

In order to process your repair as quickly as possible, we ask you to fill out this form completely before sending the tool. It is especially important to send us a detailed description of the problem, preferably with a picture or video. Please avoid error descriptions such as „defective“ or „no function“.

A separate form must be created for each tool. Send this form completed to: repaircenter@hs-technik.com

You will then receive a RMA number from us, which you must enclose with the repair so that we can assign it correctly.

Please ship the goods to:

HS-Technik GmbH
Im Martelacker 12
79588 Efringen-Kirchen
Germany

Please note: Defective batteries cannot be sent back. Defective batteries must be disposed by the customer. The data backup must be carried out by the customer before shipment to HS-Technik.

Tool bought from:* HS-Technik GmbH

Distributor - name:

Customer no.

Customer name*

Sales contact person

Technical contact person*

Phone no.*

E-mail*

Your reference no.*

Type*

Serial no.*

1. Error description **2. Service MCT**

If Service MCT is selected, please continue with point 2.1 or 2.2.

1.1 Mechanical defects

How did the error occur?*

How is the error noticed?*



1.2 Electrical defects

How did the error occur?*

How ist the error noticed?*

2.1 MCT for tightening tools

○ Machine-related MCT according to VDI 2645 - Sheet 2¹

¹ Possible variants depending on the torque tool type are:

Torque controlled

0 % = Torque start of working range with 30° (hard)

100 % = End torque of the working range with 360° (soft)

Angle-controlled exclusively for EC torque tools

Target angle: 180°, Tolerance: ± 20°

Scope of the joint related MCT

MFU-25

MFU-50

MFU-100

○ Joint related MCT to VDI 2645 - sheet 2²

Simulation of the real tightening case

Torque controlled

Tool working range Nm to (e.g. 9,0 Nm)

Final torque, check point Nm

Tolerance ± Nm

Tolerance ± %

Angle start torque Nm

Tightening joint hardness (angle) °

Speed (1st step) min⁻¹

Speed (2nd step / last step) min⁻¹

The angle start torque is typically 50% of the target torque.

The rotation speed in the final stage for EC screwdrivers is 20 min⁻¹.

The rotation speed in the final stage for clutch screwdrivers is 350 min⁻¹



Angle controlled

Angle start torque (Nm) % (z.B. +/- 10 %)
 Final angle, check point °
 Tolerance ± in °
 Final torque Nm
 Tolerance ± in Nm
 Speed min⁻¹

Scope of the joint related MCT

- MFU-25
- MFU-50
- MFU-100

Note:
 Without complete information, a torque application-specific MFU is not possible, and this may also cause delays.

2.2 MCT for blind rivet tools

Scope of MCT for blind rivet tools

- Machine related MCT³
- Rivet case related MCT⁴

³ 80 % of the force range

⁴ **Necessary** informations about rivet case related MCT

Tolerance% (e.g. +/- 10 %)
 Setting forcekN (e.g.. 15 kN)
 Setting speed (1. step)mm/s (e.g. 15,0 mm/s)
 Setting speed (last step)mm/s (e.g. 2,0 mm/s)
 Setting strokein (e.g. 21 in)

Scope of rivet case related MCT

- MFU-25-BR/BRN*
- MFU-50-BR/BRN*
- MFU-100-BR/BRN*

* BR = Blind Rivet / BRN = Blind Rivet Nut

