

ISO 6789-2:2017-02 (E)

Assembly tools for screws and nuts - Hand torque tools - Part 2: Requirements for calibration and determination of measurement uncertainty

Contents		Page
Foreword		iv
Introduction		v
1	Scope	1
2	Normative references	1
3	Terms, definitions and symbols	1
3.1	Terms and definitions	2
3.2	Symbols, designations and units	2
4	Requirements for calibration	4
4.1	Calibration during use	4
4.2	Calibration method	4
4.3	Calibration system	4
5	Measurement error	5
5.1	Calculation of the relative measurement error	5
5.2	Exemplary calculations of the relative measurement error	5
5.2.1	Example 1	5
5.2.2	Example 2	6
6	Sources of uncertainty	7
6.1	General	7
6.2	Evaluation of Type B uncertainties due to the torque tool	8
6.2.1	Scale, dial or display resolution, r	8
6.2.2	Variation due to the reproducibility of the torque tool, b_{rep}	10
6.2.3	Variation due to the interface between the torque tool and the calibration system	11
6.2.4	Variation due to the variation of the force loading point, b_l	12
6.3	Evaluation of Type A uncertainty due to the torque tool	13
6.3.1	General	13
6.3.2	Variation due to the repeatability of the torque tool, b_{re}	13
7	Determination of the calibration result	13
7.1	Determination of the relative standard measurement uncertainty, w	13
7.2	Determination of the relative expanded measurement uncertainty, W	14
7.3	Determination of the relative measurement uncertainty interval, W'	14
8	Calibration certificate	15
Annex A (informative) Calculation example for an indicating torque tool (Type I)		16
Annex B (informative) Calculation example for a setting torque tool (Type II)		25
Annex C (normative) Minimum requirements for the calibration of the torque measurement device and the estimation of its measurement uncertainty		34
Bibliography		41