Cleco®
Production Tools

Homologation

Document no: 017/2021

Cleco®

Fixtured Spindle

Type: **Cleco - 1BD-1B012A-1K3D-1VK3D**

Order no.: **1BD12T2O-A**

This homologation also applies to type(s):

Cleco - 1BD-1B012A-1VK3D
Cleco - 1BDU-1B012A-1K3D-1VK3D
Cleco - 1BDU-1B012A-1VK3D

Cleco - 1BD-1B012A-1K3D-1VK3D

Fixtured Spindle

Order no.: 1BD12T2O-A

Included	*Type*	*Order no.*
	Cleco - 1BD-1B012A-1VK3D	1BD12T1O-A
	Cleco - 1BDU-1B012A-1K3D-1VK3D	1BDU12T2O-A
	Cleco - 1BDU-1B012A-1VK3D	1BDU12T1O-A

Machine type:	Fixtured Spindle
Torque range:	2 Nm to 12 Nm
Max speed:	3152 rpm
Certified serial nos.:	755948, 755949, 755950

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Cleco Production Tools

Homologation of nutrunners

Apex Tool Group

Fixtured Spindle

C_m / C_{mk} values achieved

According VDI/VDE 2647 February 2013

Accuracy class: 7 %

Tool model	Serial nos.	Test data	30 %		80 %		100 %	
			30° ±5°	360° ±15°	30° ±5°	360° ±15°	30° ±5°	360° ±15°
1BD-1B012A-1K3D-1VK3D		Break time	5 s	5 s	5 s	15 s	5 s	25 s
		Test torque	**5,00 Nm**		**10,00 Nm**		**12,00 Nm**	
		Speed in 1st stage	1000 rpm	1000 rpm	1000 rpm	1000 rpm	1000 rpm	1000 rpm
		Speed in last stage	50 rpm	50 rpm	50 rpm	50 rpm	50 rpm	50 rpm
		Angle start torque	2,50 Nm		5,00 Nm		6,00 Nm	
	755948	C_m	3,93	4,57	7,58	7,87	6,61	6,91
		C_{mk}	3,48	3,78	7,23	6,69	6,48	6,35
	755949	C_m	5,28	5,72	4,93	7,23	5,08	6,67
		C_{mk}	4,24	3,94	4,52	6,81	4,92	6,19
	755950	C_m	5,19	4,41	6,44	6,94	8,15	7,80
		C_{mk}	4,61	3,41	6,18	6,23	7,45	7,57
Min. C_m/C_{mk}		C_m	3,93	4,41	4,93	6,94	5,08	6,67
		C_{mk}	3,48	3,41	4,52	6,23	4,92	6,19

	Target:	≥ 1.67	**Rating**
Capability index	C_m	**3,93**	**OK**
	C_{mk}	**3,41**	**OK**

Tolerances of rotational angle homologation
Measurements without angle correction

Tool model	Serial nos.	Test data	60 % of max. torque		80 % of max. torque	
			40°		**180°**	
1BD-1B012A-1K3D-1VK3D		Break time	5 s		5 s	
		Angle start torque	2,40 Nm		2,40 Nm	
		Test torque	7,20 Nm		9,60 Nm	
		Speed in 1st stage	300 rpm		300 rpm	
		Speed in last stage	50 rpm		50 rpm	
	755948	Torque	±	1,47 %	±	1,92 %
		Angle	±	1,3°	±	3,6°
	755949	Torque	±	1,99 %	±	2,36 %
		Angle	±	0,9°	±	1,3°
	755950	Torque	±	1,51 %	±	1,90 %
		Angle	±	1,2°	±	1,7°

Torque	Target: ±	7 %	Target: ±	7 %
	Actual: ±	1,99 %	Actual: ±	2,36 %
Rating	**OK**		**OK**	

Angle	Target: ±	5°	Target: ±	10°
	Actual: ±	1,3°	Actual: ±	3,6°
Rating	**OK**		**OK**	

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Test sheet no. 1a

General specifications

Manufacturer:	Apex Tool Group	**Assembly tool type**	Fixtured Spindle
Tool model:	1BD-1B012A-1K3D-1VK3D	**Serial numbers:**	755948, 755949, 755950
Torque range:	2 Nm to 12 Nm		

Operating voltage:	380	VDC
Power consumption:	510	W
Weight:	4,58	kg
Control cable length:	15	m
Diameter of control cable:	14	mm
Maximum speed at the first stage:	3152	rpm
Maximum speed at the final stage:	3152	rpm
Minimum speed at the final stage:	0	rpm
Sound pressure level at maximum speed: (acc. to DIN EN 62841-1:2016-07, DIN EN 62841-2-2:2015-05)	70	dB(A)

Temperature of electrical tools:

(After 100 measurements with soft jont at 80% torque)

	start	end
at the angle head:	-	-
on the electric motor:	22 °C	58 °C
on the handle:	-	-

Output type:	Square drive	
Output drive size:	3/8	inches

Test sheet no. 1b

Specifications of controller

Manufacturer:	Apex Tool Group	**Serial number:**	AXABH0001
Controller type:	MPRO400GCD-P	**Software version:**	S168813-1.12.0.61436-Test 03.03.21

Fastening Strategy:	Current shut-off:	Yes
	Torque control:	Yes
	Torque control, angle monitoring:	Yes
	Angle control, torque monitoring:	Yes
	Yield point control:	Yes
	Pre-load control:	No
Options:	Prevailing torque:	Yes
	Angle correction:	No
	Pulsing:	No
	Tighten - loosen - tighten:	Yes
	Tapping screw monitoring:	Yes
	Left-hand rundown:	Yes
	Other procedures:	Yes, see documentation
Angle of rotation resolution:		1 degree
Torque accuracy:		1 %
Programming:	Keyboard:	Yes
	External PC:	Yes
	Text display:	Yes
	Display:	Yes
	LCD display:	No
Printer interface:		Yes
Additional inputs and outputs:		2 Serial RS232 8 Digital in, 8 Digital out (24V) 2 Fieldbus modules 3 USB 2.0
Isolation transformer:		No, galvanic isolated power supply
Network:		2 RJ45 10/100 BaseT Ethernet ports

POWER TOOLS SALES & SERVICE CENTERS

Please note that all locations may not service all products.
Contact the nearest Cleco® Sales & Service Center for the appropriate facility to handle your service requirements.

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