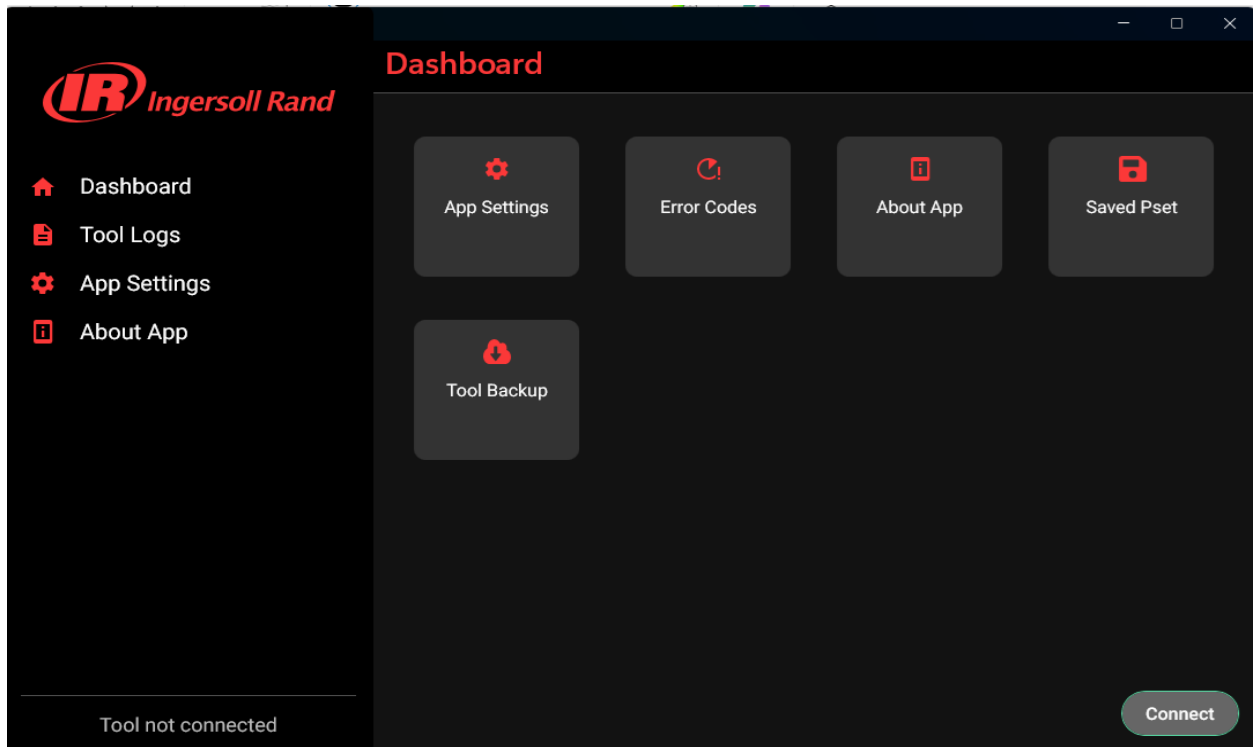
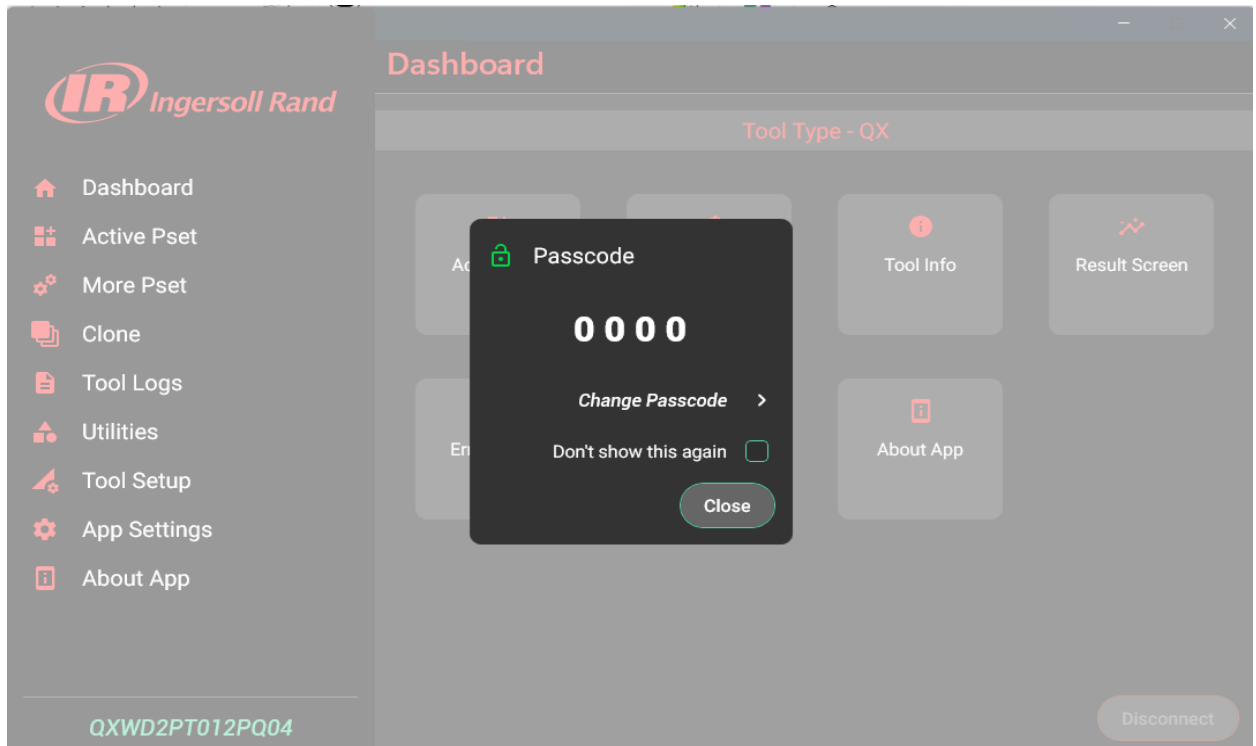


Programming a Pset using the Desktop App

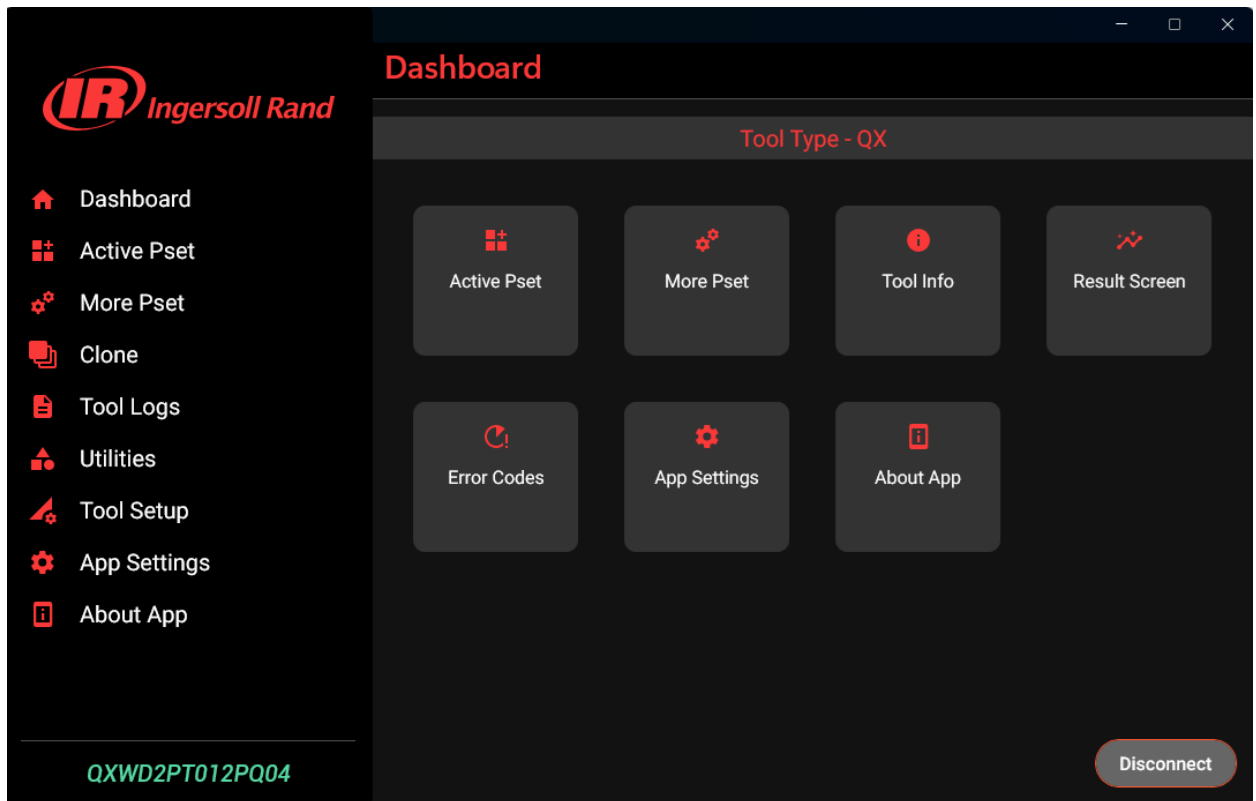
1. Plug USB cable into tool and PC.
2. Open the App.



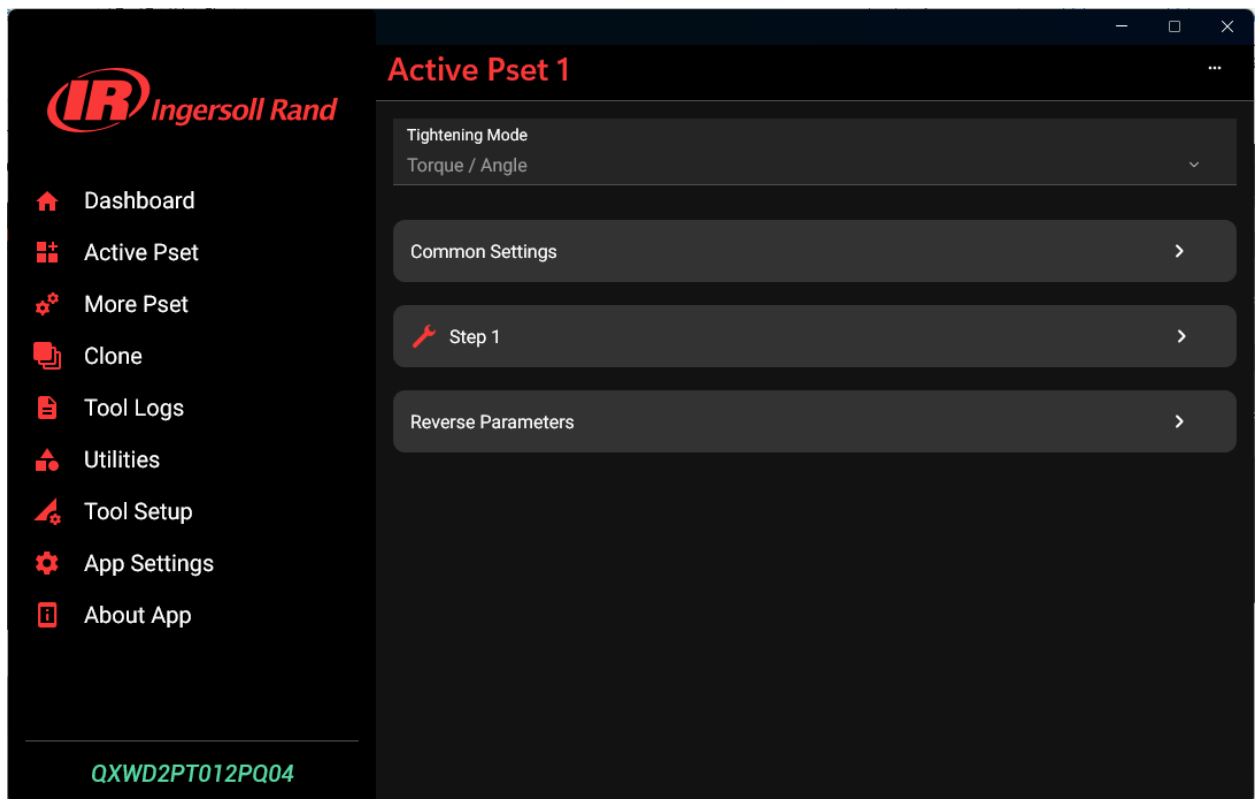
3. Select the Connect button.



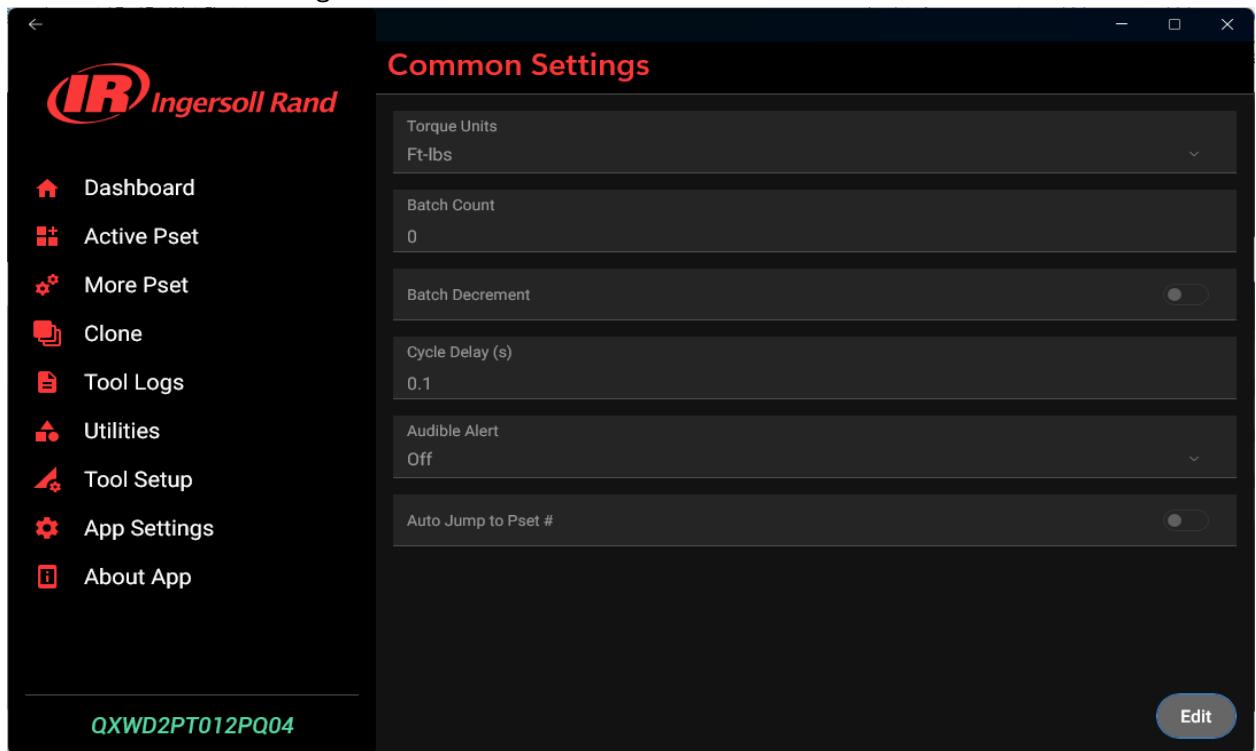
4. For a new tool the default Passcode is 0000. Select the Close button.



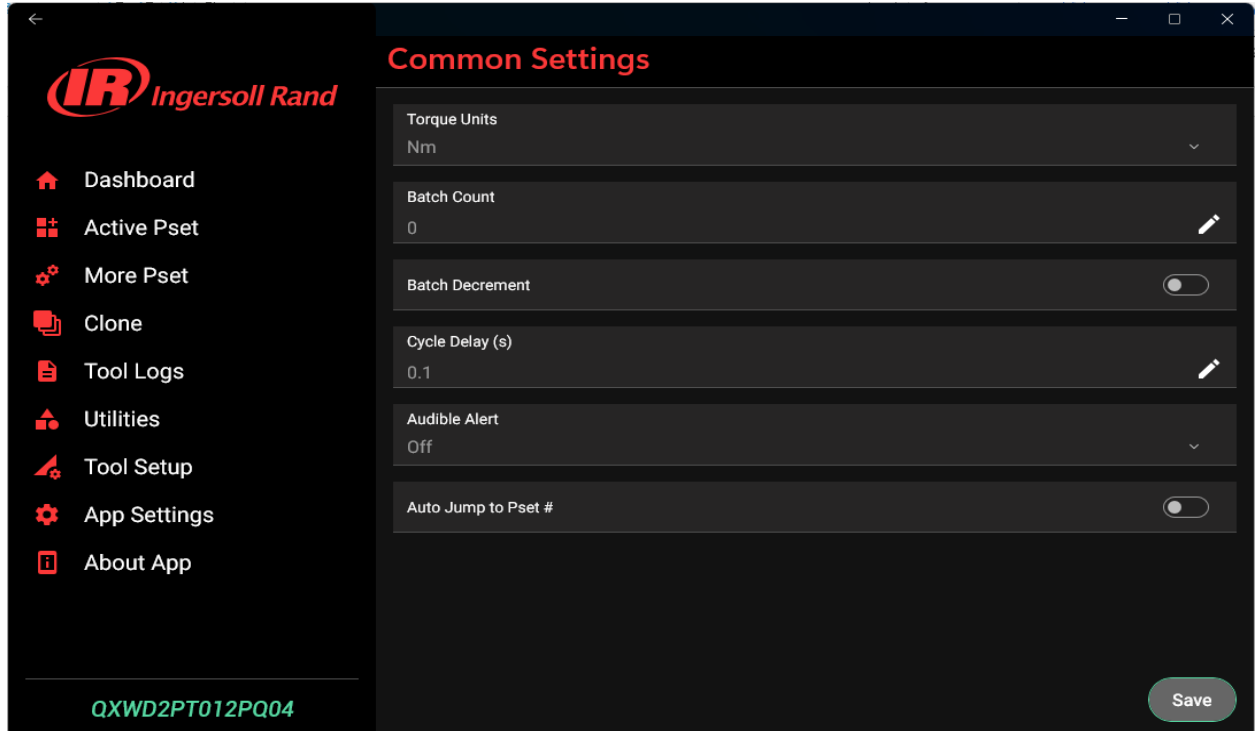
5. Click on Active Pset.



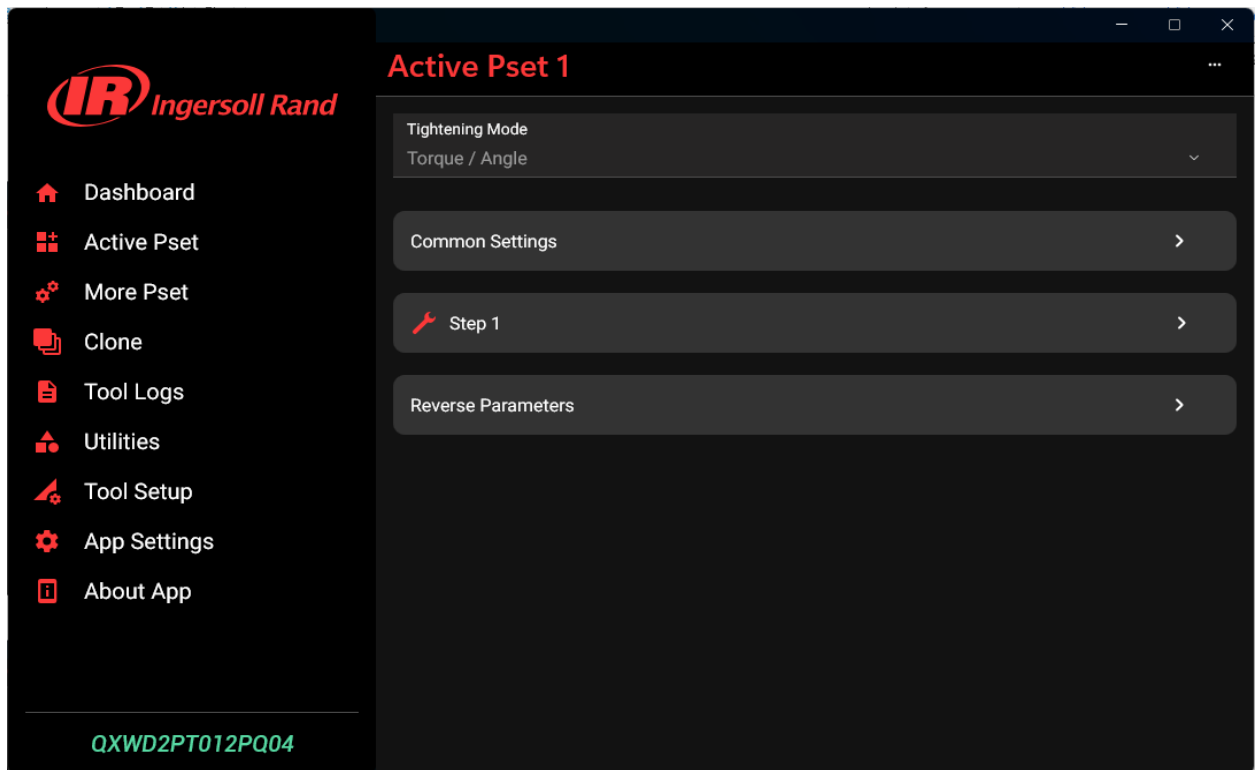
6. Click on Common Settings.



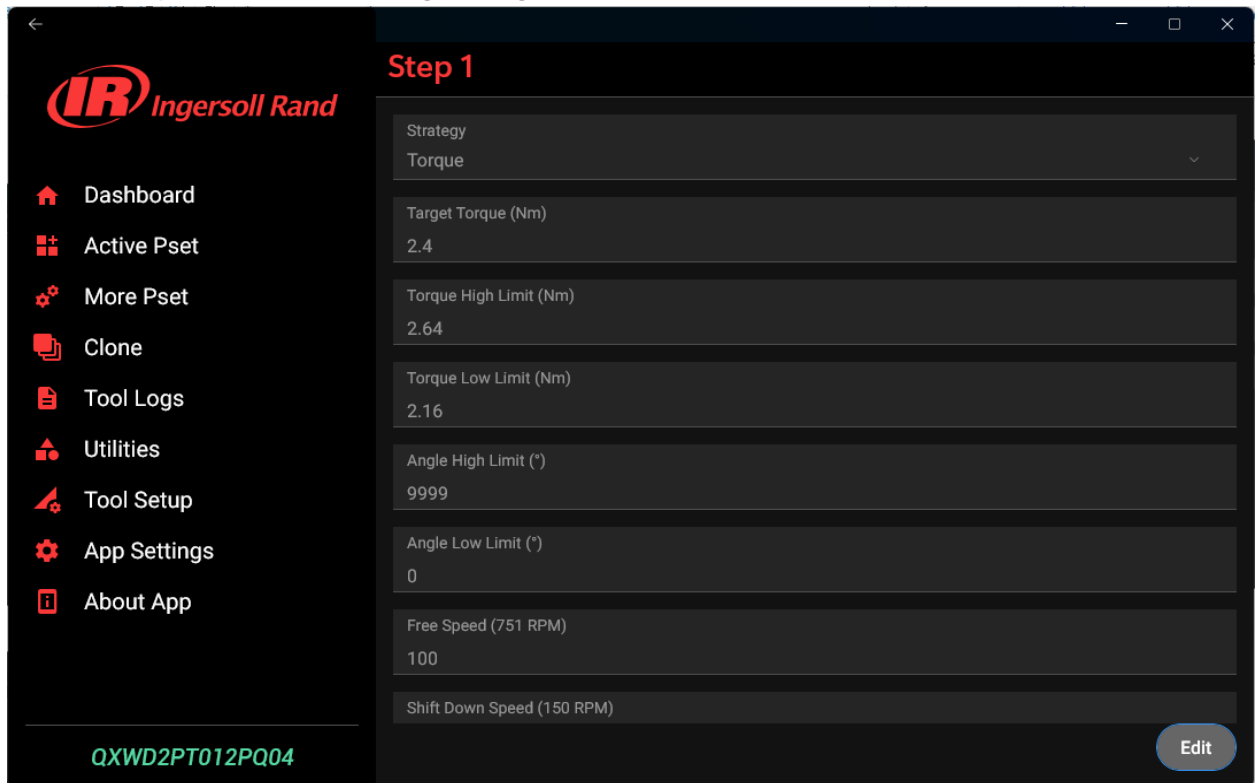
7. Click on Edit to make changes to any of the Parameters.



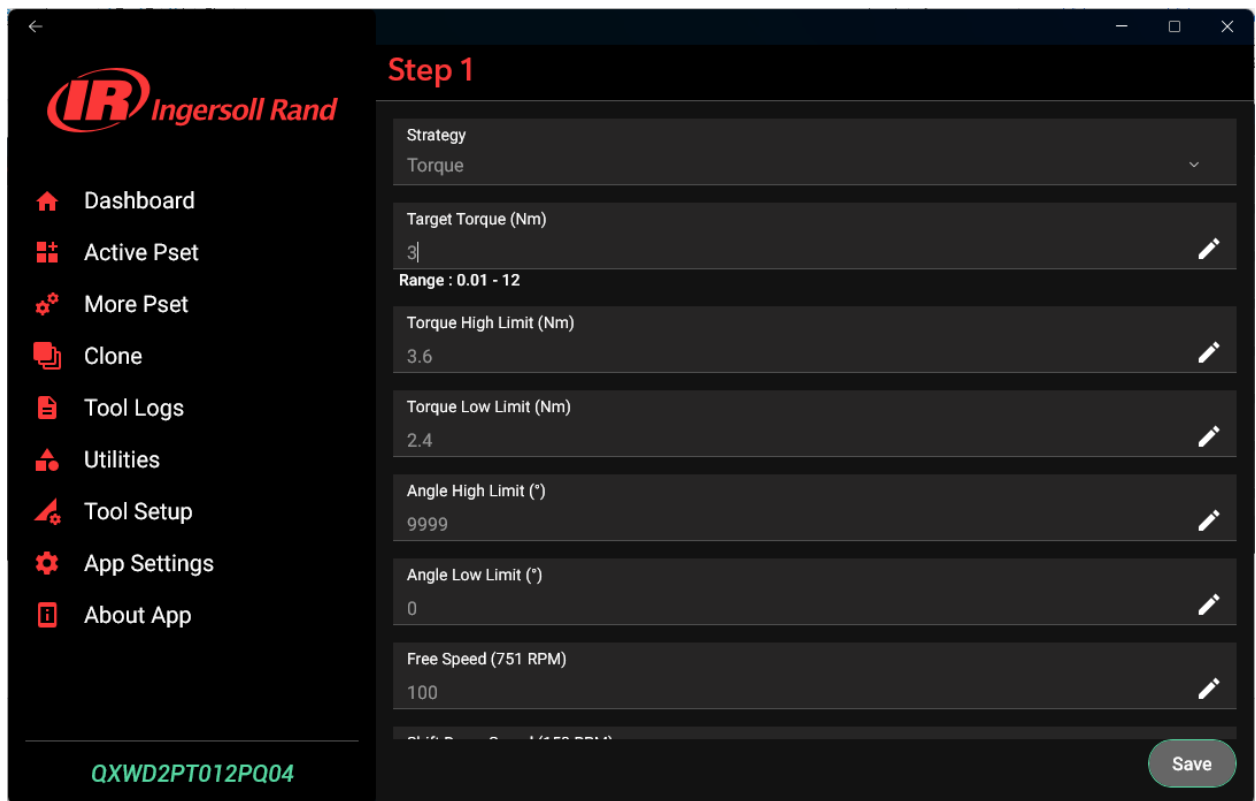
8. Click Save.



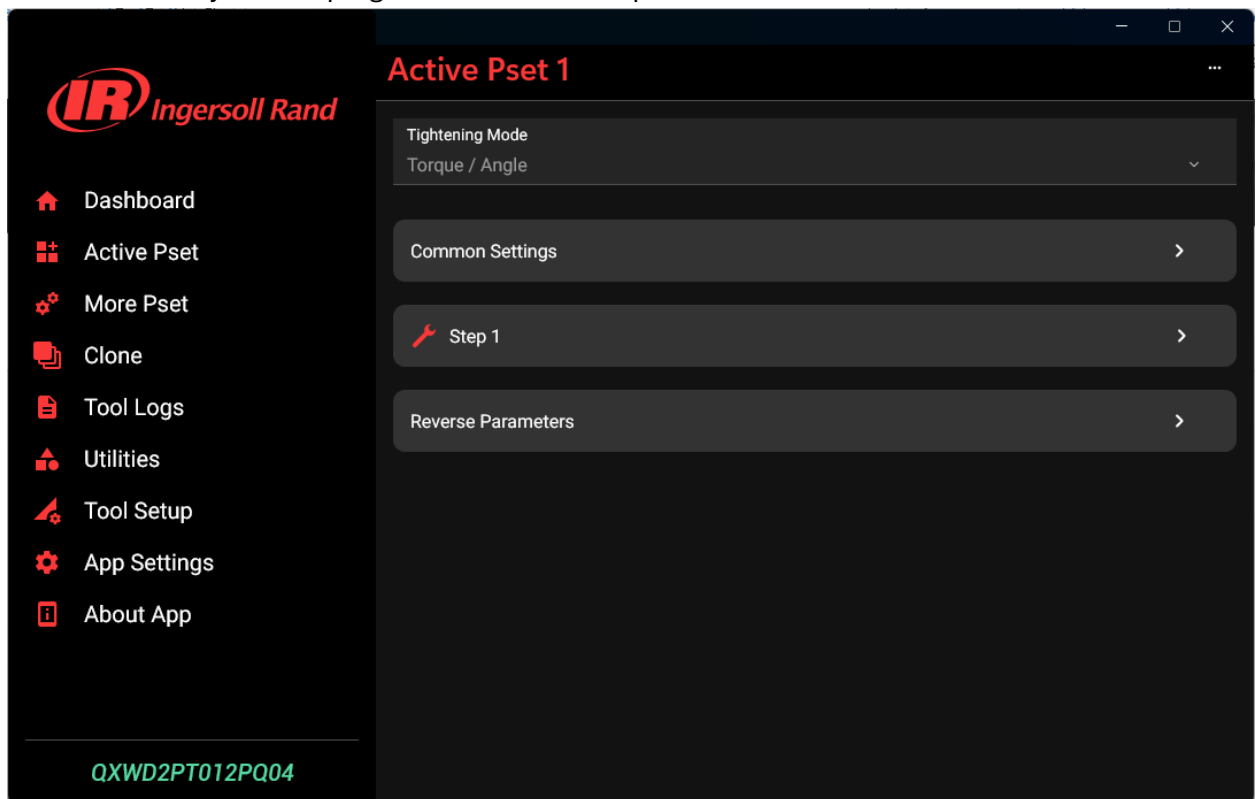
9. Click on Step 1 to view/edit the Tightening Parameters.



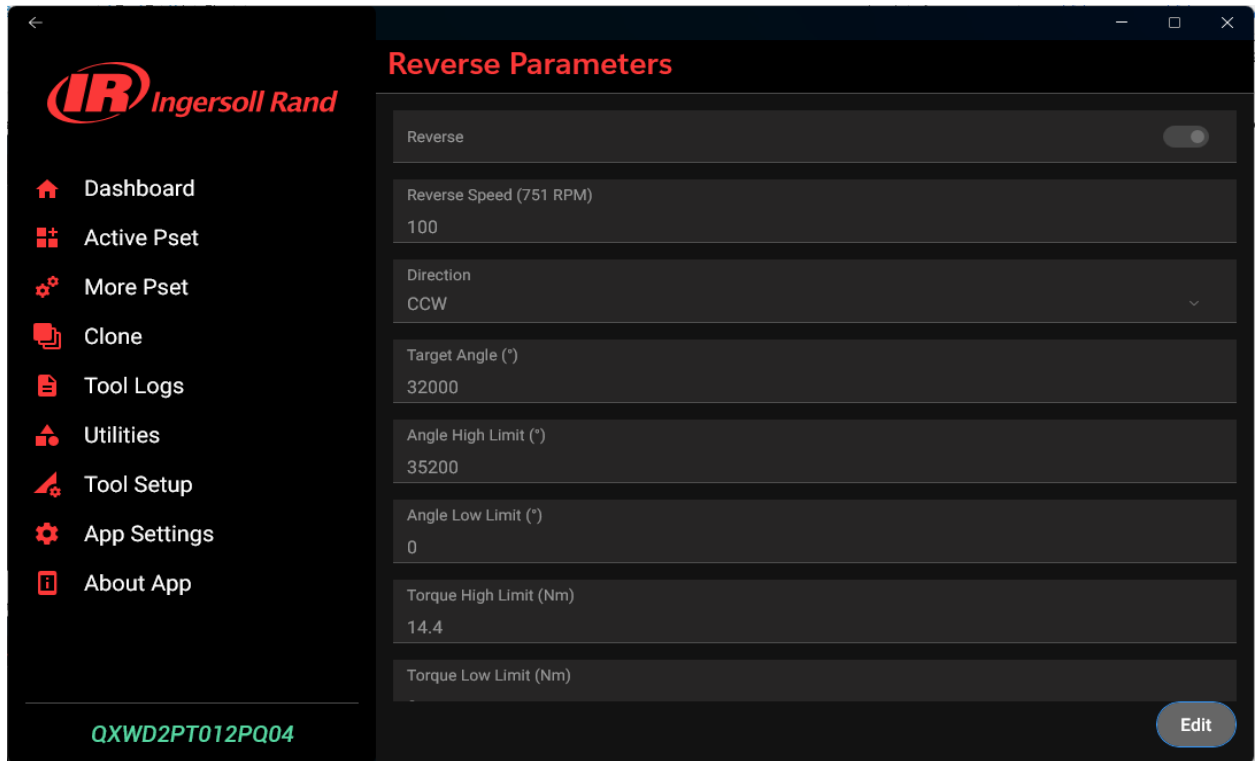
10. Click Edit to make changes to any of the parameters.



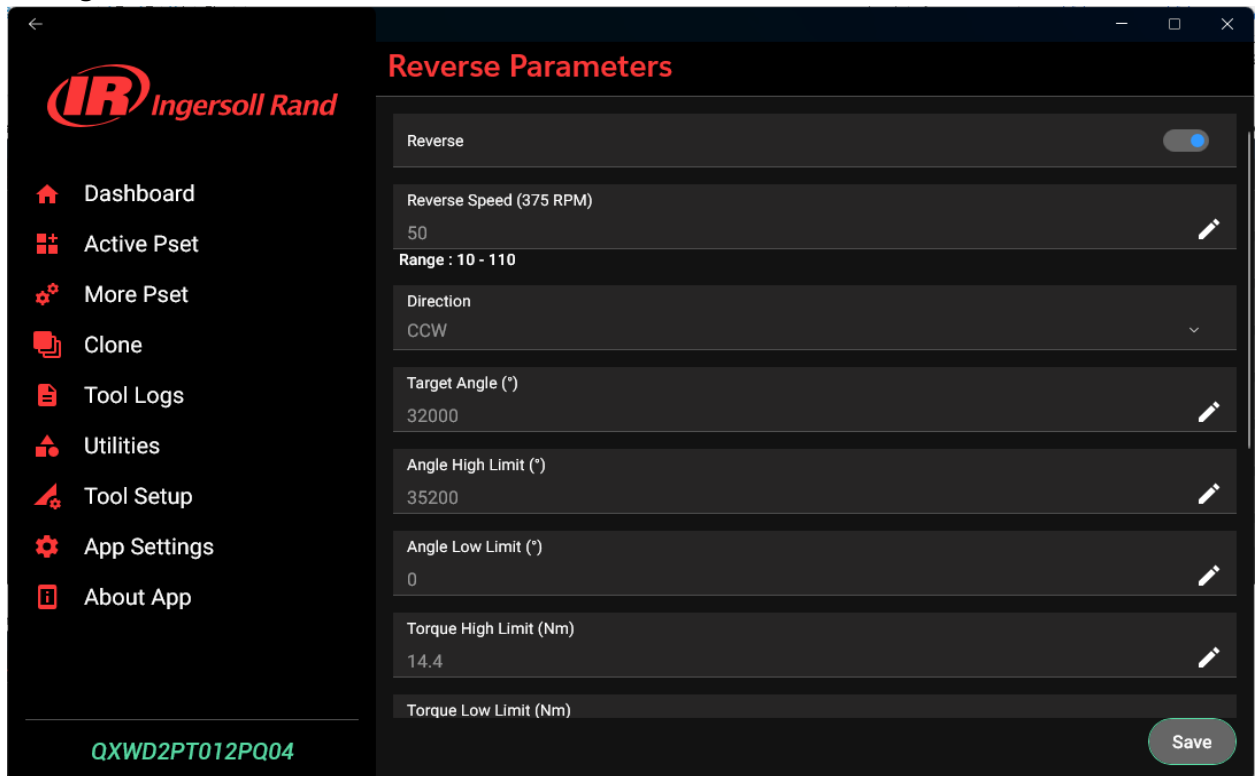
11. Click Save after you have programmed all desired parameters.



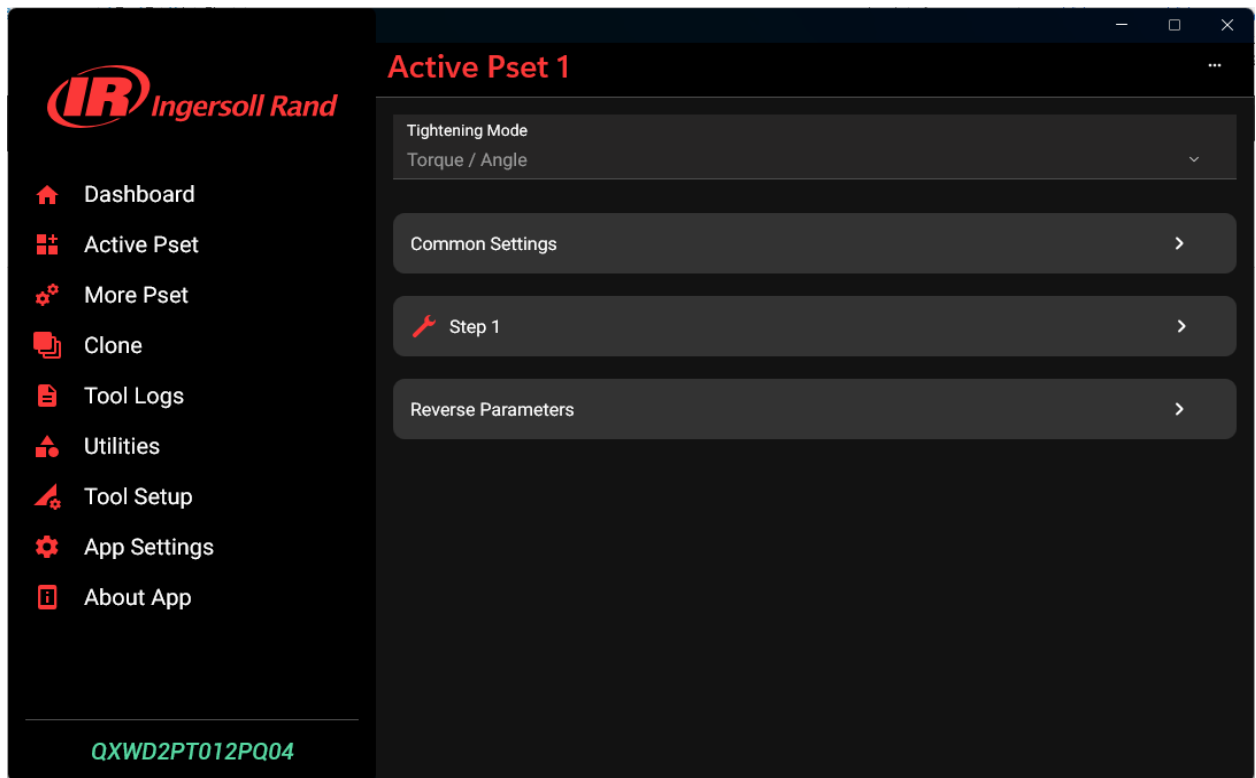
12. Click Reverse Parameters if you wish to customize the Reverse Operation.



13. Click edit to make any changes. Note that it is not necessary to modify the Reverse settings.

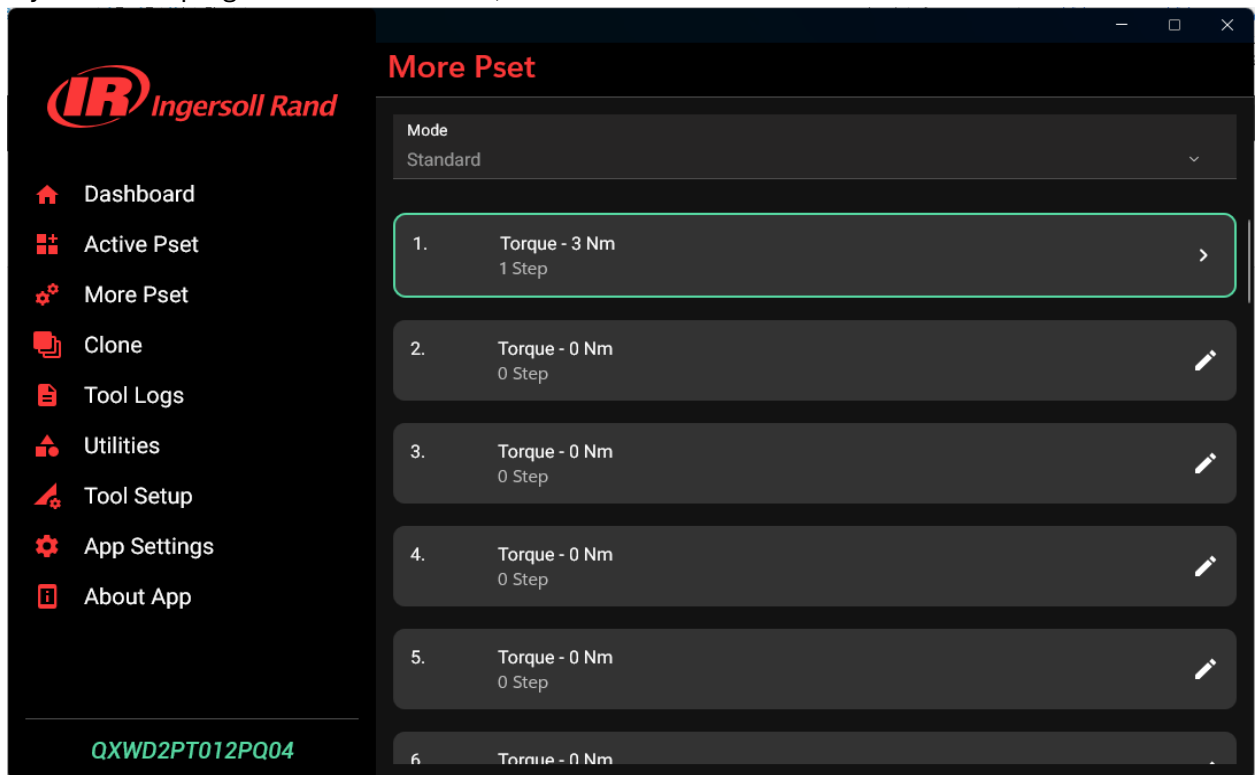


14. Click Save.



15. Pset 1 is programmed and ready to run.

16. If you want to program additional Psets, Select More Pset.



17. Click on the Pset you want to program and follow the same procedure used for Pset 1.

18. Below are definitions for the various parameters for a Torque Strategy. Similar definitions apply for the other Strategies.

- a. **Strategy: Torque**
- b. **Target:** Target value. All other parameters are auto generated from this value. They may be edited.
- c. **Torque High Limit:** Must be higher than the Target Torque. A High Torque fault will be returned if this value is met or exceeded. Default is 20% above Target Torque.
- d. **Low Limit:** Must be lower than Target Torque. A Low Torque fault will be returned if the Torque Threshold is exceeded but the Torque Low Limit value is not met. The default is 20% less than Target Torque.
- e. **Angle High Limit:** The fastening will be aborted, and a High Angle fault will be returned if this value is exceeded. The default is 32,000 degrees.
- f. **Angle Low Limit:** The fastening will return to a fault if the fastening reaches Torque Target, but the Angle Low Limit has not been met. Default is zero degrees.
- g. **Free Speed:** Initial speed in percentage, generally a high speed for quickly advancing through free threads. Default is 100%.
- h. **Shiftdown Speed:** Second speed of the step. The transition occurs at the Shiftdown Point. Default is 20%.
- i. **Shiftdown Point:** Torque value where the speed changes from Free Speed to Shiftdown Speed. Default is 20% of Target Torque.
- j. **Torque Threshold for Counting Angle:** Torque value from which Angle is measured. The default is 50% of Target Torque.
- k. **Step Timeout (sec):** The fastening will be aborted, and a fault will be declared if the fastening takes longer than the step timeout. Default is 15s, range 1-65s.
- l. **Acceleration (%):** Range 5 to 100%, default 90%. Set to a lower value for driving a high inertia load.
- m. **Direction:** Tightening direction. Default is CW.