Mechanical Setup Procedure for the ST-120

1. Lower the table assembly and release the clamp and platform adjustment knobs and handles.

2. Place the container (with the closure tightened on it) on the platform.

3. Manually raise/lower the platform until the platform height is such that the container fits snugly in the left clamp. (It is recommended to clamp the container as close to the container neck as it is possible without interference from the collet.).

4. Tighten the platform adjustment knobs, and document the platform height setting.

5. Go into the MANUAL MODE of the HMI, and raise the table assembly by actuating both the high and the low pressure cylinders (use the HEAD and CAL buttons to actuate).

6. Mechanically adjust the height of the table assembly until the closure is up in the collet, then finetune the topload force by minor height adjustments of the table. When finished, tighten the table adjustment handle, and document the table height setting.

7. Actuate the collet by pressing the CHUCK button on the HMI. This will center the container on the platform.

8. Manually slide in the left side clamp - snug to the container - tighten the left clamp adjustment handle and document the left clamp position.

9. Actuate the right clamp by pressing the CLAMP button, then slide in the right clamp snugly to the container. Ensure that the bottle can not be manually rotated while it is clamped, otherwise the torque test may give a false readout, when the container slips in the clamps. Document the right clamp settings.

10. Ensure the container is centered properly, so press the CHUCK button, lower the table assembly by pressing both the HEAD and CAL, then raise the platform back into the upper position by pressing the HEAD and CAL buttons again. The cap must not hit the opening of the collet, otherwise the rubber insert in the collet, or the product itself could be damaged.

11. The machine is mechanically setup for the package, make sure every adjustment knobs and handles are tight and your final settings are documented.

12. If everything operates smoothly, escape the MANUAL MODE of the HMI and proceed to the TEST MODE.

Please find the General Arrangement of the ST-120 torque tester on the next page.

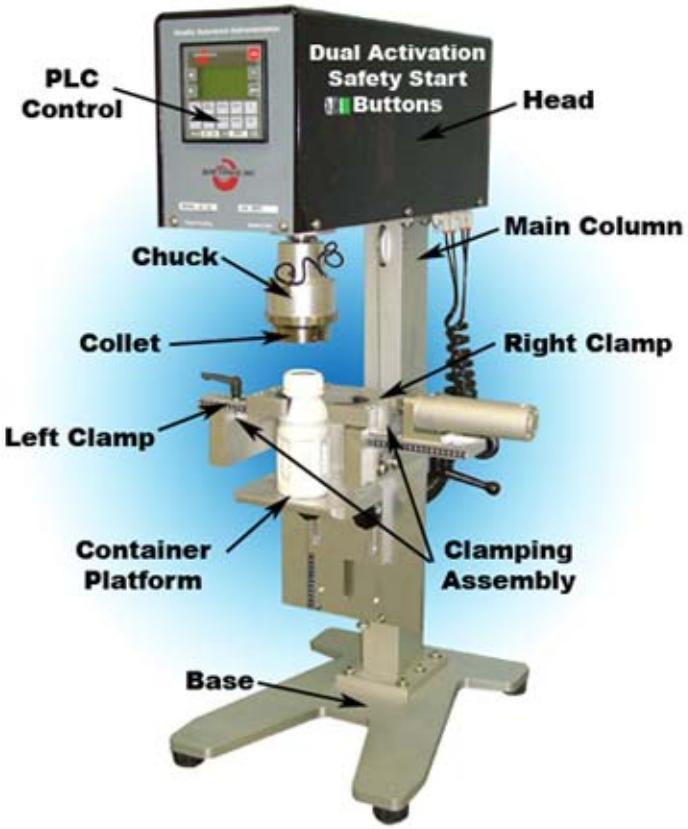

Figure 1, ST-120 Torque Tester General Arrangement.

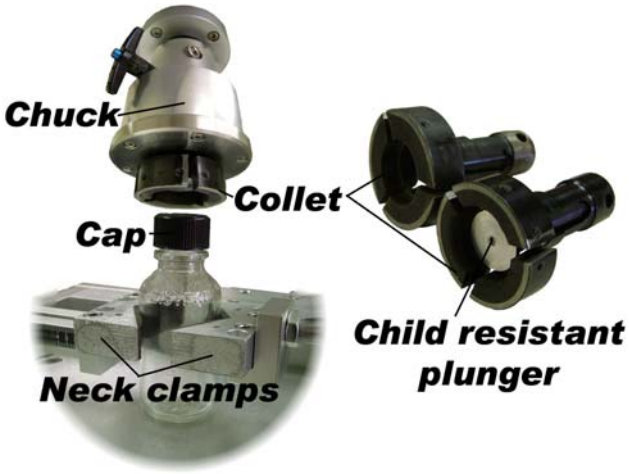

Figure 2, ST-120 Torque Tester Mechanical Components (Chuck Assembly).