

STANDARD OPERATING PROCEDURE | SOP

FLAG TYPE TORX KEY

1

IDENTIFY THE TORX SIZE



- Check the screw for the engraved Torx size (e.g., T6, T7, T8, T9, T10, T15, T20).
- Select the matching flag-type Torx key.
- Using a wrong size can strip the screw.

2

INSPECT THE TORX KEY



- Ensure the Torx tip is not worn, rounded, or deformed.
- Check the handle is secure on the flag side.
- Wipe any oil or chips from the tip.

3

CLEAN THE SCREW HEAD



- Blow air to remove chips from the Torx recess.
- Ensure the recess is not filled with coolant residue or dust.
- Clean engagement gives maximum torque.

4

POSITION THE FLAG TORX KEY



- Insert the Torx bit straight into the screw head.
- Ensure full engagement—no gap between the key and the screw.
- The flag handle should be aligned comfortably for rotation.

5

APPLY CONTROLLED TORQUE (TIGHTENING)



- Grip the flag part of the tool.
- Apply torque smoothly without jerking.
- Do not overtighten—toolholder/insert screws can break easily.
- Stop when screw seats firmly.

6

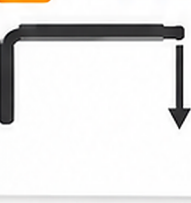
LOOSENING SCREWS



- Insert the Torx key fully.
- Use the long-handle portion for extra leverage if needed.
- Apply torque gradually until the screw loosens.
- Avoid applying side load (which can break the tip).

7

USE THE LONG ARM FOR HIGH TORQUE



- For stuck screws or initial loosening, hold the longer arm.
- Maintain straight alignment to avoid stripping.
- Once the screw starts turning, switch to flag side for better control.

8

REPLACE WORN SCREWS OR KEYS



- If you see: rounded screw head; slipping Torx engagement; chipped Torx key.
- Replace immediately to avoid damage to holders.

9

SAFETY PRECAUTIONS



- Wear safety glasses—chips can eject when loosening screws near a cutting area.
- Do not use extensions or hammers on the Torx key.
- Keep hands away from sharp tool edges.

10

STORAGE & MAINTENANCE



- Wipe with an oily cloth to prevent rust.
- Store in a designated tool area to avoid misplacing Torx keys.
- Keep sizes arranged (T6, T7, T8, T9, T10, T15, T20 etc.) for quick selection.

