



**HYTORC**<sup>®</sup>

Since 1968

**Tool Model: XXI-1**  
**Pressure/Torque Conversion Chart**

PRESSURE IN: PSI	TORQUE IN:			PRESSURE IN: BAR
	ft-lbs	KGM	NM	
1500	165	23	224	104
1600	177	25	240	110
1800	202	28	274	124
2000	227	31	308	138
2200	252	35	341	152
2400	276	38	374	165
2600	301	42	408	179
2800	325	45	441	193
3000	350	48	474	207
3200	376	52	510	220
3400	402	56	545	234
3600	428	59	580	248
3800	454	63	615	262
4000	480	66	651	276
4200	508	70	689	290
4400	536	74	727	303
4600	564	78	765	317
4800	592	82	803	331
5000	620	86	840	345
5200	647	89	877	358
5400	674	93	914	372
5600	701	97	950	386
5800	728	101	987	400
6000	755	104	1023	414
6200	784	108	1063	427
6400	813	112	1102	441
6600	842	116	1141	455
6800	871	120	1181	468
7000	900	124	1220	482
7200	930	129	1261	496
7400	960	133	1301	510
7600	990	137	1342	524
7800	1020	141	1383	538
8000	1050	145	1423	552
8200	1076	149	1459	565
8400	1103	153	1495	579
8600	1129	156	1531	593
8800	1156	160	1567	607
9000	1182	163	1602	620
9200	1212	168	1642	634
9400	1241	172	683	648
9600	1271	176	1723	662
9800	1300	180	1763	676
10000	1330	184	1803	690

**Hytorc West**

<http://www.hytorcwest.com>

## Important Safety Instructions

**WARNING:** Your **HYTORC TORQUE MACHINE** is a power tool, and as with any power tool, certain safety precautions should be observed to avoid accidents or personal injury. The following tips will assist you.

- **READ ALL INSTRUCTIONS.**
- **KEEP WORK AREA CLEAN AND WELL LIT.**
- **CONSIDER WORK AREA ENVIRONMENT.** Electrical Pumps should never be used in any atmosphere which can be considered potentially volatile. If there is any doubt, use an air pump. Also Note: metal to metal contact can cause sparks, precautions should be taken.
- **AVOID PREMATURE TOOL STARTING.** The Pump Remote Control is for the TOOL OPERATOR only.
- **STAY CLEAR DURING OPERATION.** In most cases, the tool will allow “hands free” operation. If the tool must be held or steadied during operation, use alternative means of securing the tool to the application.
- **GUARD AGAINST ELECTRIC SHOCK.** Ensure the pump is properly grounded and the proper voltage is being used.
- **STORE IDLE TOOLS.** When not in use, tools and accessories should be properly stored to avoid deterioration.
- **USE RIGHT TOOL.** Don't force small tools or attachments to do the job of a larger tool. Don't use tool for purposes not intended.
- **PROPER SAFETY ATTIRE.** When handling/operating hydraulic equipment, use work gloves, hard hats, safety shoes and other applicable clothing.
- **USE SAFETY GLASSES.**
- **Moving equipment.** Do not use hydraulic hoses, uniswivels, pump power or remote cords as means of moving the equipment.
- **MAINTAIN TOOLS WITH CARE.** For top performance, inspect tool, powerpack and accessories for visual damage frequently and always prior to use. Always follow instructions for proper tool and pump maintenance. Refer to the Operations maintenance Section for further clarification.
- **STAY ALERT.** Watch what you are doing. Use common sense. Do not use power equipment under the influence of any mood altering substances.
- **PRIOR TO OPERATION.**  
Ensure that all hydraulic connections are securely connected and there is no leakage.  
Verify that the hydraulic hoses are not kinked or otherwise damaged.  
Insure the square drive and its retainer is fully and securely engaged.  
Ascertain that all connectors, elbows, fittings and swivels are not bent, loose or damaged.
- **PRIOR TO USE.**  
Check Sockets for size, quality and flaws. (Do not use if question able.)  
Cycle tool to ensure proper function.  
Locate a solid, secure reaction point.  
Be sure the reaction arm retaining clamp is fully engaged.  
Be sure the hydraulic hoses are free of the reaction point.  
Pressurize the system momentarily if the tool tends to “ride up” or to “creep”, stop and re-adjust the reaction arm to a more solid and secure position.  
  
NOTE: Remain clear of the reaction arm during operation and never put body parts between reaction arm and reaction surface.
- **ALWAYS USE QUALITY ACCESSORIES.** Always use top quality impact sockets in good condition which are the correct size and fully engage the nut. Hidden flaws, however, remain a possibility which could cause break, so stay clear of sockets during operation.
- **DO NOT USE** other equipment to enhance performance. (Hammer on Socket/Tool)
- **NOTE:** HYTORC Pumps are designed to operate HYTORC Tools only. Damage may occur to the pump or product that is being operated due to misuse.

**SAVE THESE INSTURCTIONS FOR FUTURE USE!**