

**>Bolting Systems®**

**SPXFLOW®**

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Operating Instructions and Parts List For:



**TWHC Series**

## **HIGH CYCLE HYDRAULIC TORQUE WRENCH**

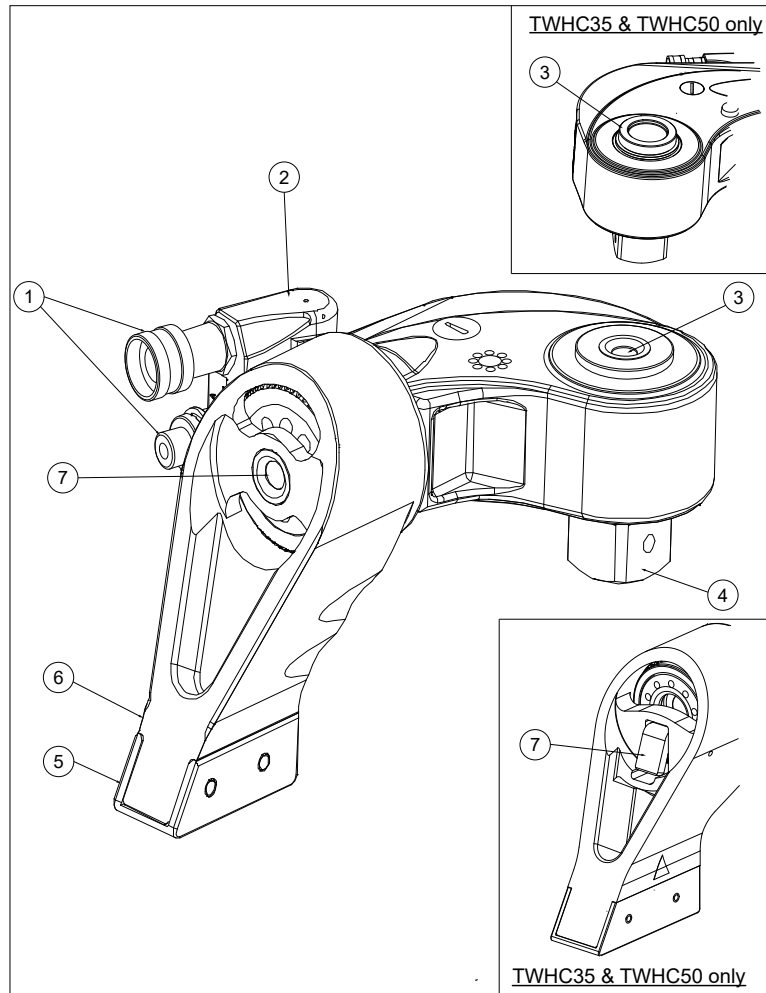


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# TORQUE WRENCH HIGH CYCLE (TWHC)

**Description:** The TWHC torque wrench is a ratchet-type torque tool used in conjunction with standard impact sockets to hydraulically tighten nuts and bolts. It is powered using a 690 bar (10,000 psi) hydraulic pump unit. The torque output from the TWHC torque wrench is proportional to the pump-pressure applied.



Item	Description
1	Hydraulic Couplings
2	Multiswivel Manifold
3	Square Drive Release Button (Square Drive Screw for TWHC35 and TWHC50)
4	Square Drive
5	Reaction Arm Protection Pad
6	Reaction Arm
7	Reaction Arm Release Button (Reaction Arm Latch for TWHC35 and TWHC50)
<b>NOTE: TWHC35 and TWHC50 use a knurled screw to retain the square drive and a latch to release the reaction arm.</b>	

**Figure 1. TWHC Hydraulic Torque Wrench**

# SAFETY SYMBOLS AND DEFINITIONS

The safety signal word designates the degree or level of hazard seriousness.

 **DANGER** : Indicates an imminently hazardous situation which, if not avoided, will result in death or serious injury.

 **WARNING** : Indicates a potentially hazardous situation which, if not avoided, could result in death or serious injury.

 **CAUTION** : Indicates a potentially hazardous situation which, if not avoided, may result in minor or moderate injury.

**CAUTION:** Used without the safety alert symbol indicates a potentially hazardous situation which, if not avoided, may result in property damage.

**IMPORTANT:** Important is used when action or lack of action can cause equipment failure, either immediate or over a long period of time.

## SAFETY PRECAUTIONS

 **WARNING** : To prevent personal injury,



- The following procedures must be performed by qualified, trained personnel who are familiar with this equipment. Operators must read and understand all safety precautions and operating instructions included with the device. If the operator cannot read these instructions, operating instructions and safety precautions must be read and discussed in the operator's native language.

- These products are designed for general use in normal environments. These products are not designed for use in special work environments such as: explosive, flammable, or corrosive. Only the user can decide the suitability of this product in these conditions or extreme environments. SPX Bolting Systems will supply information necessary to help make these decisions. Consult your nearest SPX Bolting Systems facility.



- Safety glasses must be worn at all time by the operator and anyone within sight of the unit. Additional personal protection equipment may include: face shield, goggles, gloves, apron, hard hat, safety shoes, and hearing protection.



- The owner of this tool must verify that safety-related decals are installed, maintained, and replaced if they become hard to read.



- Shut OFF the motor before opening any connections in the system.

## Pump

 **WARNING** :To prevent personal injury,

- Do not exceed the hydraulic pressure rating noted on the pump nameplate or tamper with the internal high pressure relief valve. Creating pressure beyond rated capacities can result in personal injury.
- Retract the system before adding fluid to prevent overfilling the pump reservoir. An overfill can cause personal injury due to excess reservoir pressure created when cylinders are retracted.

## Safety Precautions Continued

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### Electric Motor

**⚠ WARNING** : To prevent personal injury,



- Electrical work must be performed and tested by a qualified electrician per local directives and standards.
- Disconnect the pump from the power supply and relieve pressure before removing the motor case cover or performing maintenance or repair.
- Check the total amperage draw for the electrical circuit you will be using. For example: Do not connect a pump that may draw 25 amps to a 20 amp fused electrical circuit.
- Never use an ungrounded power supply with this unit.
- Changing the voltage is an involved and, if incorrectly performed, hazardous procedure. Consult the manufacturer for specific information before attempting rewiring.
- Wire pump motors for counterclockwise rotation when viewed from the shaft end of the motor.



- Do not attempt to increase the power line capacity by replacing a fuse with another fuse of higher value. Overheating the power line may result in fire.
- Exposing electric pumps to rain or water could result in an electrical hazard.
- Avoid conditions that can cause damage to the power cord, such as abrasion, crushing, sharp cutting edges, or corrosive environment. Damage to the power cord can cause an electrical hazard.

### Hoses

**⚠ WARNING** : To prevent personal injury,



- Before operating the pump, tighten all hose connections using the correct tools. Do not overtighten. Connections should be only secure and leak-free. Overtightening can cause premature thread failure or high pressure fittings to split at pressures lower than their rated capacities.
- Should a hydraulic hose rupture, burst, or need to be disconnected, immediately shut off the pump and shift the control valve twice to release pressure. Never attempt to grasp a leaking hose under pressure with your hands. The force of escaping hydraulic fluid could cause serious injury.
- Do not subject the hose to potential hazard, such as fire, sharp surfaces, heavy impact, or extreme heat or cold. Do not allow the hose to kink, twist, curl, or bend so tightly that the fluid flow within the hose is blocked or reduced. Periodically inspect the hose for wear, because any of these conditions can damage the hose and possibly result in personal injury.
- Do not use the hose to move attached equipment. Stress can damage the hose and possibly cause personal injury.
- Hose material and coupler seals must be compatible with the hydraulic fluid used. Hoses also must not come in contact with corrosive material such as creosote-impregnated objects and some paints. Consult the manufacturer before painting a hose. Never paint the couplers. Hose deterioration due to corrosive materials may result in personal injury.

# INITIAL SETUP

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Each hydraulic torque wrench is supplied completely assembled and ready for use. A hydraulic pump is required to provide the speed and pressure that makes the hydraulic wrench system efficient and accurate.

1. Read and understand all instructions before operating the hydraulic torque wrench. It is the operator's responsibility to read, understand, and follow all safety instructions.
2. Remove the hydraulic torque wrench from the shipping container and visually inspect all components for any shipping damage. If any damage is found, notify the carrier immediately. **DO NOT USE TOOL.**

## Power Requirements

The TWHC hydraulic torque wrench requires a hydraulic pump unit, twin-line connecting hose, and couplings to operate. All components must be capable of operating at the system maximum working pressure of 690 bar (10,000 psi). Note that the system maximum working pressure is dynamic, not static.

Pump unit specification varies between manufacturers; however, for correct torque wrench operation, the pump unit must include the following:

**Double Acting** - Pump unit must be capable of double acting operation for advancing and retracting the Torque Wrench.

**Variable Pressure Output** - For torque setting, the pump unit must be able to be easily adjusted by the operator for different pressure outputs.

**Retract Pressure** - Sometimes termed 'idle' pressure, this is the pressure used for torque wrench retraction and must be fixed at approximately 103 bar (1,500 psi). This pressure must not be operator adjustable.

**Remote Handset Controls** - The preferred configuration for the handset is such that, upon starting the pump unit, the pump enters retract or idle mode (pressure fixed at 103 bar (1,500 psi)). To advance the torque wrench, the handset advance/pressure button or lever is pressed and held, upon release of the button, retract mode is automatically entered. A separate button or lever is used to stop the pump.

**Automatic Pressure Release** - The pump must automatically release system pressure when switching between advance and retract modes.

**Pump Flow Rate** - The speed at which the hydraulic torque wrench operates is proportional to the oil flow rate. In general, 2-stage pump units are preferred for torque wrench use as this allows rapid nut rotation under low loads, with fast wrench retraction. As a minimum, 250 cm<sup>3</sup>/min @ 7 bar (15 ci/min @ 100 psi) to 20 cm<sup>3</sup>/min @ 690 bar (1.2 ci/min @ 10,000 psi) should be specified; however, for optimum speed and performance, at least 360 cm<sup>3</sup>/min @ 7 bar (22 ci/min @ 100 psi) to 30 cm<sup>3</sup>/min @ 690 bar (1.8 ci/min @ 10,000 psi) is recommended.

**Pressure Gauge** - Clarity is important for accurate torque setting; therefore, a pressure gauge of at least 100-mm (4-in.) diameter should be fitted.

**Hydraulic Couplings** - TWHC hydraulic torque wrenches are fitted with CEJN 230 screw-to-connect couplings (1/4-in. NPT) as standard. Verify any couplings that are used are compatible with these couplings and rated to the same working pressure, e.g. Parker 3000 couplings.

SPX Bolting Systems will not be responsible for torque wrench damage, malfunction or operator injury caused by the use of an incorrect pump unit; therefore, check the compatibility of your pump unit before operating the hydraulic torque wrench.

## Initial Setup Continued

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### Torque Wrench Usage

To ensure reasonable life and performance from the torque wrench and system (pump and hoses), these guidelines should be followed:

- Under normal use, the torque wrench should be limited to 75–80% of its maximum achievable torque output.
- Under breakout conditions, because the bolt can suddenly break free and result in shock loads, jumping/ jolting, it is recommended to limit the wrench output torque to 60–70% of maximum achievable torque output. It is also a good idea to have torque in reserve for the odd stubborn bolt/nut.
- Once a corroded bolt has broken free, do not use a torque wrench to wind the nut from the bolt. This can cause the nut to bind and lock onto the bolt and make it impossible to remove. It is preferred that a nut runner or impact wrench be used to remove the nut following initial breakout by hydraulic torque wrench.
- Occasional use of the torque wrench at full pressure/torque is acceptable, but unnecessary continuous use at full pressure will reduce the life of the torque wrench and system.
- In elevated temperature environments, it is advisable to cool the torque wrench as much as practical to maintain the sealing systems in good order. Depending upon the pressure applied to the wrench, repeated use in temperatures in excess of 40°C (104°F) will affect the life of the hydraulic seals.

If the temperatures are likely to exceed 40°C (104°F), it is advisable to use a larger capacity wrench so that the pressure to achieve the required torque is reduced. This will result in less temperature buildup and less softening of the seals.

Seals should be replaced regularly because, at elevated temperatures, the extrusion resistance of the seal is reduced.

### Connecting the System

The hydraulic wrench head and power pack are connected by a 690 bar (10,000 psi) twin-line hose assembly. Refer to the power-unit manufacturer's operating instructions for proper use.

### Hydraulic Connections

- Never connect or disconnect any hydraulic hoses or fittings without first unloading the wrench and the pump.
- Open all hydraulic controls several times to verify the system has been completely depressurized.
- If the system includes a gauge, double check the gauge to verify pressure has been released.
- When making connections with quick-disconnect coupling, verify the couplings are fully engaged. Threaded connections such as fittings, gauges, etc., must be securely tightened and leak-free.

**NOTE: It is advisable to use quick-connect couplings of the same brand on all system components. Although most manufacturers may state their couplings are normally interchangeable and compatible with other brands, there is no guarantee. Should the system malfunction, please check coupling compatibility.**

## Initial Setup Continued

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### Use of Sockets

Use high-quality, industrial impact sockets at all times. Verify that sockets are rated to accept the full torque output of the torque wrench they are used with. Regularly check the socket for cracks and flaws. If any sign of damage is evident, discard immediately. A damaged socket breaking under load can cause equipment damage or operator injury.

Long-reach or deep sockets are not recommended for use with hydraulic torque tools because they can make the wrench and socket unstable. However, some applications demand the use of long-reach sockets. When long-reach sockets are used, support for both the socket and reaction facility must be provided. The same applies to socket accessories, such as extension bars, knuckle joints (not recommended), etc.

### Safety

The TWHC hydraulic torque wrench is a high-power hydraulic tool. It is strongly recommended that all users are fully trained and competent in the use of hydraulic torque wrench systems. Incorrect use of the equipment or failure to follow any of the safety precaution included herein could lead to serious injury.

**NOTE: The TWHC torque wrench is designed for torque tightening of engineering nuts only. Do not use it for any other purpose.**

- Never exceed the hydraulic torque wrench maximum working pressure of: Advance 690 bar (10,000 psi) and Retract 103 bar (1,500 psi).
- Keep hands and fingers clear of the hydraulic torque wrench head and reaction pad area, before and during operation.
- Keep other personnel clear of the working area and only allow trained personnel to use the equipment.
- Before operation, verify all hoses and equipment are in proper working order. Verify all hydraulic torque wrench components (i.e. square drive, reaction arm, etc.) are properly attached and secure. Verify the square drive retainer button (square drive screw for TWHC35 and 50) is properly located.
- Do not strike any of the components, including the socket, to shock the nut free.
- Verify reaction structures are strong and rigid enough to accept the torque tool reaction forces. Do not use wedges, packing pieces, etc. as temporary reaction structures.
- If backing wrenches are used, keep hands and limbs well clear of the backing wrench.
- Do not tighten any equipment while under pressure. Do not move or rotate the multiswivel manifold while under pressure.
- Verify that any sockets to be used with the hydraulic torque wrench are of impact quality and capable of withstanding the full torque output of the tool.
- Some hydraulic torque wrenches (TWHC 20, 35 and 50) weigh in excess of 20 Kg (44 lb). If necessary, lifting equipment can be used.
- In some instances, it may be necessary for the operator to support the hydraulic torque wrench while it is tightening, i.e. upside-down operations. If the hydraulic torque wrench cannot be strapped into position using ropes, etc., the operator must take care to avoid pinch points.
- Verify hoses are in good condition and undamaged. Do not bend hoses beyond their safe bend radius limit or kink the hose.
- Never use the hydraulic torque wrench with just one hose connected to the Advance port (Port A). This will cause the pressure to intensify within the retract chamber possibly leading to tool damage. Always verify that both hoses are correctly connected.



## Initial Setup Continued

- Take care when handling equipment. Quick connect couplings are especially susceptible to knocks and damage and therefore care must be taken. Note that damaged couplings are difficult to connect. Do not force couplings.
- Do not strike, misuse or abuse any of the equipment. If any abuse or misuse of the equipment is evident, the warranty shall be invalid and the Manufacturer shall not be responsible for any injuries or failures as a result.
- If not in use, and when practical, disconnect the wrench and pump from the power supply to prevent accidental starting.

## Preparing the Torque Wrench for Use

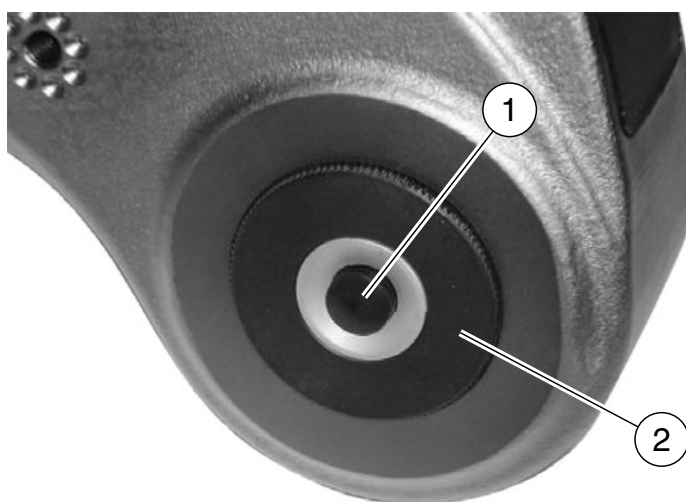
**IMPORTANT:** For a copy of the calibration certificate for a specific hydraulic torque wrench, e-mail [info@spxboltingsystems.com](mailto:info@spxboltingsystems.com) with serial number of the hydraulic torque wrench.

**⚠ CAUTION** : For top performance, frequently inspect wrench, pump, and accessories for visual damage. Always follow instructions for proper wrench and pump maintenance. Do not use other equipment to increase the capability (i.e., hammering on socket wrench).

## Changing the Drive Direction

To change the drive direction:

1. Press and hold the drive-release button (for TWHC1, 3, 6, 11, and 20) and pull out the square drive. The square drive, retainer cap, and button assembly are now free.  
Remove the square drive screw (for TWHC35 and 50) and pull out the square drive. The square drive, square drive cap, and external circlip are now free.
2. To reinstall, insert the square drive into the opposite side of the tool head, aligning the splines, and replace the retainer cap assembly.
3. Pull the square drive to verify that it is locked in position.



Item	Description
1	Square Drive Release Button
2	Square Drive Cap
<b>NOTE:</b> TWHC35 and TWHC50 use knurled screw to retain the square drive (See figure 1).	

**Figure 2. Square Drive Operation**

### Setting Torque

1. Verify the system is fully connected and the proper power supply is available.
2. Refer to the Pressure/Torque Conversion Chart in the Performance Specifications section. Note that this pressure is set on the pump.
3. Turn on the pump.
4. Press and hold the remote control button.
5. Check the pressure on the gauge.
6. Increase or decrease pressure as required. Refer to pump manufacturer's operating instructions.
7. Before tightening a nut, press the remote control button and confirm the correct pressure has been set.
8. Verify that the bolt threads, nut threads, and nut-to-flange contact faces are liberally coated with anti-seize lubricant of the same friction coefficient used to derive the torque value.
9. Make sure the hydraulic torque wrench is suitable to deliver the required torque. Should the torque value exceed 80% of the hydraulic torque wrench output, consider using a higher capacity hydraulic torque wrench.
10. Use the Pressure/Torque Conversion Chart in this manual to obtain the required pump pressure.
11. Verify that the socket to be used is of the correct type and size. A poor fitting or oversized socket can damage nuts, induce inaccurate bolt loads, and may result in operator injury.
12. Place the proper size impact socket on the square drive and secure it properly with the locking ring and pin. Verify that the square drive is fully engaged into the socket.
13. Verify that the reaction arm is placed firmly against a stationary object such as an adjacent nut, flange, equipment housing, etc.

**NOTE: When positioning the wrench, verify the hose connection will not hit any stationary object, which can result in snapping a hose connection or breaking the coupler connection.**

**NOTE: TWHC torque wrenches are equipped with a pressure-release valve built into the multiswivel manifold to protect against retract pressure intensification should the retract port hydraulic coupling not be fully connected or become loose during use. If an intensification occurs, the valve will bleed hydraulic oil externally from the manifold yoke. Oil bleeding from the swivel manifold is not a sign of seal leakage.**

14. Before applying the hydraulic torque wrench to the application, the pump output pressure must be preset to relieve at the pressure obtained from the Pressure/Torque Conversion Chart. This can be done with the hydraulic torque wrench connected to the pump and resting on the floor or bench. Applying advance pressure to the hydraulic torque wrench will extend the piston until it reaches the end of its stroke whereby the pump pressure will build. Holding the wrench at the end of its stroke will allow the pump pressure to be adjusted. Retract the hydraulic torque wrench piston and advance again making sure that the pump relieves at the desired pressure setting. The pump pressure can also be set by blanking the pump outlets using blank couplings.

**NOTE: Allow time for the wrench to retract. If another advance stroke is made before the torque wrench has fully retracted, the ratchet mechanism may not engage correctly, causing it to jump a ratchet tooth, and possibly damaging the ratchet. Before applying another advance stroke, make sure the pump is idling at 103 bar (1,500 psi), which indicates full retraction.**

# OPERATING INSTRUCTIONS

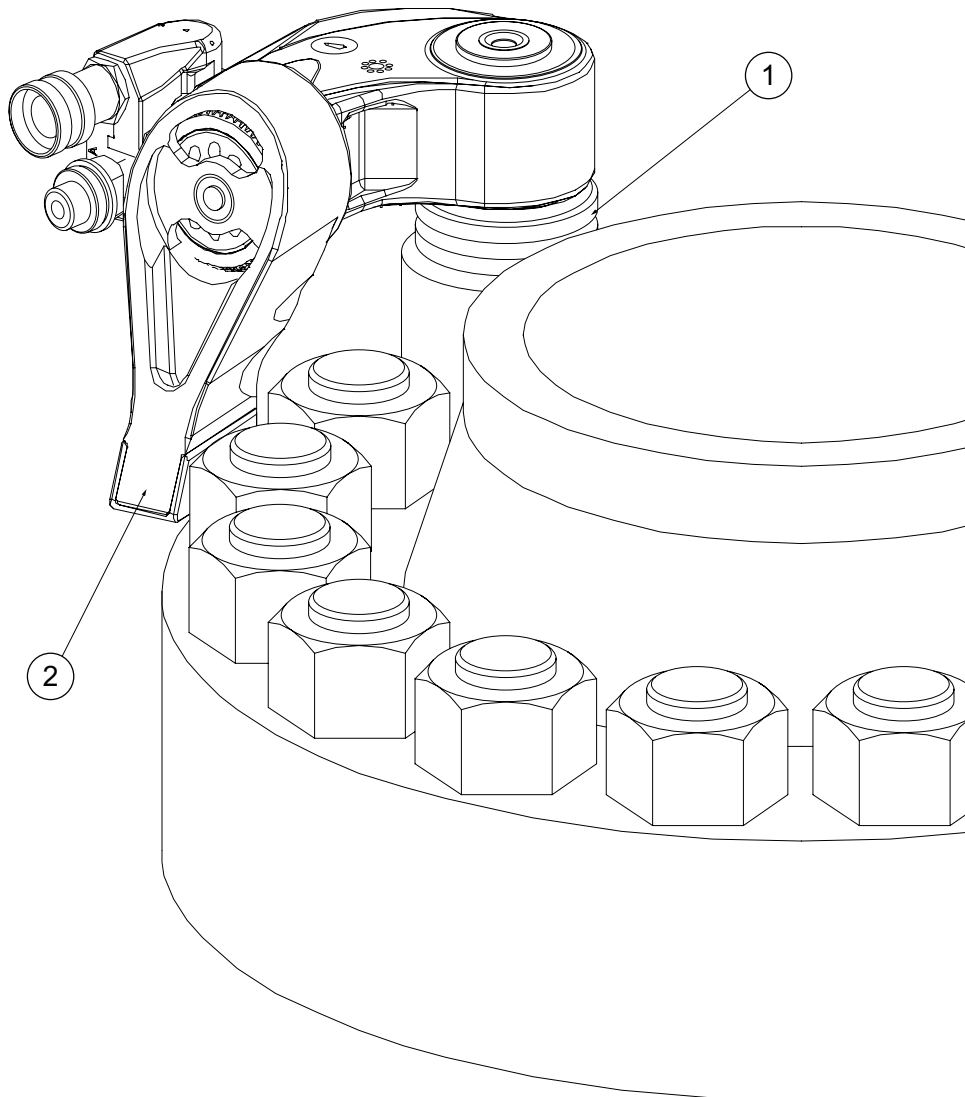
## Positioning the Hydraulic Torque Wrench on the Nut

Figure 3 indicates correct position of the hydraulic torque wrench (shown in tightening mode). Always verify that the reaction pad braces firmly against an adjacent nut or secure reaction structure.

## Using the Reaction Arm

See Figure 3. The TWHC hydraulic torque wrench features a 360° adjustable reaction arm. Although the reaction arm can be placed in a multitude of positions, always try to use the torque tool with the reaction arm positioned parallel to the socket (i.e. 90° to the torque tool body).

**NOTE:** Always verify that the reaction arm is locked onto the body before use, and never attempt to unlock and slide the reaction arm part way off the body to facilitate a reaction point out of reach of its engaged position.



Item	Description
1	Socket
2	Reaction Arm Parallel to Socket and Braced Firmly Against Flange Nut

**Figure 3. Correct Reaction Arm Positioning**

### Reaction Point Safety

Follow these guidelines when selecting appropriate reaction points:

- The reaction structure must be rigid enough to accommodate the forces from the hydraulic torque wrench. Carefully inspect the reaction points for suitability before applying the torque tool. If in doubt, contact the torque wrench supplier for advice.
- Tapered surfaces are generally unsuitable as the torque wrench tends to 'ride up' the taper, causing adverse tool loads. Flat surfaces are preferred.
- Packing pieces, spacers, etc. must never be used as a makeshift reaction point. Reaction accessories are available to increase the access to reaction points.

### Use of Backing Wrenches

Backing wrenches are often used to prevent the non-tightening nut on the opposite side of the joint assembly from turning during the torquing operation. Verify that the backing wrench is the correct size and securely fastened in position (using straps, ropes, etc.). As the torquing operation begins, it is normal for the backing wrench to move/rotate in conjunction with the torqued nut, until the backing wrench contacts an adjacent reaction point. It is important that the operator stand clear of the moving backing wrench to prevent accidental entrapment. The operator must also verify that the reaction point is secure and sufficiently rigid to prevent damage to the structure.

### Torque Wrench Selection

To choose the correct capacity Torque Wrench for the application, the estimated break-out torque should be considered, not the tightening torque. Loosening bolts usually requires a higher torque, and if a wrench has been selected on tightening criteria only, it will seldom perform in a break-out situation.

#### Break-out Considerations

Nuts / Bolts which have been correctly lubricated at the make-up / tightening stage will require approximately 1.5 x tightening torque to loosen following a period of service, PROVIDED THEY HAVE NOT BEEN SUBJECTED TO HEAT.

Corroded / rusted bolts, and bolts without lubrication applied at make-up, will require approximately 2 x tightening torque to loosen. PROVIDED THEY HAVE NOT BEEN SUBJECTED TO HEAT.

Nuts / bolts subjected to heat, seawater corrosion, chemical corrosion, can require 3 to 4 x tightening torque.

Before selecting a torque wrench for the application, ensure that the above has been considered.

### Tightening Bolts

1. Apply the torque wrench and socket to the nut to be tightened, verifying that the reaction arm firmly and squarely contacts the selected reaction point.
2. Start the pump and advance the hydraulic torque wrench. As the wrench strokes forward, the reaction pad will press against the reaction point and the socket will rotate. When the hydraulic torque wrench reaches the end of its stroke, the pump pressure will build rapidly. Fully retract the hydraulic torque wrench (the wrench ratchet mechanism will be heard clicking as it retracts), and apply another forward stroke.
3. Several forward strokes are made until the nut ceases to rotate during the stroke (known as stalling), but bear in mind that nut rotation will always cease at the end of the wrench stroke and must not be confused with the wrench stalling. When the wrench stalls, apply another forward stroke and observe the pump pressure gauge. The pump pressure gauge should read the desired preset pressure.
4. Retract the hydraulic torque wrench, stop the pump unit, and remove the wrench from the nut.

### Tightening a Flanged Joint

This procedure outlines the basic steps to torque-tighten a flanged joint with a TWHC hydraulic torque wrench. It is important that personal protective equipment (gloves, footwear, safety helmet, eye protection, etc.) is worn at all times by the operator and any other personnel in the work area. The torquing procedure uses a single hydraulic torque wrench to accurately achieve a predetermined residual bolt stress.

**⚠ WARNING** : Before bolt torquing, verify that:

- The procedure and data to be used is authorized by a responsible engineer.
- The joints/pipework being worked on are not live. Joints must be at zero pressure and free from hazardous substances.
- The torque value selected must be based upon the lubricant applied.

#### Procedure

1. Working in a crisscross pattern, number each bolt in order of torque sequence.
2. Square up the flanged joint using hydraulic torque wrenches, if necessary.
3. Set the pump at its lowest possible output, 103 bar (1,500 psi), and following the numbers on the bolts, apply the minimum torque to the bolts.
4. In the same tightening sequence, apply approximately 25% of the torque value specified in the torque data.
5. In the same tightening sequence, apply approximately 50% of the torque value specified in the torque data.
6. In the same tightening sequence, apply the full torque value specified in the torque data.
7. Working in a clockwise (or counter-clockwise) direction, make a final pass around the flange, tightening each bolt to the full torque value specified in the torque data.
8. Using a hammer, "ring" each nut to verify that each bolt has been correctly loaded and that no slack bolts remain.

### Loosening Bolts

Loosening bolts using hydraulic torque wrenches can be unpredictable and often unsuccessful, especially if the nuts and bolts are severely corroded. However, some measures can be carried out to increase the success rate of nut breakout:

- In general, loosening mildly rusted bolts requires up to twice the makeup torque to release the nut. Heavily corroded bolts may take up to three times the makeup torque. Verify that the bolt and nut material is strong enough to accept these higher torques.
- Remove surface rust and scale using a wire brush. Apply releasing oil to the nut, bolt, and bearing face, and allow time for the release oil to soak in and penetrate.
- Only use the hydraulic torque wrench to break the nut free. Using the torque tool to wind the nut from the bolt can induce high torsion and reaction forces. Therefore, it is better to use an impact wrench to completely remove the nut.
- Never strike the torque wrench or nut/bolt in an attempt to 'shock' the nut free. This can cause damage to the hydraulic torque wrench and operator injury. Evidence of torque wrench abuse will void the Manufacturer's Warranty.

**NOTE:** Should maximum pump pressure be reached, and the nut has not broken free, use a higher capacity hydraulic torque wrench (if the nut/bolt material will accept the higher torques without damage). Do not, under any circumstances, strike the hydraulic torque wrench or nut/bolt in an attempt to 'shock' the nut free.

## Operating Instructions Continued

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### Procedure

1. Connect the hydraulic torque wrench to the pump unit. Verify that the couplings are fully screwed together; they are self-sealing and will restrict oil flow if not fully connected.
2. Before applying the hydraulic torque wrench to the application, the pump output pressure must be preset to deliver the maximum pressure of 690 bar (10,000 psi). This can be done with the torque wrench connected to the pump and resting on the floor or bench. Applying advance pressure to the hydraulic torque wrench will extend the piston until it reached the end of its stroke whereby the pump pressure will build. Holding the wrench at the end of its stroke will allow the pump pressure to be adjusted. Retract the hydraulic torque wrench piston and advance again making sure that the pump delivered full pressure. The pump pressure can also be set by blanking the pump outlets using blank couplings.
3. Apply the hydraulic torque wrench and socket to the nut to be loosened and verify that the reaction pad is braced firmly and squarely against the selected reaction point.
4. Start the pump and advance the hydraulic torque wrench. As the wrench strokes forward, the reaction pad will press against the reaction point. As the pump pressure builds (and torque is applied to the nut), the nut will break free. Once the nut has been released, remove the nut by hand if loose enough, or alternatively use an impact wrench. Using the hydraulic torque wrench is not recommended.

**NOTE: Should maximum pump pressure be reached, and the nut has not broken free, use a higher capacity hydraulic torque wrench (if the nut/bolt material will accept the higher torques without damage). Do not, under any circumstances, strike the hydraulic torque wrench or nut/bolt in an attempt to 'shock' the nut free.**

5. Retract the hydraulic torque wrench, stop the pump unit, and remove the wrench from the nut.

# PERFORMANCE SPECIFICATIONS

## Technical Specifications

The following technical data is applicable to all TWHC hydraulic torque wrenches:

MAXIMUM PRESSURE: Advance - 690 bar (10,000 psi)  
Retract - 103 bar (1,500 psi)

OPERATING TEMPERATURE LIMITS: -20°C to +40°C (-4°F to 104°F)

HYDRAULIC OIL TYPE: Grade 46 hydraulic oil

Wrench Ref	Square Drive, mm (in.)	Torque Output, ft-lb		Approximate Weight, kg (lb)
		MIN**	MAX	
TWHC1	19.05 (3/4)	170	1413	2.8 (6.2)
TWHC3	25.4 (1)	376	3136	5.3 (11.7)
TWHC6	38.1 (1-1/2)	726	6050	8.8 (19.4)
TWHC11	38.1 (1-1/2)	1336	11134	15.9 (34.9)
TWHC20	63.5 (2-1/2)	2439	20325	27.6 (60.8)
TWHC35	63.5 (2-1/2)	3890	32418	46.4 (102.0)
TWHC50	63.5 (2-1/2)	6360	53000	69.0 (152.0)
** Note that minimum torque can be lower depending upon pump low-pressure capability				

# PRESSURE/TORQUE CONVERSION CHART

Pump Pressure		Torque Output					
		TWHC1		TWHC3		TWHC6	
bar	psi	Nm	ft-lb	Nm	ft-lb	Nm	ft-lb
83	1200	230	170	510	376	984	726
97	1400	268	198	595	439	1148	847
110	1600	306	226	680	502	1312	968
124	1800	345	254	765	564	1476	1089
138	2000	383	283	850	627	1640	1210
152	2200	421	311	935	690	1804	1331
165	2400	460	339	1020	753	1967	1452
179	2600	498	367	1105	815	2131	1573
193	2800	536	396	1190	878	2295	1694
207	3000	574	424	1275	941	2459	1815
221	3200	613	452	1360	1004	2623	1936
234	3400	651	480	1445	1066	2787	2057
248	3600	689	509	1530	1129	2951	2178
262	3800	728	537	1615	1192	3115	2299
276	4000	766	565	1700	1254	3279	2420
290	4200	804	593	1785	1317	3443	2541
303	4400	842	622	1870	1380	3607	2662
317	4600	881	650	1955	1443	3771	2783
331	4800	919	678	2040	1505	3935	2904
345	5000	957	707	2125	1568	4099	3025
359	5200	996	735	2210	1631	4263	3146
372	5400	1034	763	2295	1693	4427	3267
386	5600	1072	791	2380	1756	4591	3388
400	5800	1110	820	2465	1819	4755	3509
414	6000	1149	848	2550	1882	4919	3630
427	6200	1187	876	2635	1944	5083	3751
441	6400	1225	904	2720	2007	5247	3872
455	6600	1264	933	2805	2070	5411	3993
469	6800	1302	961	2890	2132	5575	4114
483	7000	1340	989	2975	2195	5738	4235
496	7200	1379	1017	3060	2258	5902	4356
510	7400	1417	1046	3144	2321	6066	4477
524	7600	1455	1074	3229	2383	6230	4598
538	7800	1493	1102	3314	2446	6394	4719
552	8000	1532	1130	3399	2509	6558	4840
565	8200	1570	1159	3484	2572	6722	4961
579	8400	1608	1187	3569	2634	6886	5082
593	8600	1647	1215	3654	2697	7050	5203
607	8800	1685	1243	3739	2760	7214	5324
621	9000	1723	1272	3824	2822	7378	5445
634	9200	1761	1300	3909	2885	7542	5566
648	9400	1800	1328	3994	2948	7706	5687
662	9600	1838	1356	4079	3011	7870	5808
676	9800	1876	1385	4164	3073	8034	5929
689	10000	1915	1413	4249	3136	8198	6050



## Pressure/Torque Conversion Chart Continued

Pump Pressure		Torque Output							
		TWHC11		TWHC20		TWHC35		TWHC50	
bar	psi	Nm	ft-lb	Nm	ft-lb	Nm	ft-lb	Nm	ft-lb
83	1200	1810	1336	3305	2439	5271	3890	8618	6360
97	1400	2112	1559	3856	2846	6150	4539	10054	7420
110	1600	2414	1781	4407	3252	7028	5187	11491	8480
124	1800	2716	2004	4957	3659	7907	5835	12927	9540
138	2000	3017	2227	5508	4065	8785	6484	14363	10600
152	2200	3319	2449	6059	4472	9664	7132	15799	11660
165	2400	3621	2672	6610	4878	10542	7780	17236	12720
179	2600	3923	2895	7161	5285	11421	8429	18672	13780
193	2800	4224	3118	7711	5691	12300	9077	20108	14840
207	3000	4526	3340	8262	6098	13178	9725	21545	15900
221	3200	4828	3563	8813	6504	14057	10374	22981	16960
234	3400	5129	3786	9364	6911	14935	11022	24417	18020
248	3600	5431	4008	9915	7317	15814	11670	25854	19080
262	3800	5733	4231	10465	7724	16692	12319	27290	20140
276	4000	6035	4454	11016	8130	17571	12967	28726	21200
290	4200	6336	4676	11567	8537	18449	13616	30163	22260
303	4400	6638	4899	12118	8943	19328	14264	31599	23320
317	4600	6940	5122	12669	9350	20206	14912	33035	24380
331	4800	7242	5344	13220	9756	21085	15561	34472	25440
345	5000	7543	5567	13770	10163	21963	16209	35908	26500
359	5200	7845	5790	14321	10569	22842	16857	37344	27560
372	5400	8147	6012	14872	10976	23720	17506	38780	28620
386	5600	8449	6235	15423	11382	24599	18154	40217	29680
400	5800	8750	6458	15974	11789	25478	18802	41653	30740
414	6000	9052	6680	16524	12195	26356	19451	43089	31800
427	6200	9354	6903	17075	12602	27235	20099	44526	32860
441	6400	9656	7126	17626	13008	28113	20748	45962	33920
455	6600	9957	7348	18177	13415	28992	21396	47398	34980
469	6800	10259	7571	18728	13821	29870	22044	48835	36040
483	7000	10561	7794	19278	14228	30749	22693	50271	37100
496	7200	10862	8016	19829	14634	31627	23341	51707	38160
510	7400	11164	8239	20380	15041	32506	23989	53144	39220
524	7600	11466	8462	20931	15447	33384	24638	54580	40280
538	7800	11768	8685	21482	15854	34263	25286	56016	41340
552	8000	12069	8907	22033	16260	35141	25934	57453	42400
565	8200	12371	9130	22583	16667	36020	26583	58889	43460
579	8400	12673	9353	23134	17073	36899	27231	60325	44520
593	8600	12975	9575	23685	17480	37777	27879	61762	45580
607	8800	13276	9798	24236	17886	38656	28528	63198	46640
621	9000	13578	10021	24787	18293	39534	29176	64634	47700
634	9200	13880	10243	25337	18699	40413	29825	66070	48760
648	9400	14182	10466	25888	19106	41291	30473	67507	49820
662	9600	14483	10689	26439	19512	42170	31121	68943	50880
676	9800	14785	10911	26990	19919	43048	31770	70379	51940
689	10000	15087	11134	27541	20325	43927	32418	71816	53000

# GENERAL MAINTENANCE

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## Maintenance

Maintenance should follow each period of use to keep the TWHC hydraulic torque wrench in good working condition.

### TWHC Hydraulic Torque Wrench

1. Wipe away any debris that may have accumulated, particularly around the square-drive area, reaction arm, and hydraulic couplings.
2. Inspect the following components:
  - Hydraulic couplings for signs of damage.
  - Swivel manifold to verify the retaining ring is present and fitted correctly.
  - Verify the guard is present and securely attached. Replace/reattach as necessary.
3. Remove the square drive from the torque wrench and inspect for damage, cracks, etc. Lubricate the bearing journals using Revol R5 Moly Anti-Seize, and replace the square drive if damaged and reinstall.

**NOTE: The TWHC torque wrench drive components must be lubricated using the specified product only. Using alternative lubricants will affect the torque wrench and might lead to premature component failure.**

4. Lightly spray the hydraulic torque wrench with water repellent spray before placing in storage.

Drive components should be lubricated at regular intervals depending on usage. Refer to the repair procedures section for instructions.

### Hoses

1. Clean and inspect each hydraulic hose and quick-connect coupling. Check the entire length of the hose for cuts, abrasions, and damage. Replace the entire hose if any evidence of damage is present.
2. Coat each quick-connect coupling with a water repellent spray.

## Maintenance, Service, and Warranty

In addition to post-use maintenance, and to ensure that the Product Warranty remains valid, it is recommended that routine maintenance and servicing be carried out by the Manufacturer or Authorised Service Centre.

Maintenance and servicing should be carried out in accordance with the manufacturers 'Equipment Maintenance and Servicing Manual'.

All TWHC torque wrenches are supplied under the Manufacturers standard terms and conditions.

All components shall be guaranteed for a period of twelve months from the date of purchase against material defects and workmanship. All components shall be guaranteed for a period of twelve months from the date of purchase against defects arising from normal use, with the following exclusions:

- |                                     |                            |
|-------------------------------------|----------------------------|
| • Hydraulic seals and back-up rings | • Springs                  |
| • Bushes and bearings               | • Circlips                 |
| • O-ring seals                      | • Paints and coatings      |
| • Quick-disconnect couplings        | • Plastic screws and plugs |
| • Labels and decals                 |                            |

## End of Life and Disposal

In accordance with our End of Life Policy, should the product be no longer required for use, it should be returned to SPX Bolting Systems where it shall be disposed of in a safe and environmentally friendly manner.

## TROUBLE SHOOTING

FAULT	POSSIBLE CAUSE	REMEDY
Cylinder will not advance.	1. Coupling not fully mated.	1. Check coupling.
Cylinder will not retract.	2. Cylinder seal leakage.	2. Replace seal.
	3. Pump unit.	3. Check pump unit.
	4. Faulty coupling.	4. Replace coupling.
Torque wrench operates backwards.	1. Reversed couplings.	1. Check pump, hose, and torque wrench for cross connection.
Pressure will not build.	1. Cylinder seal leakage.	1. Change seals.
	2. Swivel seal leakage.	2. Change seals.
	3. Defective pump unit.	3. Check pump unit.
Pressure builds, but wrench does not move.	1. Hose restriction.	1. Change hose.
	2. Coupling not fully assembled.	2. Fully tighten coupling.
Slow torque wrench operation.	1. Hose restriction.	1. Change hose.
	2. Coupling not fully assembled.	2. Fully tighten coupling.
	3. Pump flow rate too small.	3. Use higher flow pump.
Erratic or slow retraction speed.	1. Hose restriction.	1. Change hose.
	2. Coupling not fully assembled.	2. Fully tighten coupling.
Torque wrench does not ratchet.	1. Broken drive shoe.	1. Replace drive shoe.
	2. Jammed drive shoe.	2. Check drive shoe and spring.
	3. Damaged ratchet.	3. Check/replace ratchet.
Ratchet jumps while driving.	1. Worn/damaged ratchet.	1. Replace ratchet and drive shoe.
	2. Worn/damaged drive shoe.	2. Replace ratchet and drive shoe.
	3. Wrench incorrectly retracted.	3. Allow time to fully retract.
	4. Weak/snapped drive shoe spring.	4. Replace springs.
Difficulty in hose connection.	1. Pressure within hose.	1. Vent hose.
	2. Damaged coupling.	2. Replace coupling.

## REPAIR PROCEDURES

It is recommended that full servicing is carried out on an annual basis by the manufacturer or approved service agent (other than maintenance, lubrication, and emergency seal replacement). All components shall be inspected and critical components subjected to nondestructive testing. Hydraulic torque wrenches will be pressure tested and issued with test certification.

Although it is possible to disassemble the TWHC hydraulic torque wrench on site, it is recommended that this operation be carried out in a clean workshop environment, as dirt and debris can severely affect the performance of the seals and other components. Eye protection should be worn at all times during tool assembly and disassembly.

General servicing/repair can be carried out in three specific areas of the hydraulic torque wrench. This allows servicing and lubricating of specific components without complete stripdown. The three servicing areas are:

- Drive components and lubrication.
- Multiswivel manifold components.
- Hydraulic cylinder components.

Full servicing indicates that all three areas are serviced.

### Drive Component Disassembly

The drive components should be lubricated at regular intervals, typically every three months for normal use but monthly or even weekly for frequent/prolonged use. Component lubrication is carried out as follows.

1. Verify the torque wrench is fully retracted. Disconnect the power supply.
2. See Figure 4. Remove the guard, unscrewing the guard screws.



Item	Description
1	Guard Screw
2	Guard

**Figure 4. Guard Removal**

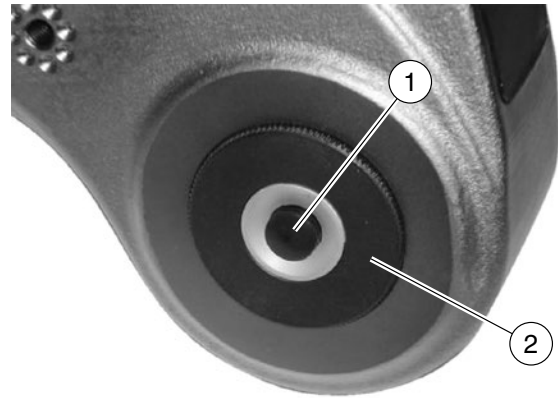
3. See Figure 5. Remove the body plugs (both sides).



**Figure 5. Body Plug Removal**

## Repair Procedures Continued

- See Figure 6. Remove the square drive and square drive cap.



Item	Description
1	Square Drive Release Button
2	Square Drive Cap
<b>NOTE:</b> TWHC35 and TWHC50 use knurled screw to retain the square drive (See figure 1).	

**Figure 6. Square Drive Removal**

- See Figure 7. Push the drive assembly upward until the crank pin is centralised in the body plug hole. Push and remove the crank pin from the drive assembly via the opposite body plug hole.



**Figure 7. Crank Pin Alignment**

- See Figure 8. Using a screwdriver, lever the drive assembly forward and withdraw the complete assembly from the front of the body.



**Figure 8. Drive Assembly Removal**

## Repair Procedures Continued

7. See Figure 9. Remove the ratchet, drive shoe and springs from the crank.
8. Thoroughly clean all components, removing the old lubricant using a mild degreasing agent. Inspect all components for damage and/or excessive wear. Inspect the ratchet and drive shoe teeth for damage, cracks, etc. Any substandard component must be replaced immediately using genuine parts supplied by SPX Bolting Systems.

### Drive Component Assembly

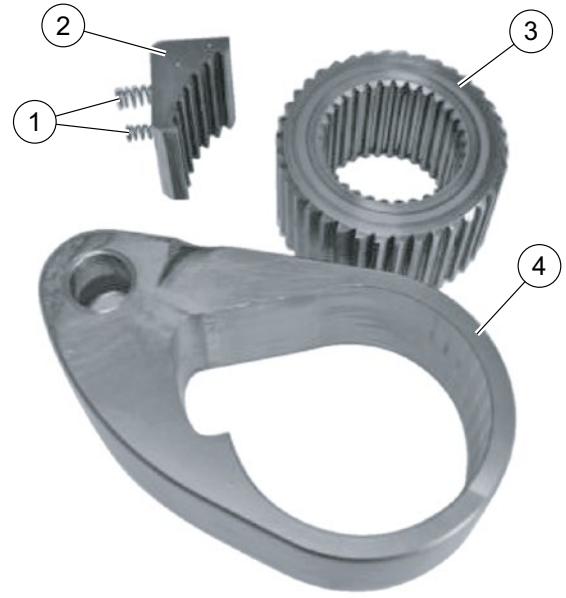
See Figure 10. Before assembly, apply a liberal coat of Revol R5 Moly Anti Seize to the following areas:

- Body internal sideplates (where the crank contacts).
- Crank bearings.
- Crank pocket where the drive shoe is located (not the crank bore).
- Body sideplate journals.
- Square drive bearings.
- Square drive cap bearing.

**IMPORTANT: Do not apply lubricant to the ratchet and drive shoe teeth.**

The hydraulic torque wrench drive components must be lubricated using the specified product only. Using alternative lubricants will affect the output and possibly lead to premature component failure.

1. Place the drive shoe and springs into the crank pocket and install the ratchet ensuring the springs do not tilt. Verify that the ratchet teeth are driving in the correct direction and are engaged with the drive shoe teeth. Rotate the ratchet to ensure correct operation.
2. Install the drive assembly into the wrench body, centralise the crank pin hole in the body plug hole and install the crank pin.
3. Press the drive assembly downwards to centralise the ratchet in the sideplate journals.
4. Slide the square drive into the wrench body and attach the square drive cap.
5. Install both body plugs
6. Refit the guard.



Item	Description
1	Springs
2	Drive Shoe
3	Ratchet
4	Crank

**Figure 9. Drive Disassembly**



Item	Description
1	Body Internal Sideplates
2	Crank Pin
3	Square Drive Cap Bearing
4	Square Drive Bearings
5	Crank Pocket
6	Crank Bearings
7	Sideplate Journals

**Figure 10. Lubrication Areas**

## Repair Procedures Continued

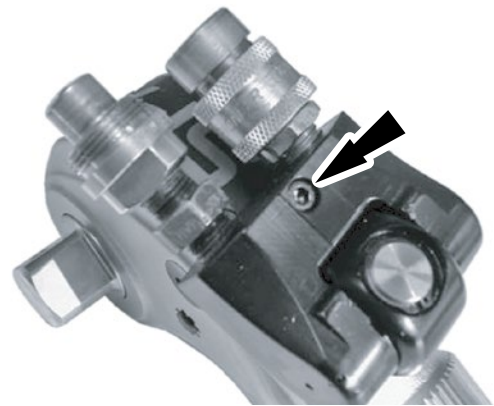
7. Test the operation of the torque wrench by connecting to the appropriate pump unit. Keeping hands clear of the wrench, advance and retract the wrench several times ensuring the drive mechanism functions correctly

Following stripdown and/or lubrication, the hydraulic torque wrench should be calibrated to verify that the torque output is within specification.

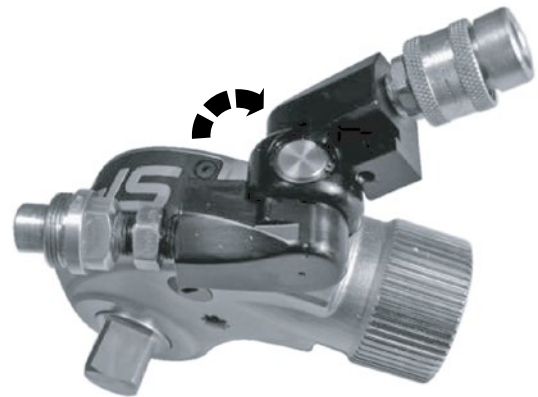
### Multiswivel Manifold Disassembly

The multiswivel manifold should only be removed for seal replacement or during full servicing.

1. Disconnect the hydraulic torque wrench from the power supply.
2. Attach open ended couplings to the swivel manifold couplings to vent any residual pressure.
3. See Figure 11. Remove the swivel yoke screw.
4. See Figure 12. Disengage the swivel yokes by rotating the advance yoke away from the retract yoke, disengaging the keyways.

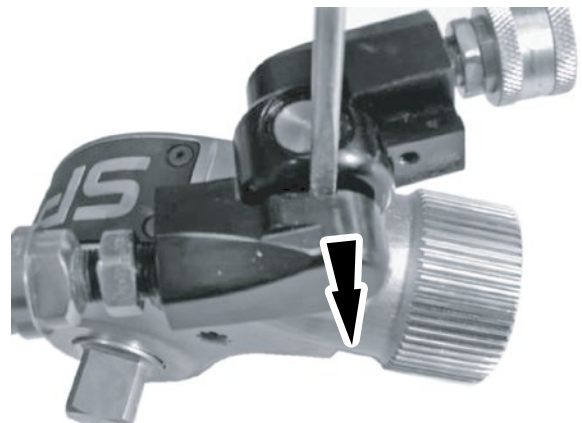


**Figure 11. Swivel Yoke Screw Removal**



**Figure 12. Swivel Yoke Disengagement**

5. See Figure 13. Pull each yoke away from the banjo, if necessary, a screwdriver can be inserted into the slot provided to lever the yoke. Remove and discard the yoke seals.



**Figure 13. Swivel Yoke Removal**



## Repair Procedures Continued

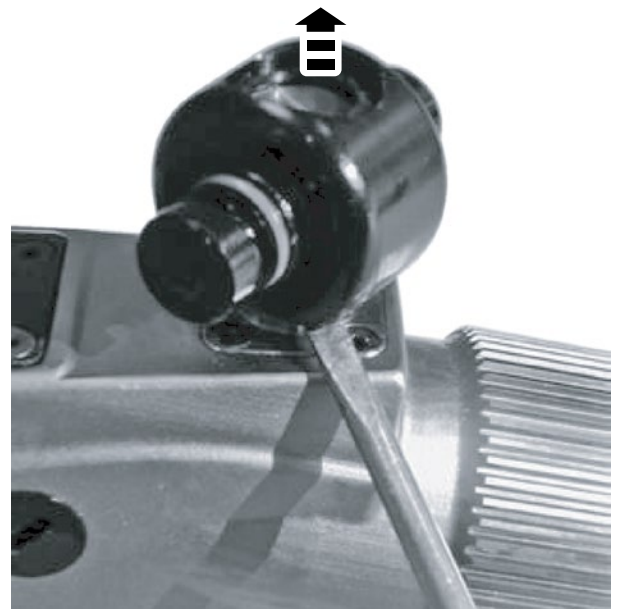
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6. See Figure 14. Remove the banjo circlip.



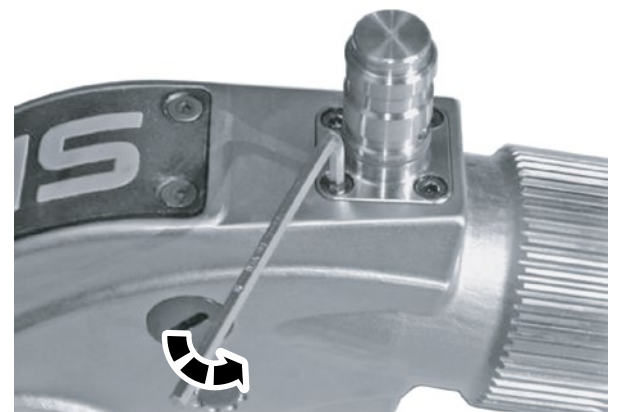
**Figure 14. Swivel Banjo Circlip Removal**

7. See Figure 15. Remove the banjo from the swivel post. Remove and discard the banjo seals.



**Figure 15. Swivel Banjo Removal**

8. See Figure 16. Unscrew and remove the four capscrews that attach the swivel post to the wrench body.



**Figure 16. Swivel Post Removal**



## Repair Procedures Continued

9. See Figure 17. Lift off the swivel post. Remove and discard the post and port seals.

Clean and inspect all components including the hydraulic couplings. If the hydraulic couplings are damaged, remove and replace (swivel yoke threads are  $\frac{1}{4}$ " NPT). Inspect the components for scoring, pitting and damage, which could impair the sealing ability and replace as necessary.

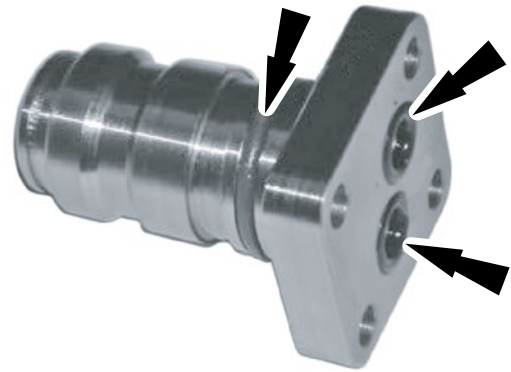
### Multiswivel Manifold Assembly

**NOTE: All seals should be new and lubricated with clean hydraulic oil or seal assembly paste before installation.**

1. Install the new port o-ring seals into the base of the swivel post.
2. Apply Loctite® 243 or equivalent to the four screws and attach the swivel post to the wrench body. Torque the screws as follows.
  - TWHC1 & 3 (M4) – 5.1 Nm (45 in-lb).
  - TWHC6, 11, 20, 35 & 50 (M5) – 10.2 Nm (90 in-lb).
3. Assemble a new o-ring seal to the swivel post.
4. Assemble four new o-ring seals to the banjo.
5. Carefully push the banjo onto the swivel post ensuring the seals do not get nipped.
6. Attach the banjo circlip to the post.
7. Assemble a new o-ring seal into the advance and retract yokes.
8. Assemble the advance and retract yokes to the banjo ensuring the seals do not get nipped.

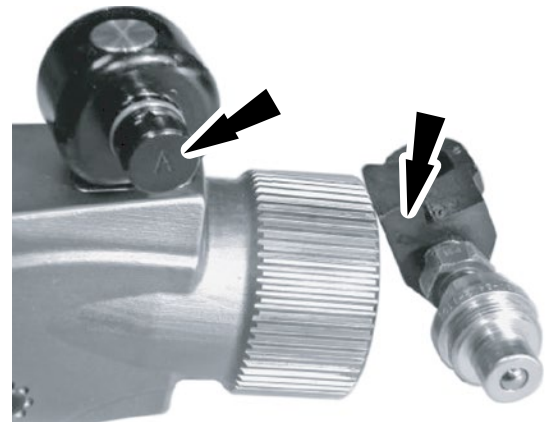
**IMPORTANT: See Figure 18. Ensure the advance and retract yokes are installed correctly onto the banjo. The banjo and advance yoke are engraved with A (advance) to indicate the correct position of the respective yoke. Reversal of the yokes will cause the torque wrench to malfunction and can lead to damage.**

9. Rotate the yokes around the banjo until the keyways engage.
10. Clamp the yokes together by installing the yoke screw and torquing to 5.1 Nm (45 lb-in).
11. Check the operation of the multiswivel manifold by rotating and tilting, movement should be free and smooth.



**Figure 17. Swivel Post Seals**

**NOTE: The swivel post on TWHC6 and larger sizes use 3 port seals.**



**Figure 18. Swivel Banjo/Yoke Identification**

## Repair Procedures Continued

12. Test the operation of the torque wrench by connecting to the appropriate pump unit. Keeping hands clear of the wrench, advance and retract the wrench several times ensuring the drive mechanism functions correctly. Apply full pressure to the wrench (690 bar/10,000 psi advance; 103 bar/1500 psi retract), and check for leaks.

**NOTE:** If the hydraulic couplings were removed, verify that they are installed into the correct yoke. The male coupling/nipple assembles into the advance yoke (A) and the female coupling assembles into the retract yoke (R). Apply hydraulic thread sealant to the hydraulic coupling thread before assembly. Thread sealing tape should not be used as debris from the sealing tape can contaminate the system.

### Hydraulic Cylinder Disassembly

It is only necessary to remove the hydraulic cylinder/body components if seal replacement is required.

1. Verify the torque wrench is fully retracted. Disconnect the power supply.
2. Attach open ended couplings to the swivel manifold couplings to vent any residual pressure.
3. See Figure 19. Unscrew the endcap using a pin spanner.
4. Remove the drive assembly as described in section 'Drive Component Disassembly'.
5. See Figure 20. The piston assembly can be withdrawn from the rear of the body by pushing the end of the piston rod.
6. Remove and discard the piston seal and the rod seal located in the centre of the body.

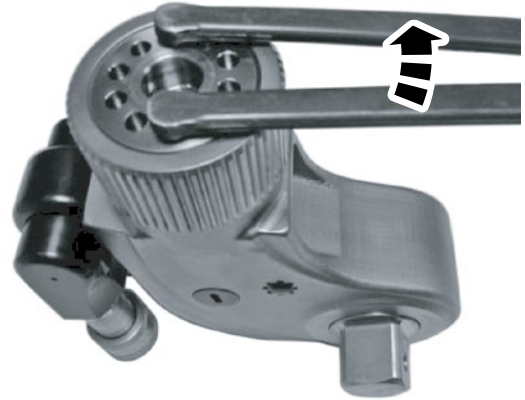


Figure 19. Endcap Removal



Figure 20. Piston Removal

## Repair Procedures Continued

7. See Figure 21. Clean and inspect the piston assembly for wear/damage. It is not necessary to remove the piston rod from the piston.
8. Clean and inspect the cylinder bore for scoring, pitting and damage that could impair the sealing ability and replace/repair as necessary.
9. Remove and discard the endcap seal. Clean and inspect the endcap ensuring the threads are checked for damage.



Item	Description
1	Seal
2	Piston
3	Piston Rod

**Figure 21. Piston Assembly**

### Hydraulic Cylinder/Body Assembly

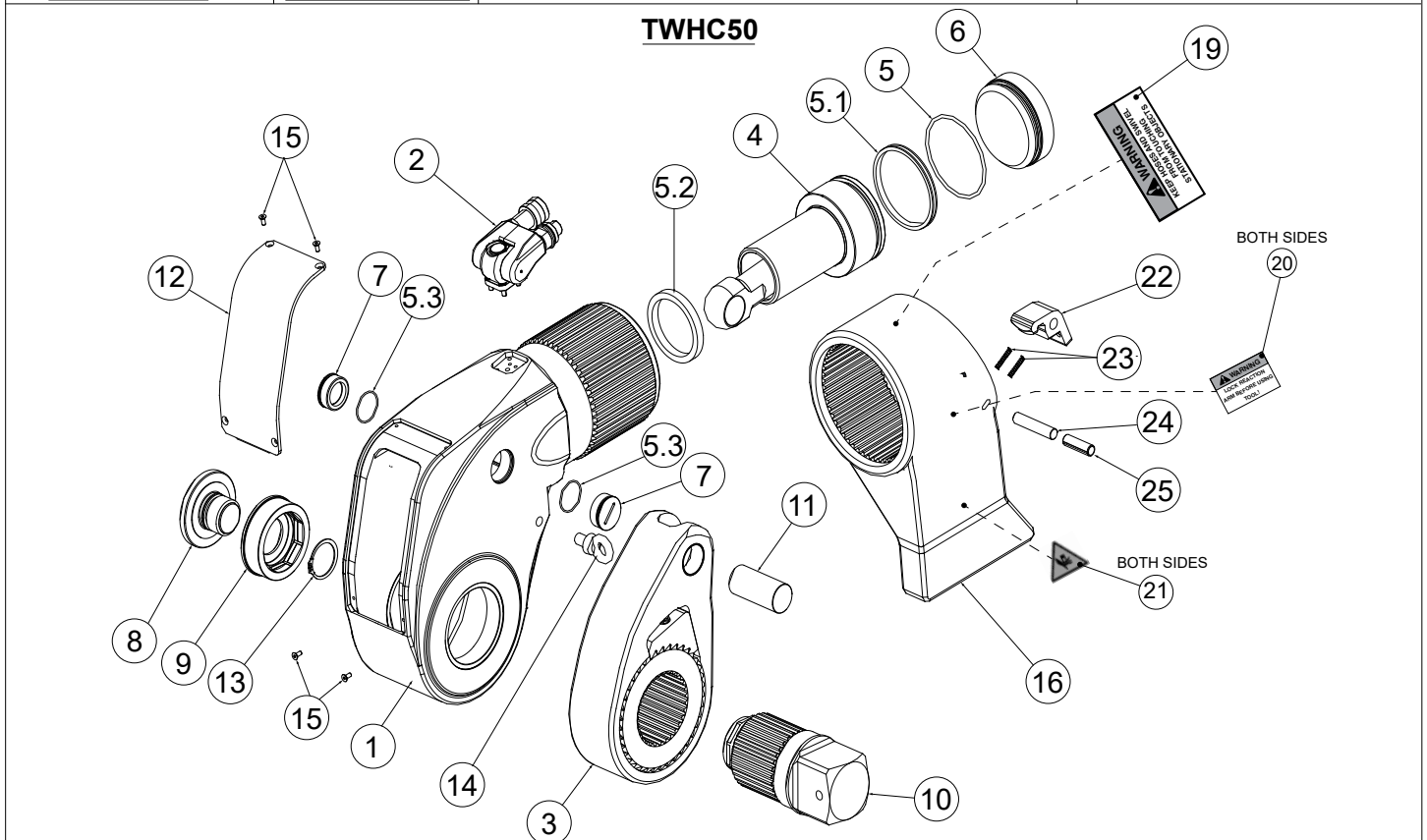
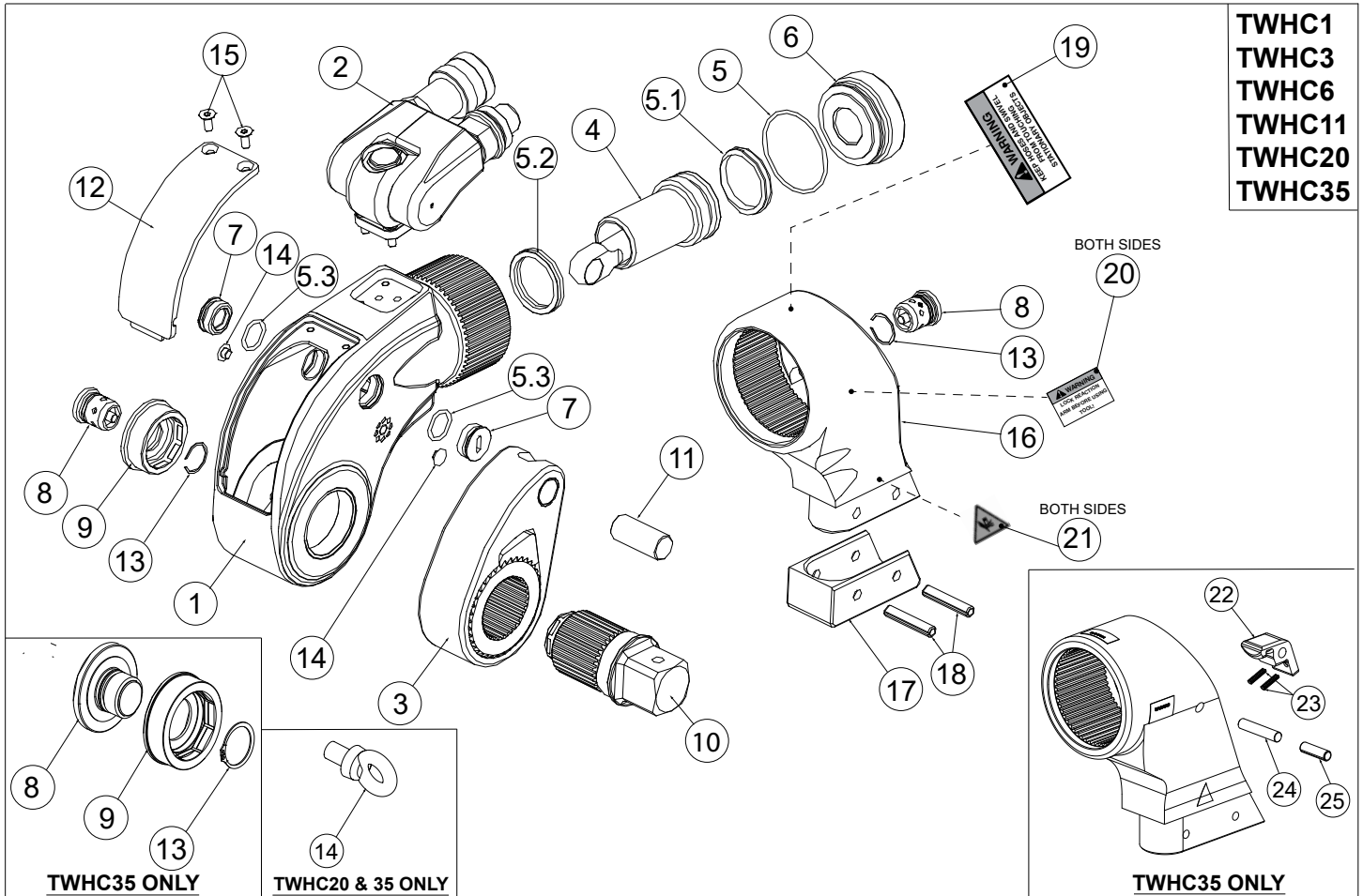
**NOTE: All seals should be new and lubricated with clean hydraulic oil or seal assembly paste before installation.**

1. Assemble a new rod seal into the body. Assemble a new piston seal onto the piston ensuring the seal backup ring scarfed joints are rotated 180° apart.
2. With the seals and bores coated in clean hydraulic oil, insert the piston into the body bore, guiding/aligning the piston through the rod seal during installation. Ensure the piston backup rings are not dislodged during installation.
3. Install a new o-ring seal onto the endcap and install it into the body. Tighten the endcap using a pin spanner.
4. Assemble the drive components as described in section 'Drive Component Assembly'.
5. Replace the guard.
6. Test the operation of the torque wrench by connecting to the appropriate pump unit. Keeping hands clear of the wrench, advance and retract the wrench several times ensuring the drive mechanism functions correctly. Apply full pressure to the wrench (690 bar/10,000 psi advance; 103 bar/1500 psi retract), and check for leaks.

Following stripdown and/or lubrication, the hydraulic torque wrench should be calibrated to verify that the torque output is within specification.

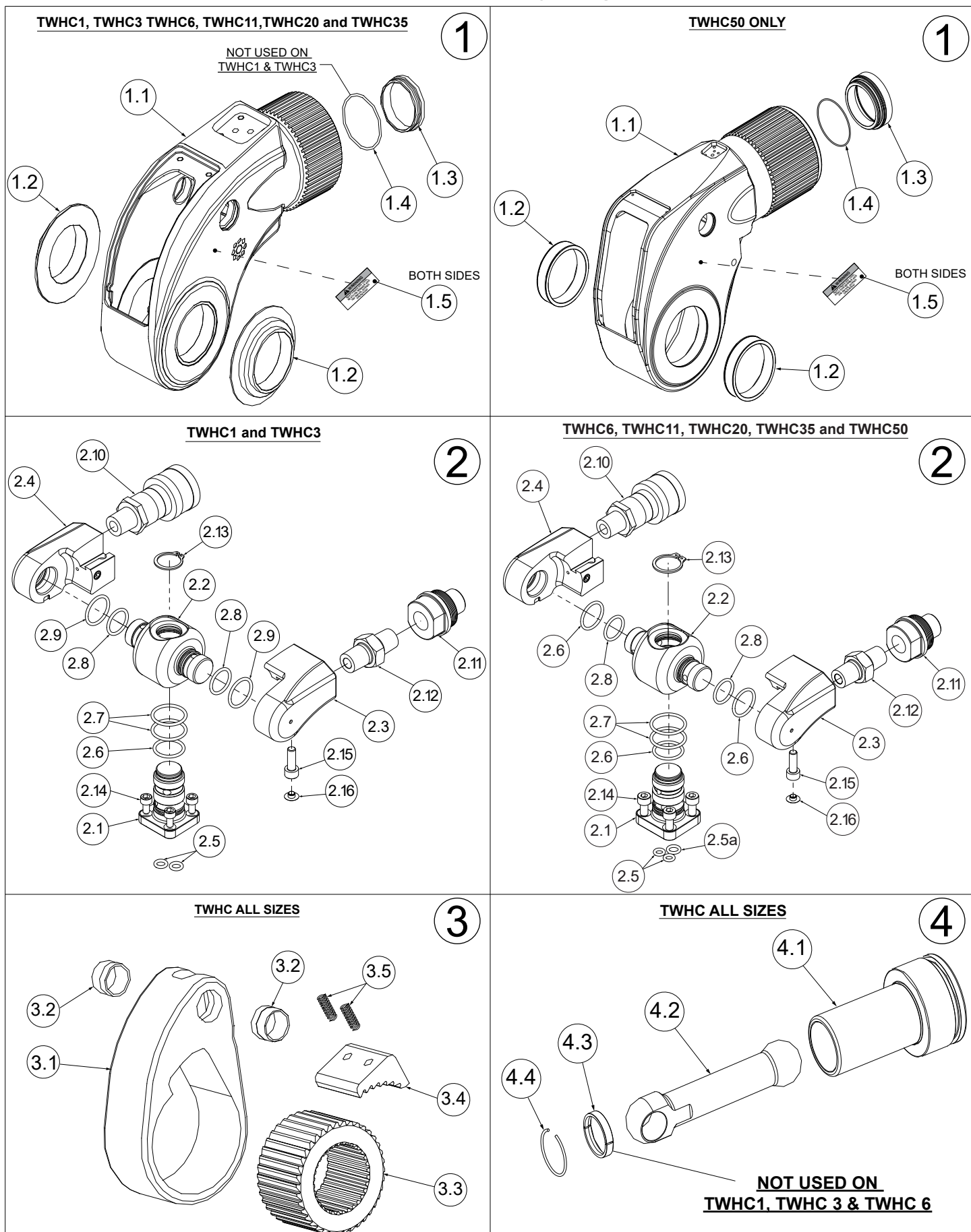
# PARTS LIST

## TWHC Final Assembly Diagrams



# Parts List Continued

## TWHC Subassembly Diagrams



## Parts List Continued

### TWHC1 to TWHC6 Parts Table

ITEM NO.	PART NO.			DESCRIPTION	QTY.
	TWHC1	TWHC3	TWHC6		
1	TWHCAS010003	TWHCAS030003	TWHCAS060003	TWHC Body Assembly	1
1.1	TWHCBD010001	TWHCBD030001	TWHCBD060001	TWHC Body	1
1.2	TWHCSJ010001	TWHCSJ030001	TWHCSJ060001	TWHC Sideplate Journal	2
1.3	TWHCBB010001	TWHCBB030001	TWHCBB060001	TWHC Body Bushing	1
1.4	NONE		STDSE000006	Seal	1
1.5	1000082			Decal, Warning	2
2	TWHCAS010008		TWHCAS020001	TWHC Multiswivel Manifold Assembly	1
2.1	TWHCSP010001		TWHCSP020001	TWHC Swivel Post	1
2.2	TWHCSB010001		TWHCSB020001	TWHC Swivel Banjo	1
2.3	TWHCAY010001		TWHCAY020001	TWHC Swivel Advance Yoke	1
2.4	TWHCAS010009		TWHCAS020002	TWHC Swivel Retract Yoke	1
2.5	Multiswivel Seal Kit TWHCAS010010		Multiswivel Seal Kit TWHCAS020003	O-Ring (0.20ID X .07CS (NBR); TWHC1,3) (0.17ID X .07CS (NBR); TWHC6)	2
2.5a				O-Ring (0.23ID X .07CS (NBR); TWHC6)	1
2.6				O-Ring (0.61ID X .07CS (PU); TWHC1,3) (0.67ID X .07CS (PU); TWHC6) (* TWHCAS020003 uses 3 seals)	1*
2.7				O-Ring (0.73ID X .07CS (PU); TWHC1,3) (0.80ID X .07CS (PU); TWHC6)	2
2.8				O-Ring (0.55ID X .07CS (PU); TWHC1,3,6)	2
2.9				O-Ring (0.67ID X .07CS (PU); TWHC1,3)	2
2.10	251410			Female Coupling	1
2.11	251411			Male Coupling	1
2.12	INTHC000002		INTHC000002	Adapter	1
2.13	STDRC000057		STDRC000057	Clip	1
2.14	STDFA000025		STDFA000025	Screw	4
2.15	STDFA000027		STDFA000027	Screw	1
2.16	STDST000078		STDST000078	Cap	1
3	TWHCAS010005	TWHCAS030005	TWHCAS060005	TWHC Drive Assembly	1
3.1	TWHCCR010001	TWHCCR030001	TWHCCR060001	Crank	1
3.2	TWHCCB010001	TWHCCB030001	TWHCCB060001	Crank Bearing	2



## Parts List Continued

ITEM NO.	PART NO.			DESCRIPTION	QTY.
	TWHC1	TWHC3	TWHC6		
3.3	TWHCRT010001	TWHCRT030001	TWHCRT060001	Ratchet	1
3.4	TWHCDS010001	TWHCDS030001	TWHCDS060001	Drive Shoe	1
3.5	STDST000105	STDST000106	STDST000107	Spring	2
4	TWHCAS010004	TWHCAS030004	TWHCAS060004	TWHC Piston Assembly	1
4.1	TWHCPI010001	TWHCPI030001	TWHCPI060001	Piston	1
4.2	TWHCPR010001	TWHCPR030001	TWHCPR060001	Piston Rod	1
4.3	NONE			Retainer Cup/Piston Collar	1
4.4	STDRC000061	STDRC000062	STDRC000063	Clip (Spring Clip on TWHC11,20,35)	1
5	Body Seal Kit TWHCAS010007	Body Seal Kit TWHCAS030007	Body Seal Kit TWHCAS060007	O-Ring (1.23ID X .07CS (PU); TWHC1) (1.61ID X .07CS (PU); TWHC3) (1.92ID X .10CS (PU); TWHC6)	1
5.1				Piston T seal	1
5.2				Seal	1
5.3				O-Ring (0.43ID X .07CS (NBR); TWHC1) (0.55ID X .07CS (NBR); TWHC3) (0.73ID X .07CS (NBR); TWHC6)	2
6	TWHCEC010001	TWHCEC030001	TWHCEC060001	TWHC End Cap	1
7	TWHCBP010001	TWHCBP030001	TWHCBP060001	TWHC Body Plug	2
8	BSDAS010008		BSDAS060008	TWHC Lock Button Assembly	2
9	TWHCSC010002	TWHCSC030002	TWHCSC060002	TWHC Square Drive Cap	1
10	TWHCSD010003	TWHCSD030003	TWHCSD060002	TWHC Square Drive	1
11	TWHCCP010001	TWHCCP030001	TWHCCP060001	TWHC Crank Pin	1
12	TWHCGD010001	TWHCGD030001	TWHCGD060001	TWHC Guard	1
13	STDRC000030		STDRC000031	Clip	2
14	STDST000079		STDST000109	Cap	2
15	STDFA000156			Screw	2
16	TWHCRA010001	TWHCRA030001	TWHCRA060001	TWHC Reaction Arm	1
17	TWHCAP010001	TWHCAP030001	TWHCAP060001	TWHC Reaction Arm Pad	1
18	STDST000098	STDST000104	STDST000034	Pin	2
19	1000079			Decal, Warning	1
20	1000083			Decal, Warning	2
21	251057			Decal, Pinch Point	2

## Parts List Continued

### TWHC11 to TWHC50 Parts Table

ITEM NO.	PART NO.				DESCRIPTION	QTY.
	TWHC11	TWHC20	TWHC35	TWHC50		
1	TWHCAS110003	TWHCAS200003	TWHCAS350003	TWHCAS500003	TWHC Body Assembly	1
1.1	TWHCBD110001	TWHCBD200001	TWHCBD350001	TWHCBD500001	TWHC Body	1
1.2	TWHCSJ110001	TWHCSJ200001	TWHCSJ350001	TWHCSJ500001	TWHC Sideplate Journal	2
1.3	TWHCBB110001	TWHCBB200001	TWHCBB350001	TWHCBB500001	TWHC Body Bushing	1
1.4	STDSE000079	2010694	2010661	STDSE000097	Seal	1
1.5	1000082				Decal, Warning	2
2	TWHCAS020001				TWHC Multiswivel Manifold Assembly	1
2.1	TWHCSP020001				TWHC Swivel Post	1
2.2	TWHCSB020001				TWHC Swivel Banjo	1
2.3	TWHCAY020001				TWHC Swivel Advance Yoke	1
2.4	TWHCAS020002				TWHC Swivel Retract Yoke	1
2.5	Multiswivel Seal Kit TWHCAS020003				O-Ring (0.17ID X .07CS; NBR)	2
2.5a					O-Ring (0.23ID X .07CS; NBR)	1
2.6					O-Ring (0.67ID X .07CS; PU)	3
2.7					O-Ring (0.80ID X .07CS; PU)	2
2.8					O-Ring (0.55ID X .07CS; PU)	2
2.10	251410				Female Coupling	1
2.11	251411				Male Coupling	1
2.12	INTHC000002				Adapter	1
2.13	STDRC000064				Clip	1
2.14	STDFA000157				Screw	4
2.15	STDFA000027				Screw	1
2.16	STDST000078				Cap	1
3	TWHCAS110005	TWHCAS200005	TWHCAS350005	TWHCAS500005	TWHC Drive Assembly	1
3.1	TWHCCR110001	TWHCCR200001	TWHCCR350001	TWHCCR500001	Crank	1
3.2	TWHCCB110001	TWHCCB200001	TWHCCB350001	TWHCCB500001	Crank Bearing	2
3.3	TWHCRT110001	TWHCRT200001	TWHCRT350001	TWHCRT500001	Ratchet	1



## Parts List Continued

ITEM NO.	PART NO.				DESCRIPTION	QTY.
	TWHC11	TWHC20	TWHC35	TWHC50		
3.4	TWHCDS110001	TWHCDS200001	TWHCDS350001	TWHCDS500001	Drive Shoe	1
3.5	STDST000020	STDST000020	2010668	STDST000118	Spring	2
4	TWHCAS110004	TWHCAS200004	TWHCAS350004	TWHCAS500004	TWHC Piston Assembly	1
4.1	TWHCPI110001	TWHCPI200001	TWHCPI350001	TWHCPI500001	Piston	1
4.2	TWHCPR110001	TWHCPR200001	TWHCPR350001	TWHCPR500001	Piston Rod	1
4.3	TWHCRC110001	TWHCRC200001	TWHCRC350001	TWHCPC500001	Retainer Cup/Piston Collar	1
4.4	2010636*	2010691*	2010697*	STDRC000069	Clip (*Spring Clip on TWHC11, 20, 35)	1
5	Body Seal Kit TWHCAS110007	Body Seal Kit TWHCAS200007	Body Seal Kit TWHCAS350007	Body Seal Kit TWHCAS500007	O-Ring (2.36ID X .07CS (PU); TWHC11) (2.67ID X .10CS (PU); TWHC20) (3.10ID X .13CS (PU); TWHC35) (3.48ID X .13CS (PU); TWHC50)	1
5.1					Piston T seal	1
5.2					Seal	1
5.3					O-Ring (0.80ID X .07CS (NBR); TWHC11) (1.11ID X .10CS (NBR); TWHC20) (1.05ID X .07CS (NBR); TWHC35) (1.23ID X .07CS (NBR); TWHC50)	2
6	BSDEC110001	TWHCEC200001	TWHCEC350001	TWHCEC500001	TWHC End Cap	1
7	TWHCBP110001	TWHCBP200001	TWHCBP350001	TWHCBP500001	TWHC Body Plug	2
8	BSDAS110008	BSDAS250008	TWHCSS500002*	TWHCSS500002*	TWHC Lock Button Assy (* 1 Screw on 35 & 50)	2*
9	TWHCSC110001	TWHCSC200001	TWHCSC350001	TWHCSC500002	TWHC Square Drive Cap	1
10	TWHCSD110001	TWHCSD200001	TWHCSD350001	TWHCSD500002	TWHC Square Drive	1
11	TWHCCP110001	TWHCCP200001	TWHCCP350001	TWHCCP500001	TWHC Crank Pin	1
12	TWHCGD110001	TWHCGD200001	TWHCGD350001	TWHCGD500001	TWHC Guard	1
13	STDRC000032	STDRC000033	STDRC000077	STDRC000077	Clip (* 1 clip on 35 & 50)	2*

## Parts List Continued

ITEM NO.	PART NO.				DESCRIPTION	QTY.
	TWHC11	TWHC20	TWHC35	TWHC50		
14	STDST000109	STDFA000075*	STDFA000075*	STDFA000075*	Cap (* 1 Lift Eye on TWHC20, 35, & 50)	2*
15	STDFA000013	2010456	2010456	STDFA000156*	Screw (* TWHC50 uses 4 screws)	2*
16	TWHCRA110001	TWHCRA200001	TWHCRA350001	TWHCRA500001	TWHC Reaction Arm	1
17	BSDAP110001	BSDAP250001	TWHCAP350001	NONE	TWHC Reaction Arm Pad	1
18	STDST000035	STDST000036	2010704	NONE	Pin	2
19	1000079				Decal, Warning	1
20	1000083				Decal, Warning	2
21	251057				Decal, Pinch Point	2
22	NONE		TWHCRL350001	TWHCRL500001	TWHC Reaction Arm Latch	1
23	NONE		STDST000119	STDST000119	Spring	2
24	NONE		STDST000122	STDST000122	Pin	1
25	NONE		STDST000121	STDST000121	Pin	1

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## EC DECLARATION OF CONFORMITY

We declare under our sole responsibility that our High Cycle Torque Wrench Model:

**\* TWHC series**

to which this declaration relates are in conformity with the following:

<u>EN, EN-ISO, ISO standards</u>	<u>Title</u>
<b>Per the provisions of the Machinery Safety Directive</b>	<b>2006/42 EC</b>
EN_ISO 12100	Safety of machinery, basic concepts, general principles for design, risk assessment & risk reduction
EN 4413	Hydraulic Fluid Power – general rules and safety requirements for systems & their components

We hereby declare that the equipment specified under \* conforms to the above quoted European Community Directive(s) and Standard(s) as per the currently valid revision. SPX Hydraulic Technologies is certified and registered to ISO 9001: 2015.

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The Netherlands

The Netherlands August 16<sup>th</sup>, 2022



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Andreas J. Klemm, PhD

## UKCA DECLARATION OF CONFORMITY

We declare under our sole responsibility that our High Cycle Torque Wrench Model:

**\* TWHC series**

to which this declaration relates are in conformity with the following:

### EN, EN-ISO, ISO standards

### Title

#### **The Supply of Machinery (Safety) Regulations 2008 No. 1597 and amendments**

EN\_ISO 12100

Safety of machinery, basic concepts, general principles for design, risk assessment & risk reduction

EN 4413

Hydraulic Fluid Power – general rules and safety requirements for systems & their components

We hereby declare that the equipment specified under \* conforms to the above quoted UK Legislation and International Standard(s) as per the currently valid revision.  
SPX FLOW Europe Ltd. - Netherlands is certified and registered to ISO 9001: 2015.

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