



Screwdriving technology

Automation

Air motors

Air tools

DEPRAG

MEASURING
TECHNOLOGY

Torque Transducers

Transducers, measurement platforms and measurement wrenches

- highly accurate measurements
- wide measurement range
- in-process control with the torque transducer

The selection of a suitable torque transducer is a basic requirement for the adjustment, monitoring and inspection of screwdrivers, and also for the testing of screw joints and screw joint analysis.



Examples for the use of the most suitable measurement device for processing reliability requirements

Example 1:

An operator always assembles the same type of screw using a DEPRAG pneumatic screwdriver. Through the driver shut-off when the preset torque is reached, the assembly is controlled and assured to be accurate. In certain intervals, the screwdrivers are cross-checked using torque-transducers and if deviations occur, re-adjustments can be made. Measurement platforms which are intended for stationary use in a measurement laboratory or on a mobile measurement station are suitable for this test.

Example 2:

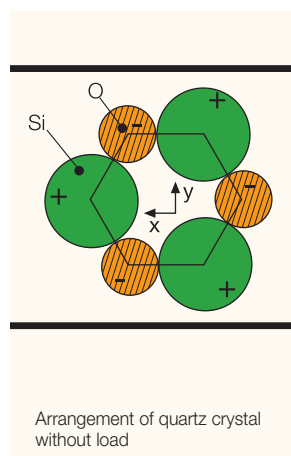
In a fully automatic assembly station, the regular testing of stationary screwdrivers is necessary. The DEPRAG torque wrenches in straight and angle-design, allow the mobile use when testing screwdriver-spindles without their removal from an assembly station.

The torque-wrenches can also be used for the re-tightening or loosening of already assembled fastener.

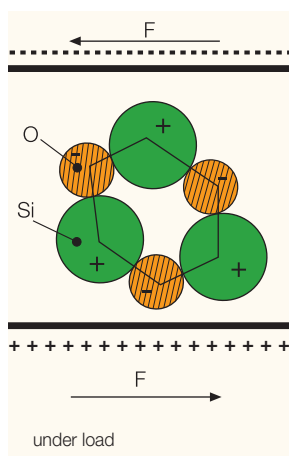
Example 3:

Transducers measure the torque directly on the component. When connected to a DEPRAG measuring instrument, this transducers are ideal for torque acquisition and screw joint analysis and are an important component for the optimum quality assurance.

Physical principles

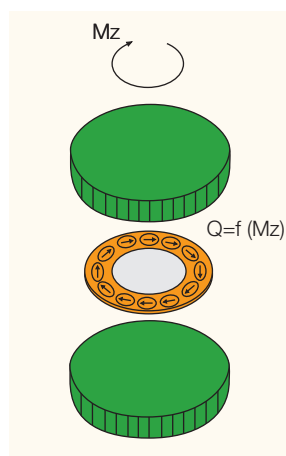


Arrangement of quartz crystal without load



under load

Function principle of the piezoelectric transducers



Torque transducers vary widely in operation and appearance, and work on many different physical principles. The most common of these are:

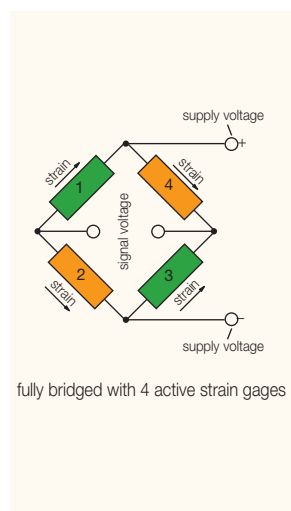
a strain gage wrapped around a torsion bar, an eddy current transducer, a mechanical (spring or hydraulic) element, and a piezoelectric crystal.

To be effective, the torque transducer must have the following attributes. It must support a sampling rate that will allow the measurement of rapidly changing loads, it must be sufficiently stiff to withstand the peak load, it must have a high degree of linearity, it must be stable under varying environmental conditions, and it must have a good operating lifetime.

DEPRAG offers torque transducers that work on two different physical principles, both meeting these requirements.

- PE (Piezo Electric) Transducer
- DMS (Strain Gage) Transducer

When connected to the correct measuring instrument, each type of torque transducer has applications in the screwdriving technology. The familiar DEPRAG piezo-electric transducer offers a large measuring range and a robust design. For less demanding applications, the strain gage transducer offers an economical alternative.

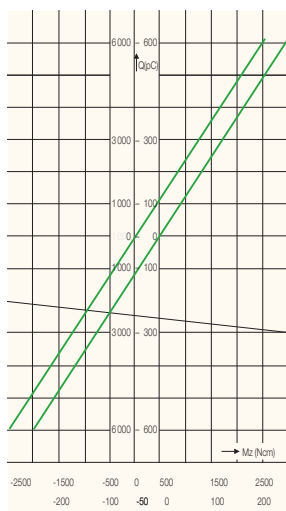


fully bridged with 4 active strain gages



standard design of a strain gage

Function principle of the strain gage transducers



Linearity diagram

Torque transducers are available as stationary platforms as well as in portable version of straight and angular torque wrenches. Depending on piezo-electric, strain gage or non-contact version the transducers are built to be connected to the relative electronic torque meters (see brochure D 3022 E).



V002-E6.3/F6.3
to
V020-E6.3/F6.3

TECHNICAL DATA

Transducer (DMS, non-contact)

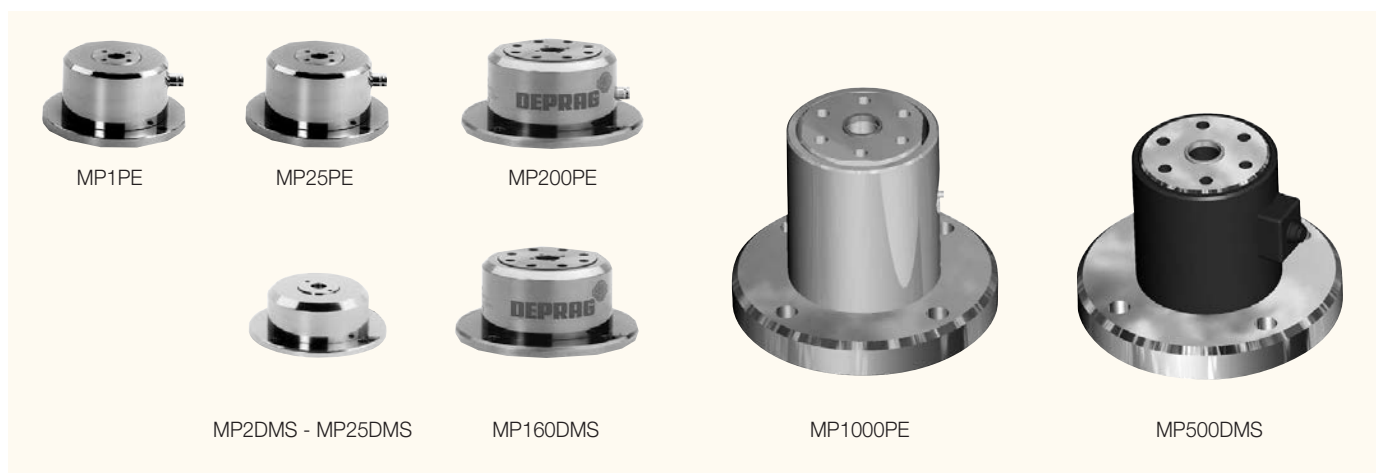
	Type Part no.	V002-E6.3/F6.3 385481 B	V005-E6.3/F6.3 385481 C	V010-E6.3/F6.3 385481 D	V020-E6.3/F6.3 385481 E
Calibrated measuring range	Nm	0.2 - 2	0.5 - 5	1 - 10	2 - 20
	in.lbs	2 - 18	4 - 40	9 - 88	18 - 177
Permissible overload	%	100	100	100	30
Speed max.	rpm	10,000	10,000	10,000	10,000
Weight approx.	kg / lbs	0.3 / 0.66	0.3 / 0.66	0.3 / 0.66	0.3 / 0.66

Required Accessories

Measuring Instrument	Type ME 5000, ME 5400, ME 5600 or type ME 6000 (see brochure D 3022 E)	
Connector Cable (for transducer to measuring instrument ME 5...) Length 2 m / 4 m / 6 m 6.6' / 13' / 20'	Part no.	385486 A / B / C
Power Supply for transducer connected to measuring instrument ME 5000	Part no.	800827
Power Supply Cable 220 V / 110 V	Part no.	812587 / 812295

When connected to a DEPRAG measuring instrument, this transducer is ideal for torque acquisition and documentation of all acquired results of screw joints and assembly requirements.

During the actual assembly process, performing torque acquisition and screw-joint analysis is possible. This feature fulfills most or all assembly-process requirements and assures even the highest quality demands.



TECHNICAL DATA

Piezoelectric (PE) transducers: measuring platforms

	Type	MP 1 PE		MP 25 PE	MP 200 PE	MP 1000 PE
	Part no.	408000 C		360850 A	373205 A	408000 A
Calibrated measuring range *)	Nm	0.1 - 1		2.5 - 25	20 - 200	50 - 500
	in.lbs	0.88 - 8.85		22.12 - 221.25	177-1770	442.5 - 4425
Permissible overload	%	20		20	20	20
Sensibility	pC / Ncm	21.7		2.4	1.7	1.0
Frequency response	kHz	> 53		approx. 15	approx. 3.5	approx. 11
Linearity	≤ %	± 0.2		± 1	± 1	± 0.5
Diameter D	mm / in.	109.5 / 4.3		105 / 4 1/8	140 / 5 1/2	200 / 7 7/8
Weight	kg / lbs	1.3 / 2.9		1.3 / 2.9	3.5 / 7.7	16 / 35.2
Connecting plug	type	BNC, neg.		BNC, neg.	BNC, neg.	10-32 UNF neg.

Strain gage (DMS) transducers: measuring platforms

	Type	MP 2 DMS	MP 7 DMS	MP 25 DMS	MP 160 DMS	MP 500 DMS
	Part no.	385200 B	385200 A	385200 C	385200 D	408088 A
Calibrated measuring range *)	Nm	0.2 - 2	1.05 - 7	2.5 - 25	16 - 160	50 - 500
	in.lbs	1.77 - 17.7	9.29 - 61.95	22.12 - 221.25	141.6 - 1416	442.5 - 4425
Permissible overload	%	20	20	20	20	20
Accuracy class		1	1	1	1	1
Sensibility	mV/V	1.5	1.8	1.8	1.8	—
Operational temperature range	°C	0 to + 60	0 to + 60	0 to + 60	0 to + 60	0 to + 60
	°F	32 to 140	32 to 140	32 to 140	32 to 140	32 to 140
Parameter temperature coefficient	% / K	0.01	0.01	0.01	0.01	0.01
Zero signal temperature coefficient	% / K	0.02	0.02	0.02	0.02	0.02
Supply voltage (DC)	V	5	5	5	5	12
Diameter D	mm / in.	105 / 4 1/8	105 / 4 1/8	105 / 4 1/8	140 / 5 1/8	229 / 9 1/64
Weight	kg / lbs	1 / 2.2	1 / 2.2	1 / 2.2	2 / 4.4	18 / 39.6
Connecting plug		4-pole	4-pole	4-pole	4-pole	12-pole

*) Calibrated measuring range (standard calibration - part no. 3855285 – included in delivery) according to VDI/VDE2646, optional calibration, see page 7.
Calibrations for other measuring ranges upon request!

Required Accessories:

Measuring Instrument (see brochure D 3022 E).
Connection Cable and **Screwplates** see page 6.

The measuring platforms are well suited for the installation into a calibration laboratory, as well as for the construction of a mobile measuring waggon. The robust and sturdy platform design guarantees permanent high measuring accuracies. As an optional accessory, we offer a clamping plate, which allows the temporary fasten-

ing of the platform into a vice. For specially high accuracy demands, or for the obtaining of extremely small torque values, we recommend to mount the platform with its polished lower surface to a table top, which has been treated in a similar fashion.

Because of such an extreme high grade installation, even the smallest measuring-errors, created by lateral force, deflection, vibration, or misalignment, can be completely avoided.

To ensure optimal measurement conditions we offer screwdriver adapters in combination with linear stands or parallelogram arms (see brochure D 3340 E).



MS 25 PE-W



MS 2 DMS
MS 7 DMS



MS 7 DMS-W
MS 25 DMS-W

TECHNICAL DATA

Piezoelectric (PE) transducer: E-torque wrench

	Type			MS 25 PE-W	MS 25 PE-WS
	Part no.			346217 A	346217 C
Calibrated measuring range *)	Nm			2.5 - 25	2.5 - 25
	in.lbs			22.12 - 221.25	22.12 - 221.25
Permissible overload	%			20	20
Sensibility	pC / Ncm			2.4	2.4
Frequency response	kHz			approx. 15	approx. 15
Linearity	≤ %			± 1	± 1
Length L	mm / in.			442 / 17 ¹³ / ₃₂	297 / 11 ¹¹ / ₁₆
Weight	kg / lbs			1.1 / 2.4	0.9 / 1.98
Connecting plug	type			BNC, neg.	BNC, neg.

Strain gage (DMS) transducers: E-torque wrench

	Type	MS 2 DMS	MS 7 DMS	MS 7 DMS-W	MS 25 DMS-W
	Part no.	387798 B	387798 A	388050 A	388050 C
Calibrated measuring range *)	Nm	0.2 - 2	1.05 - 7	1.05 - 7	2.5 - 25
	in.lbs	1.77 - 17.7	9.29 - 61.95	9.29 - 61.95	22.12 - 221.25
Permissible overload	%	20	20	20	20
Accuracy class		1	1	1	1
Sensibility	mV/V	1.5	1.8	1.8	1.8
Operational temperature range	°C	0 to + 60	0 to + 60	0 to + 60	0 to + 60
	°F	32 to 140	32 to 140	32 to 140	32 to 140
Parameter temperature coefficient	% / K	0.01	0.01	0.01	0.01
Zero signal temperature coefficient	% / K	0.02	0.02	0.02	0.02
Supply voltage (DC)	V	5	5	5	5
Length L	mm / in.	186 / 7 ⁵ / ₁₆	186 / 7 ⁵ / ₁₆	268 / 10 ⁹ / ₁₆	423 / 16 ⁵ / ₈
Weight	kg / lbs	0.5 / 1.1	0.5 / 1.1	0.5 / 1.1	0.7 / 1.5
Connecting plug		4-pole	4-pole	4-pole	4-pole

*) Calibrated measuring range (standard calibration - part no. 3855285 – included in delivery) according to VDI/VDE2646, optional calibration, see page 7.
Calibrations for other measuring ranges upon request!

Required Accessories:

Measuring Instrument (see brochure D 3022 E).
Connection Cable and **Screwplates** see page 6.

The E-torque wrenches allow the testing of screwdriver spindles without their removal from an assembly station.

In connection with the corresponding torque measuring instrument, the E-torque wrenches can also be used for the testing of a screw connection already, by either tightening or loosening the connection.

The E-torque wrench combines the application variety of conventional torque wrenches with the precision and the possibilities of up-to-date electronic torque measurement.

Required Accessories on special request

For Piezoelectric (PE) transducers: measuring platforms			Type	MP1PE			MP25PE	MP200PE	MP1000PE
For Piezoelectric (PE) transducer: E-torque wrench			Type				MS25PE-W(S)		
Connection cable to measuring instrument	5 m/16.4 ft.	Part no.		810675			810675	810675	
Connection cable to measuring instrument	1 m/3.3 ft.	Part no.							810629
For Strain gage (DMS) transducers: measuring platforms			Type		MP2DMS	MP7DMS	MP25DMS	MP160DMS	MP500DMS
For Strain gage (DMS) transducers: E-torque wrenches, angle head design			Type			MS7DMS-W	MS25DMS-W		
For Strain gage (DMS) transducers: E-torque wrenches, straight design			Type		MS2DMS	MS7DMS			
Connection cable to measuring instrument	2 m/ 6.6 ft.	Part no.			385493 A	385493 A	385493 A	385493 A	385486 A
Connection cable to measuring instrument	4 m/13.2 ft.	Part no.			385493 B	385493 B	385493 B	385493 B	385486 B
Connection cable to measuring instrument	6 m/19.8 ft.	Part no.			385493 C	385493 C	385493 C	385493 C	385486 C
Screwplate M1.6: 0.8-2 Ncm	right	Part no.		120422 A					
(for above allen bit AF1.5)	left	Part no.							
Screwplate M1.6: 2-6 Ncm	right	Part no.		120422 B					
(for above allen bit AF1.5)	left	Part no.							
Screwplate M2.5: 6-16 Ncm	right	Part no.		120424 A					
(for above allen bit AF2)	left	Part no.							
Screwplate M2.5: 16-40 Ncm	right	Part no.		120424 B					
(for above allen bit AF2)	left	Part no.							
Screwplate M4: 40-100 Ncm	right	Part no.		120426 E					
(for above allen bit AF3)	left	Part no.							
Screwplate M1.6: 0.06-0.12 Nm	right	Part no.			120571 A	120571 A	120571 A		
(for above allen bit AF1.5)	left	Part no.							
Screwplate M2: 0.12-0.25 Nm	right	Part no.			120572 A	120572 A	120572 A		
(for above allen bit AF1.5)	left	Part no.			120572 B	120572 B	120572 B		
Screwplate M2.5: 0.25-0.5 Nm	right	Part no.			120573 A	120573 A	120573 A		
(for above allen bit AF2)	left	Part no.			120573 B	120573 B	120573 B		
Screwplate M3: 0.5-0.9 Nm	right	Part no.			120574 A	120574 A	120574 A	120574 A	
(for above allen bit AF2.5)	left	Part no.			120574 B	120574 B	120574 B	120574 B	
Screwplate M4: 0.9-2.2 Nm	right	Part no.			120575 A	120575 A	120575 A	120575 A	
(for above allen bit AF3)	left	Part no.			120575 B	120575 B	120575 B	120575 B	
Screwplate M5: 2.2-5 Nm	right	Part no.				120576 A	120576 A	120576 A	
(for above allen bit AF4)	left	Part no.				120576 B	120576 B	120576 B	
Screwplate M6: 5-8 Nm	right	Part no.				120577 A	120577 A	120577 A	
(for above allen bit AF5)	left	Part no.				120577 B	120577 B	120577 B	
Screwplate M8: 8-25 Nm	right	Part no.					120578 A	120578 A	
(for above allen bit AF6)	left	Part no.					120578 B	120578 B	
Screwplate M10: 17-35 Nm	right	Part no.						120579 A	
(for above socket AF17)	left	Part no.						120579 B	
Screwplate M12: 35-60 Nm	right	Part no.						120580 A	
(for above socket AF19)	left	Part no.							
Screwplate M14: 60-100 Nm	right	Part no.						120446 C	
(for above socket AF22)	left	Part no.							
Screwplate M16: 100-200 Nm	right	Part no.						120446 D	
(for above socket AF24)	left	Part no.							

More Accessories on special request

Bit adapter, hex. drive female DIN ISO 1173 F6.3 (1/4")	Part no.		120489 A	120489 A	120489 A	120489 A	
Socket adapter, square drive male DIN 3121 E12.5 (1/2")	Part no.		120488 A	120488 A	120488 A	120488 A	
Clamping plate for clamping the torque dynamometer into a vice	Part no.	120436 A	120436 A	120436 A	120436 A	120436 A	



Screwplate



Bit adapter



Socket adapter



Clamping
plate

Calibration of DEPRAG measurement transducer or factory calibration of a measurement device or measurement electronic - for special order

DKD-calibration in accordance with DIN 51309 Strain gauge measurement transducer Load right/left 3 mounting positions 8 measurement points DKD-calibration certificate Part no. 3855281	Factory calibration in accordance with DIN 51309 Strain gauge or piezo measurement transducer Load right/left 3 mounting positions 8 measurement points Factory calibration certificate Part no. 3855282
Factory calibration in accordance with DIN 51309 Strain gauge or piezo measurement transducer Load right 3 mounting positions 8 measurement points Factory calibration certificate Part no. 3855283	Factory calibration in accordance with VDI/VDE 2646 Strain gauge or piezo measurement transducer Load right/left 2 mounting positions 8 measurement points Factory calibration certificate Part no. 3855284
Factory calibration (Standard) in accordance with VDI/VDE 2646 Strain gauge or piezo measurement transducer Load right 2 mounting positions 8 measurement points Factory calibration certificate Used for first calibration Standard for recalibration Part no. 3855285	Factory calibration of measurement device or measurement electronic Inspection and calibration of a torque measurement device or measurement electronic in accordance with DIN ISO 9001, as well as the creation of a corresponding measurement protocol with proof of traceability to national standards. Part no. 000768
Factory calibration of torque transducers DMS non-contact Documentation by factory certificate Part no. 000769	

TECHNICAL DATA

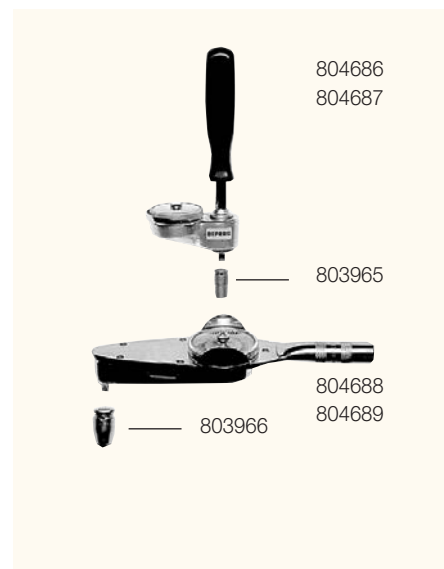
Mechanical torque wrenches

	Part no.	804686	804687	804688	804689
Measuring range	Nm/in.lbs	0 - 3.4 / 30	0 - 8.4 / 74	0 - 17 / 150	0 - 60 / 531
Increment	Nm/in.lbs	0.1 / 0.89	0.2 / 1.77	0.5 / 4.43	1 / 8.85
Drive (square male)		1/4"	1/4"	3/8"	3/8"
Optional equipment					
Bit adapter *)	Part no.	803965	803965	803966	803966

*) Inserting tools see leaflet D 3320 E

The **mechanical torque wrenches** (manual indicator design) can be used for simple adjustment or control tasks. To obtain the torque of a screw connection, simply re-

tighten the fastener. The use of a mechanical torque wrench allows the fast appraisal of tightening torque values.



Possible Combinations

Measuring principle: PIEZO-ELECTRIC

Measuring Instrument	Connection Cable:	Torque Transducer
type ME5000, type ME5400, type ME5600 or type ME6000	Length 5 m Part no. 810675	Measuring type MP1PE, type MP25PE, Platforms: type MP200PE E-Torque-Wrenches: type MS25PE-W type MS25PE-WS
type ME5000, type ME5400, type ME5600 or type ME6000	Length 1 m Part no. 810629	Measuring Platform: type MP1000PE

Measuring principle: STRAIN GAGE

Measuring Instrument	Connection Cable:	Torque Transducer
type ME5000, type ME5400, type ME5600 or type ME6000	Connection Measuring Instrument ME... to Measuring Platforms or Torque Wrenches Length 2 m Part no. 385493 A Length 4 m Part no. 385493 B Length 6 m Part no. 385493 C	Measuring Platforms: type MP2DMS type MP7DMS type MP25DMS type MP160DMS E-Torque Wrenches: type MS2DMS type MS7DMS type MS7DMS-W type MS25DMS-W

Measuring principle: STRAIN GAGE OR DMS NON-CONTACT

Connection Cable, Length 2 m / 4 m / 6 m

Measuring Instrument

type ME5000, type ME5400,
type ME5600 or type ME6000

Connection Cable:

Connection Measuring Instrument ME... to
Non-contact Transducer or Measuring Platforms

Length 2 m	Part no. 385486 A
Length 4 m	Part no. 385486 B
Length 6 m	Part no. 385486 C

Additionally required when connected with ME5000:
Power Supply Part no. 800827 and
Power Supply Cable 230 V Part no. 812587
115 V Part no. 812295

Torque Transducer

Non-contact Transducer
type V002-E6.3/F6.3
type V005-E6.3/F6.3
type V010-E6.3/F6.3
type V020-E6.3/F6.3

Measuring Platform
type MP500DMS

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