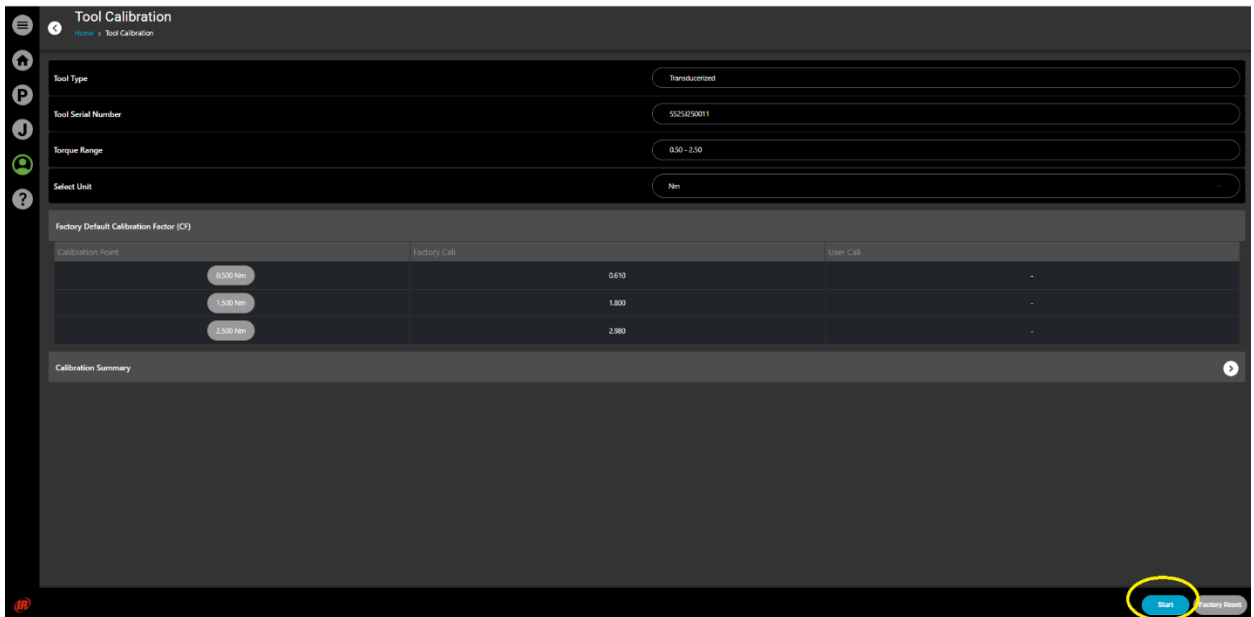
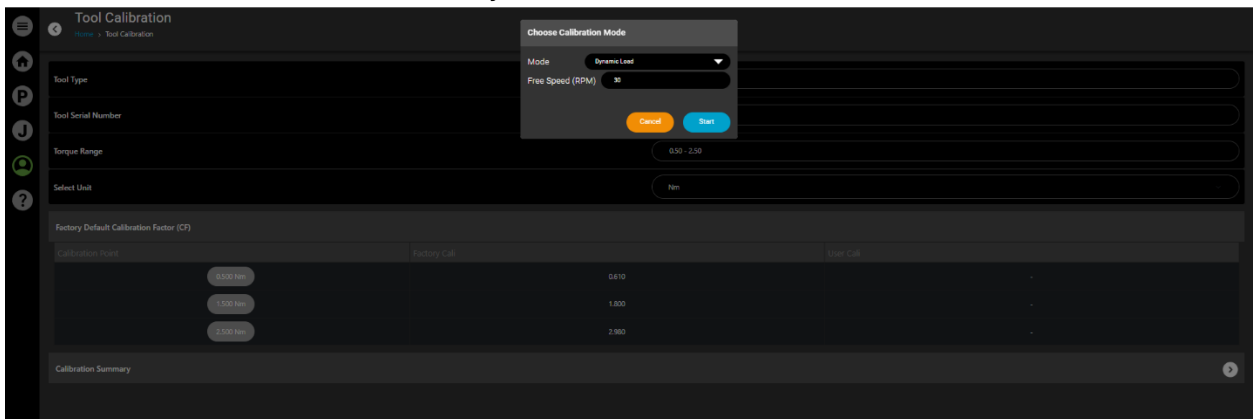


IQi Series Tool Calibration

1. Log in to the controller and go to System Maintenance->Tool Calibration.
2. Click on the Start Button.

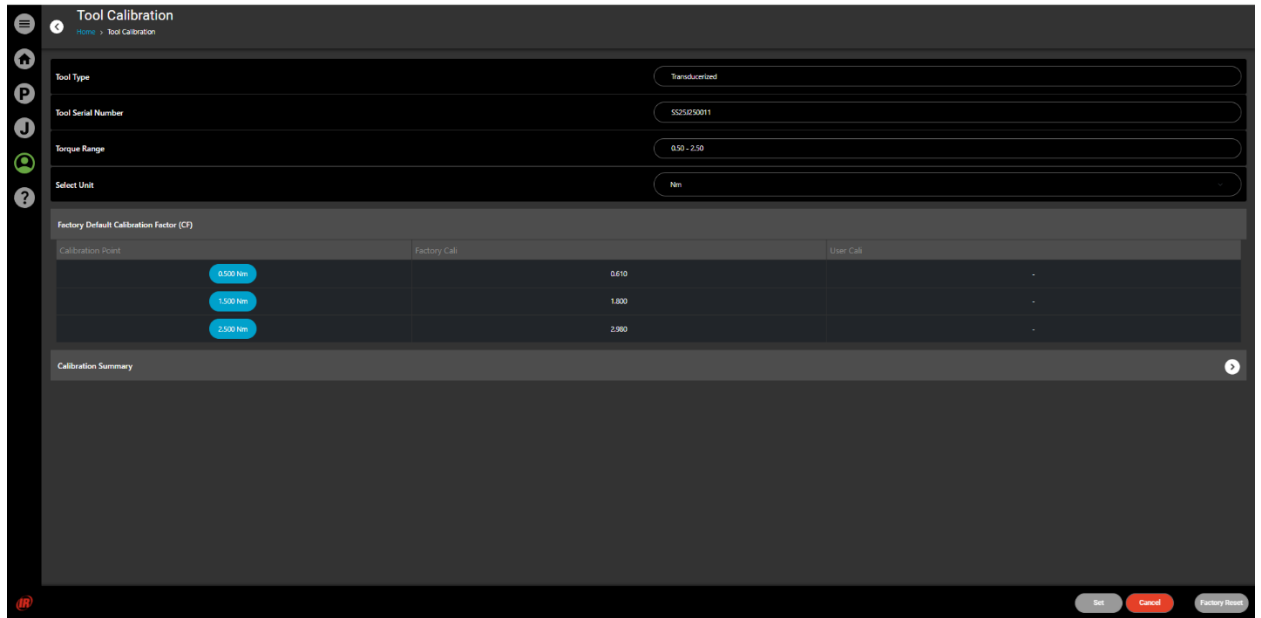


3. Select the desired Calibration Mode, Dynamic or Static.

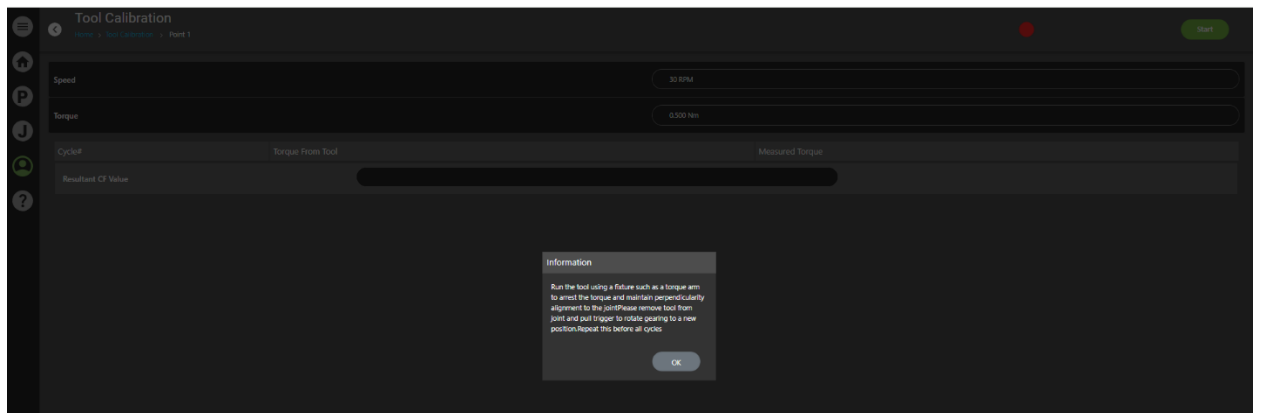


- a. For Dynamic Mode, set the desired Freespeed. Tool will shift down to 5% speed when the torque reaches 20% of Target. Recommended Joint Rate is 180-360 degrees of rotation from 20% Target Torque to Target.
 - b. For Static Mode, speed is set by default to 5%. Joint is locked, with no rotation.
4. The following example is for a standard Dynamic Mode 3-point calibration. Note: For Current Controlled tools it will be a 10-point calibration.

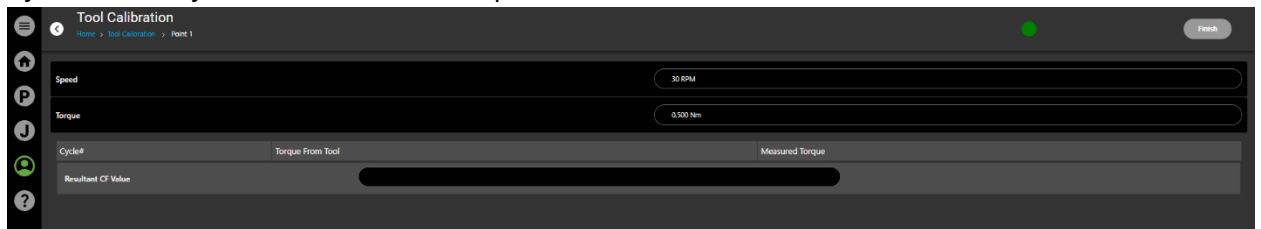
- After selecting Mode and Speed (if required) select Start.



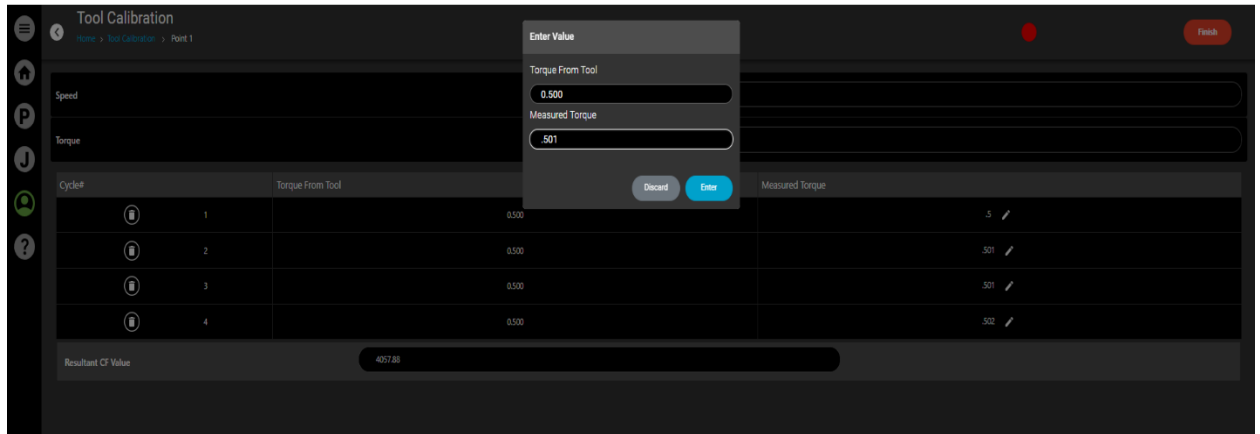
- Click on the desired Calibration Point to begin the calibration.
- Read and acknowledge the Information Message.



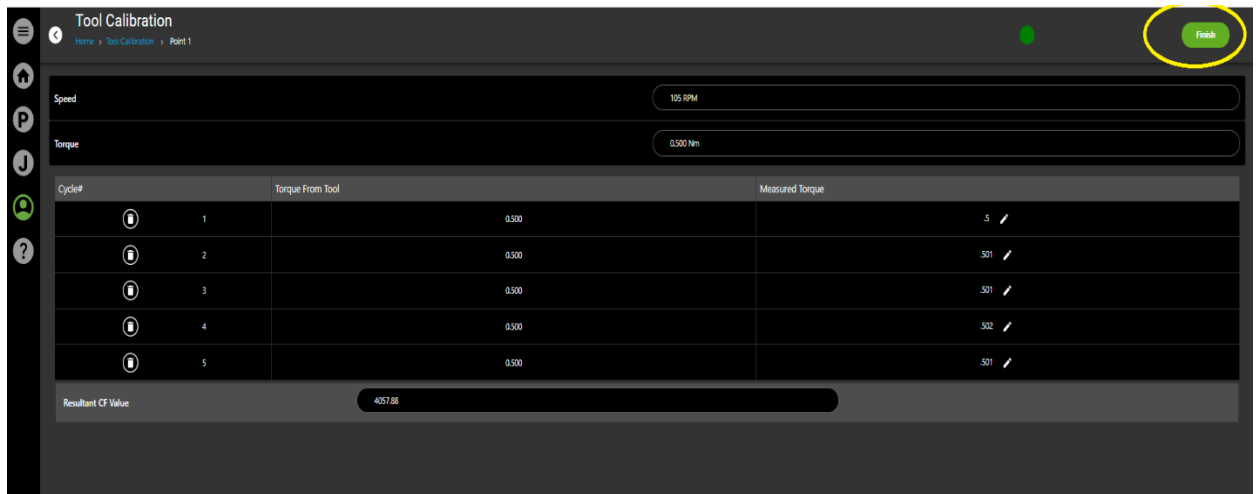
- System is ready to start the calibration process.



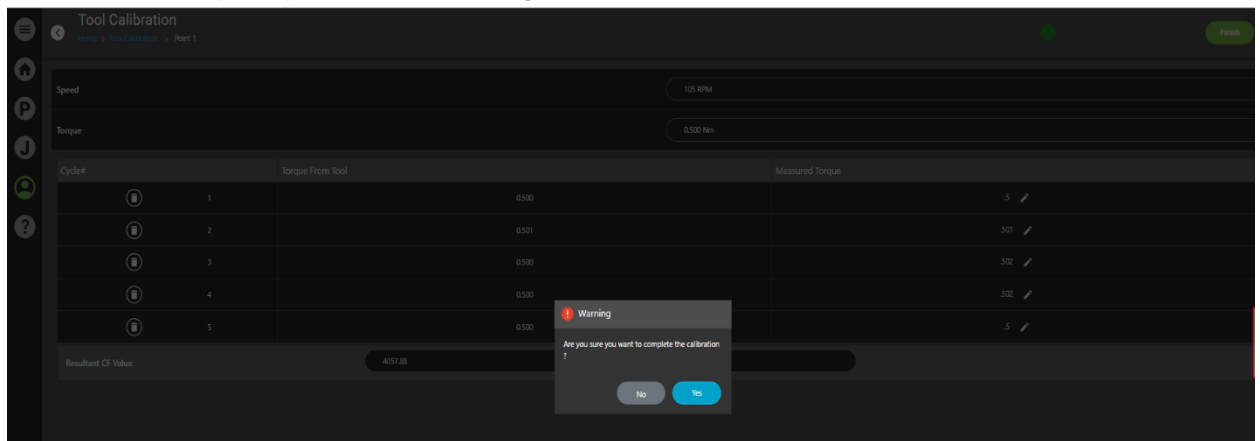
9. Run a minimum of 5 cycles. After each cycle enter the Measured Torque.



10. Once the desired number of cycles has been run, select Finish.

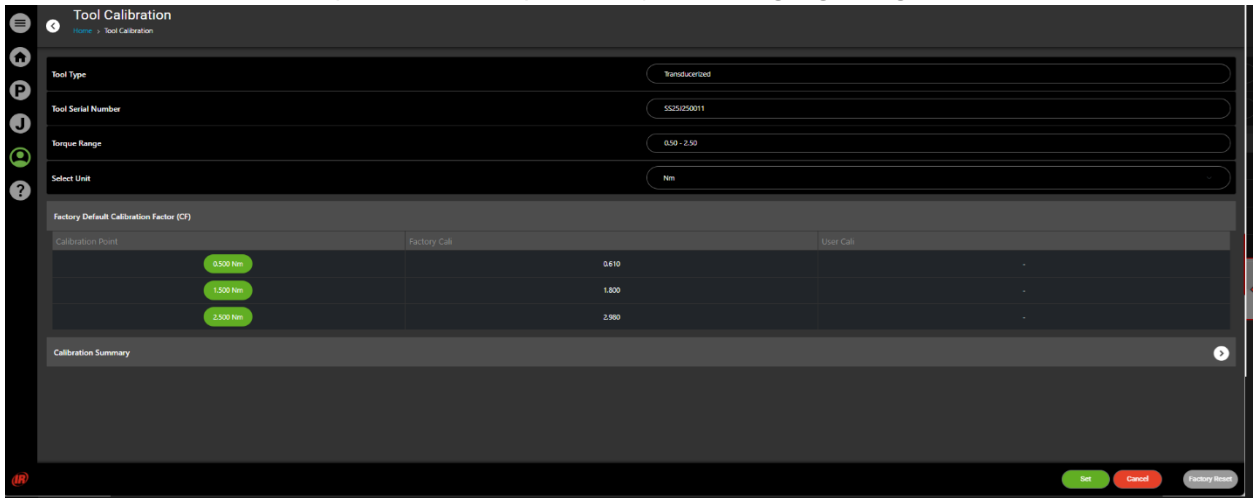


11. Select Yes when prompted about finishing the calibration.

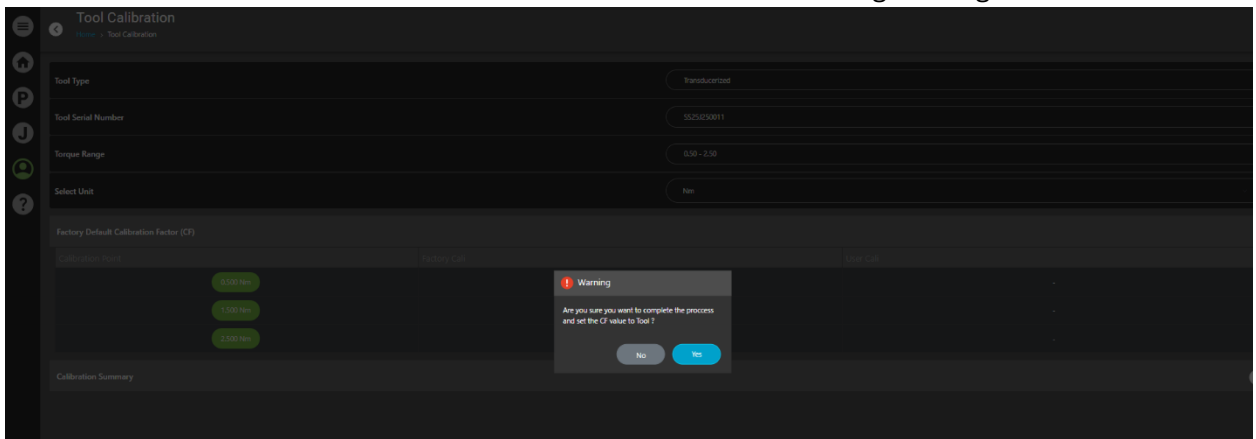


12. Follow the same steps for the next two Calibration Points.

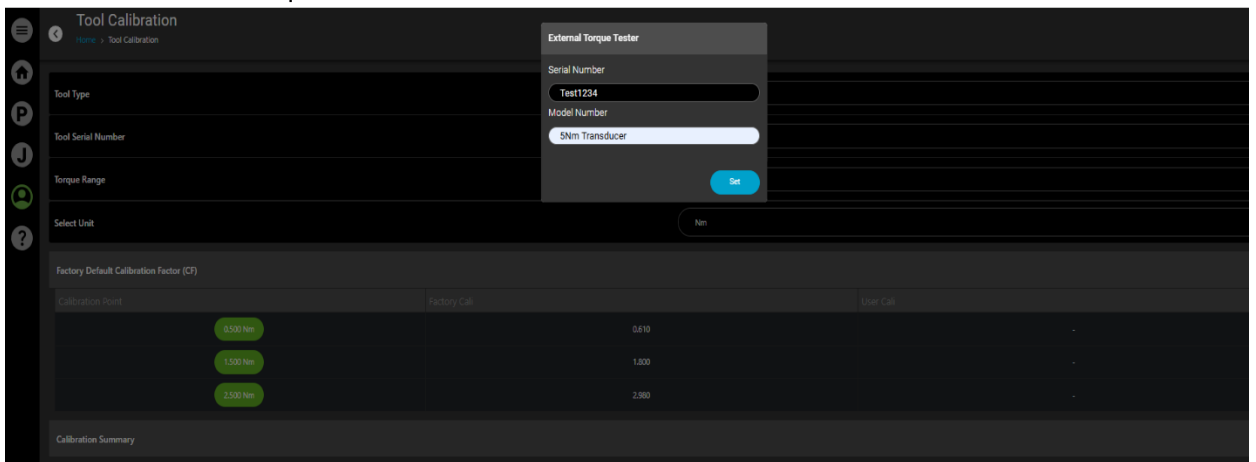
13. When all three calibration points are complete, they will be highlighted green.



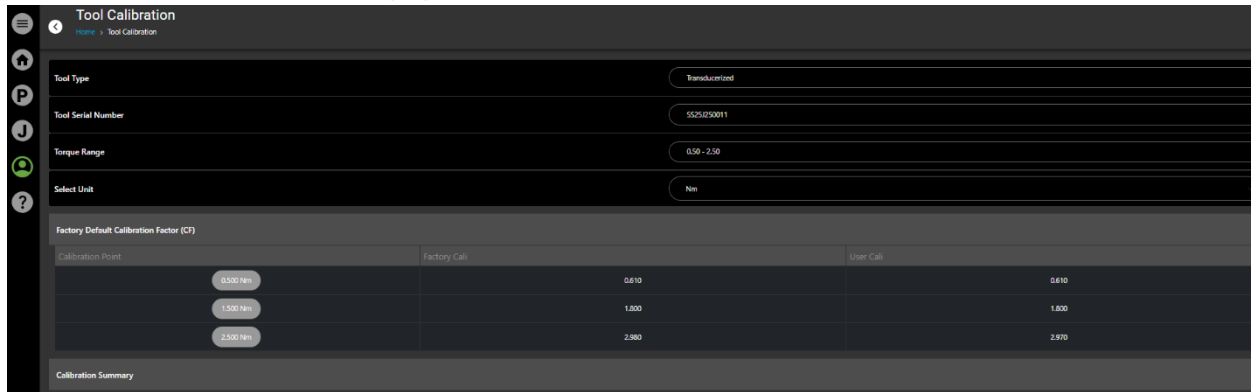
14. Select Set to set the new calibration factor. Select Yes on the Warning message.



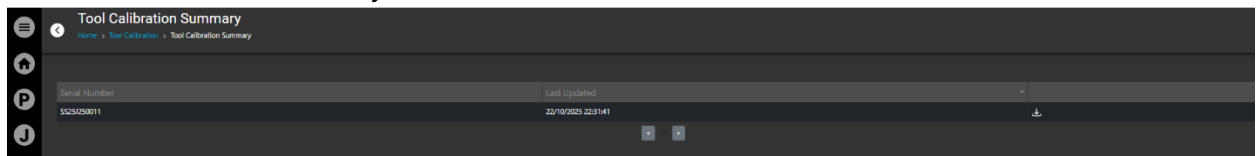
15. Enter the External Torque Tester information and select Set.



16. You will see the User Cal data populated.



17. Click on Calibration Summary.



18. You can download the Calibration Summary Report. Below is a snapshot of the report.



Torque Calibration of IQI Tool

Tool Information

Tool Serial Number	SS25J250011
Tool Model Number	IQI2LT0250PQ4
External Torque Tester Serial Number	Test1234
External Torque Tester Model Number	5Nm Transducer

Calibration Result

22/10/2025 22:31:41

Calibration Point - Point 1

Cycle Counter	From Tool	From External
1	0.501 Nm	0.501 Nm
2	0.500 Nm	0.5 Nm
3	0.500 Nm	0.501 Nm
4	0.500 Nm	0.5 Nm
5	0.500 Nm	0.501 Nm

Set Resultant CF Value: 4061.13

Calibration Point - Point 2

Cycle Counter	From Tool	From External
1	1.500 Nm	1.5 Nm
2	1.500 Nm	1.5 Nm
3	1.500 Nm	1.502 Nm
4	1.501 Nm	1.5 Nm

Cycle Counter	From Tool	From External
5	1.502 Nm	1.5 Nm

Set Resultant CF Value: 1648.89

Calibration Point - Point 3

Cycle Counter	From Tool	From External
1	2.509 Nm	2.505 Nm
2	2.519 Nm	2.515 Nm
3	2.502 Nm	2.5 Nm
4	2.512 Nm	2.51 Nm
5	2.507 Nm	2.507 Nm

Set Resultant CF Value: 1163.36

