

Unitec Installation Instructions



1. Insert the Unitec coupler over the end of the first bar until contact with the center pin. Strongly hand tighten the screws from center to outside with a wrench to pre-position the coupler progressively in order to maintain its alignment with the bar.



2. Tighten the screws, from center to outside, with a power drive (pneumatic wrench) until their heads shear off. (A manual wrench can be sufficient for small screws M12 & M16 if there are not many couplers to assemble).



3. Insert the second bar into the coupler until contact with the center pin and repeat the operation. Check the bar alignment when hand tightening the screws with a wrench : at a distance of 25cm the misalignment should not exceed 5mm (or not more than 1/4" at a distance of 1ft).



Safety tip: Wear goggles and ear plugs when using the impact wrench.

General instruction: Grease shall not be used.



1. Remove the center pin with a punch.



2. Mark the bar engagement length on each bar end, using the data in the table.

Part No.	Bar Size		Minimum bar engagement length	
	USA / Mexico	Canada	in	mm
SBUUSS4	#4		2-21/32"	68
SBUUSS5	#5	15M	2-21/32"	68
SBUUSS6	#6	20M	3-13/32"	86
SBUUSS7	#7	20M	3-27/32"	98
SBUUSS8	#8	25M	4-1/8"	105
SBUUSS9	#9		4-9/16"	116
SBUUSS10	#10	30M	5-5/16"	135
SBUUSS11	#11	35M	6-7/8"	174
SBUUSS12	#12		8-5/32"	207
SBUUSS14	#14	45M	10-23/32"	272
SBUUSS18	#18	55M	12-11/32"	313



3. Slide the Unitec coupler all over the first bar. Bring the continuation bar in front of it and slide the Unitec coupler back over it. Position the coupler between the marks and hand tighten the screws.



4. Tighten the screws, from center to outside, with a power drive (pneumatic wrench) until their heads shear off.

Equipment Needed

We recommend to use one of the Toku & Metabo pneumatic impact wrenches listed below. If another brand or another model is used, the proper speed should be determined before starting the job.



Bar Size	Brand	Model	Square Drive	Weight		Air consumption under load		Air inlet thread	Manufacturer's Speed Setting
			in	lbs	kg	cfm	(L/min)	in	
#4 to #8 12 to 25	Toku	MI-20P	3/4"	8.6	3.9	39	1,104	3/8"	4
	Ingersoll Rand	2141P	3/4"	7	3.2	40	1,132	3/8"	-
	Atlas Copco	LMS61 HR20	3/4"	11.2	5.1	25	707	3/8"	-
#4 to #18 12 to 50	Toku	MI-5000GS	1"	31.2	14.2	66	1,868	1/2"	4
	Metabo	RS-4900L	1"	23.3	10.6	22	622	1/2"	2
	Ingersoll Rand	2940 B2	1"	22	10	58	1,641	1/2"	-
	Chicago	CP7780	1"	15	6.8	49.8	1,404	1/2"	-
	Atlas Copco	LMS86 GIR38	1-1/2"	36	16.4	61	1,726	1/2"	-

(* Remark: SureBuilt is not the owner of the brands mentioned here. Any protected trademark rights remain entirely exclusive to their respective owners and are only mentioned here as a reference in relation to Dextra products.

Air Supply



The requirement for air flow is 100 psig (7 bar) of operating pressure and 70 cfm (2 m³/min) of delivered air to the pneumatic impact wrench through a 3/4" (Unitec 12 to 25) or 1" (Unitec 12 to 50) hose.

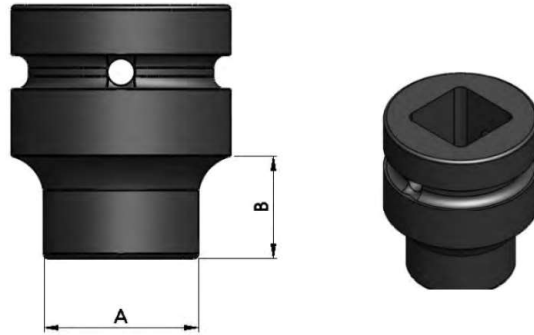
Electric Impact Wrench

Some electric wrenches can also be used, for example :

Bar Size	Brand	Model	Square Drive	Weight		Power Supply
			in	lbs	kg	
#4 to #8 12 to 25	Hitachi	WR 25 SE	1"	16.9	7.7	110 - 240 V



Tooling Settings



Bar Size		Coupler Part No.	Coupler Weight		Length mm	Total number of screws per coupler	Screw Size	Average torque to shear screw heads		Air Gun Socket Size		A (mm)	B (mm)
USA	Canada		lbs	kg				ft - lb	Nm	Square drive	Hexagonal dimension mm		
#4		SBUUSS4	2.9	1.3	140	6	M12	100	140	3/4"	13	26	22
#5	15M	SBUUSS5	2.8	1.3	140	6							
#6	20M	SBUUSS6	4.4	2.0	200	8							
#6, #7	20M	SBUUSS7	5.3	2.4	180	6	M16	185	250	3/4" or 1"	15	26	22
#8	25M	SBUUSS8	7.5	3.4	240	8							
#9		SBUUSS9	12.5	5.7	220	6	M20	500	680	1"	19	36	24
#10	30M	SBUUSS10	17.3	7.9	280	8							
#11	35M	SBUUSS11	24.8	11.3	360	10							
#12		SBUUSS12	31.4	14.3	425	12	M24	730	990	1"	21	38	24
#14	45M	SBUUSS14	41.1	18.6	555	16							
#18	55M	SBUUSS18	80.9	36.7	640	16							