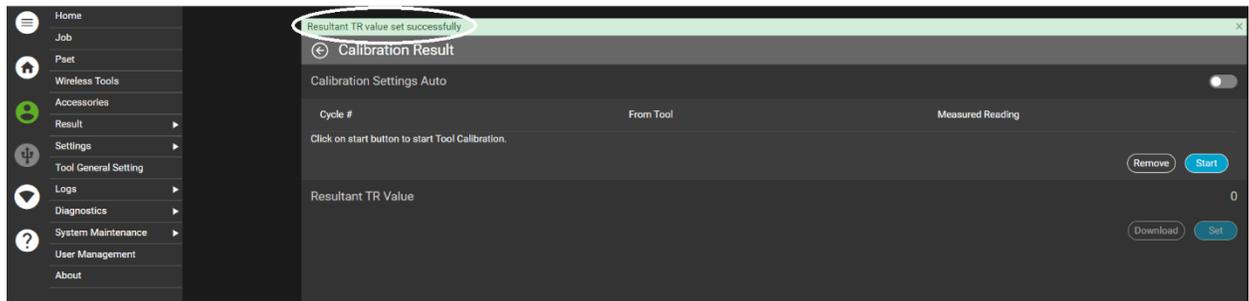
12. The Manual Mode Torque Calibration is complete.

13. If you have access to an EXTT or EXTA Torque Analyzer, Auto Calibration Mode can be used.
14. For Auto Calibration Mode using and EXTT or EXTA Torque Analyzer, turn on the Calibration Settings Auto slider.
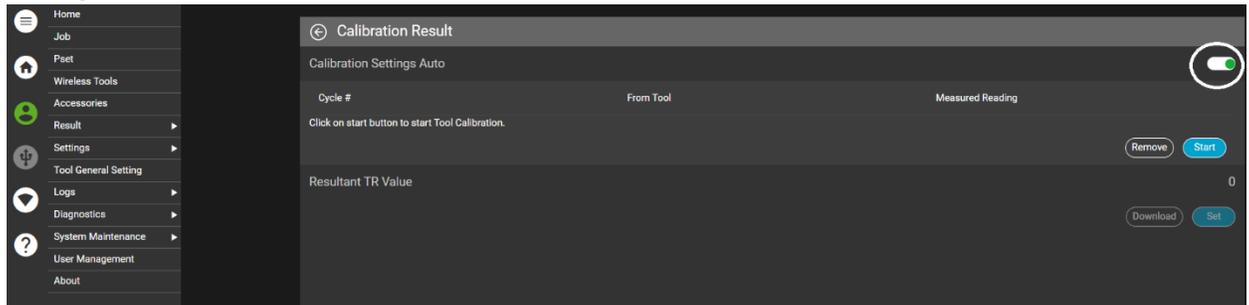
15. Select the Start button.
16. Run one cycle.
17. The results will be populated From Tool and from the EXTT or EXTA connected analyzer automatically after each cycle. Note: The connected Com Port must be selected.
18. Repeat this process for a minimum of 5 cycles (A minimum of 5 readings (30 are recommended) must be collected before a new TR will be calculated).
19. Continue with Steps 8, 9, 10, and 11 from above.
20. The Auto Calibration is complete.