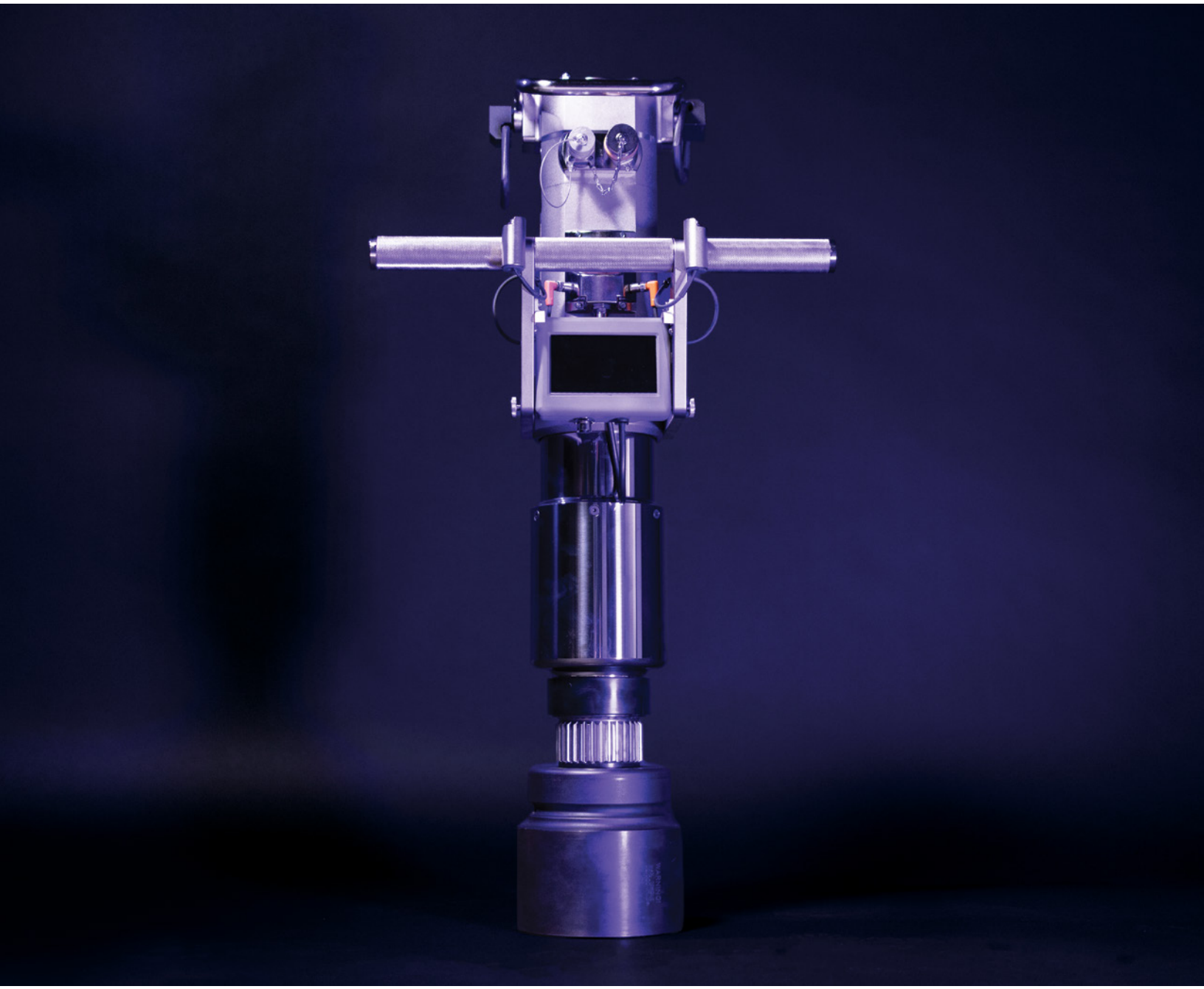
HYTORC



BLITZ
Basic Operations Manual

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HYTORC

HY-CARE SERVICE PLANS

Never Settle For Less.



WHERE UNMATCHED SUPPORT MEETS OPERATIONAL PEACE OF MIND

Downtime due to tool maintenance can significantly impact project timelines and operational efficiency. Our HY-CARE service plans directly address this issue, providing essential support when you need it most. With this program, the hassle and uncertainty of tool servicing are taken off your shoulders, allowing every bolt tightened to be a step towards a more efficient, safer, and cost-effective operation.

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- **No Deductible**
- **24-Hour Loaner Tools**
- **Lifetime Product Upgrades**
- **Discounted Calibration Rates***
- **and much more**

*Not included in HY-CARE Basic.

ABOUT THIS DOCUMENT

ORIGINAL INSTRUCTIONS

Purpose. This operations manual provides detailed guidelines on the proper operation, usage, storage conditions, and troubleshooting of the **BLITZ.** It is intended to ensure efficient operation, prevent equipment failures, and maintain workplace safety standards. This manual applies to all personnel involved in the operation, maintenance, and supervision of **BLITZ**. It should be used in conjunction with workplace safety policies. Entrust that these operating instructions are always accessible for the user at the site and are in legible condition. Always make sure that these operating instructions accompany the **BLITZ** when transferring from location to location.

This document applies to the **BLITZ**, model designations as follows:

Model: BLITZ
Configurations: 15K, 10K
Option: N/A
Custom options: -zzzz if specified

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Product Modifications. HYTORC DOES NOT ALLOW any of the products listed in this manual to be modified by any end user without exception. Should an application require a modification to the tool or any of the standard accessories please consult with your local HYTORC representative and they will be able to obtain the assistance for any modification that may be required.

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⚠ **WARNING Read all safety warnings, instructions, illustrations and specifications provided with this power tool.** *Failure to follow all instructions listed below may result in electric shock, fire and/or serious injury.*

Save all warnings and instructions for future reference.

⚠ **WARNING All control and power cables must be connected to the appropriate ports on toolhead and control case before powering on. Failure to do so will result in damage to the tool.**

⚠ **WARNING Disconnect the plug from the power source before servicing the power tool and/or disconnecting cables from the power tool. Such measure reduces the risk of electric shock.**

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1

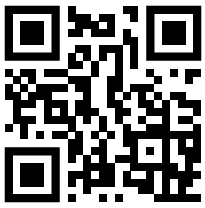
CARE AND MAINTENANCE

1. Care and Maintenance

ENVIRONMENTAL CONSIDERATIONS

- The BLITZ Electric Torque Tool is a rugged industrial tool with an electric powered toolhead and electronic control box. The following environmental considerations will help maintain reliable tool operation.
- The tool should not be exposed to moisture. Do not operate in rain, snow or extreme humidity.
- The operating temperature range of the toolhead and control box is -10 deg C to 46 deg C.The ambient storage temperature range for tool head and control box is -30 deg C to 50 deg C.
- All Cooling Vents should be kept clear of dust, dirt and debris to allow internal fans to maintain airflow to keep the motor and electronics within temperature limits.
- Do not subject the tool to extremely dusty environments. Do not cover or obstruct vents during operation.
- The tool and electronic components are not certified or approved for explosive environments or areas containing combustible chemical materials.
- Secure the tool per local practice to protect from dropping.

TOOL MAINTENANCE GUIDELINES



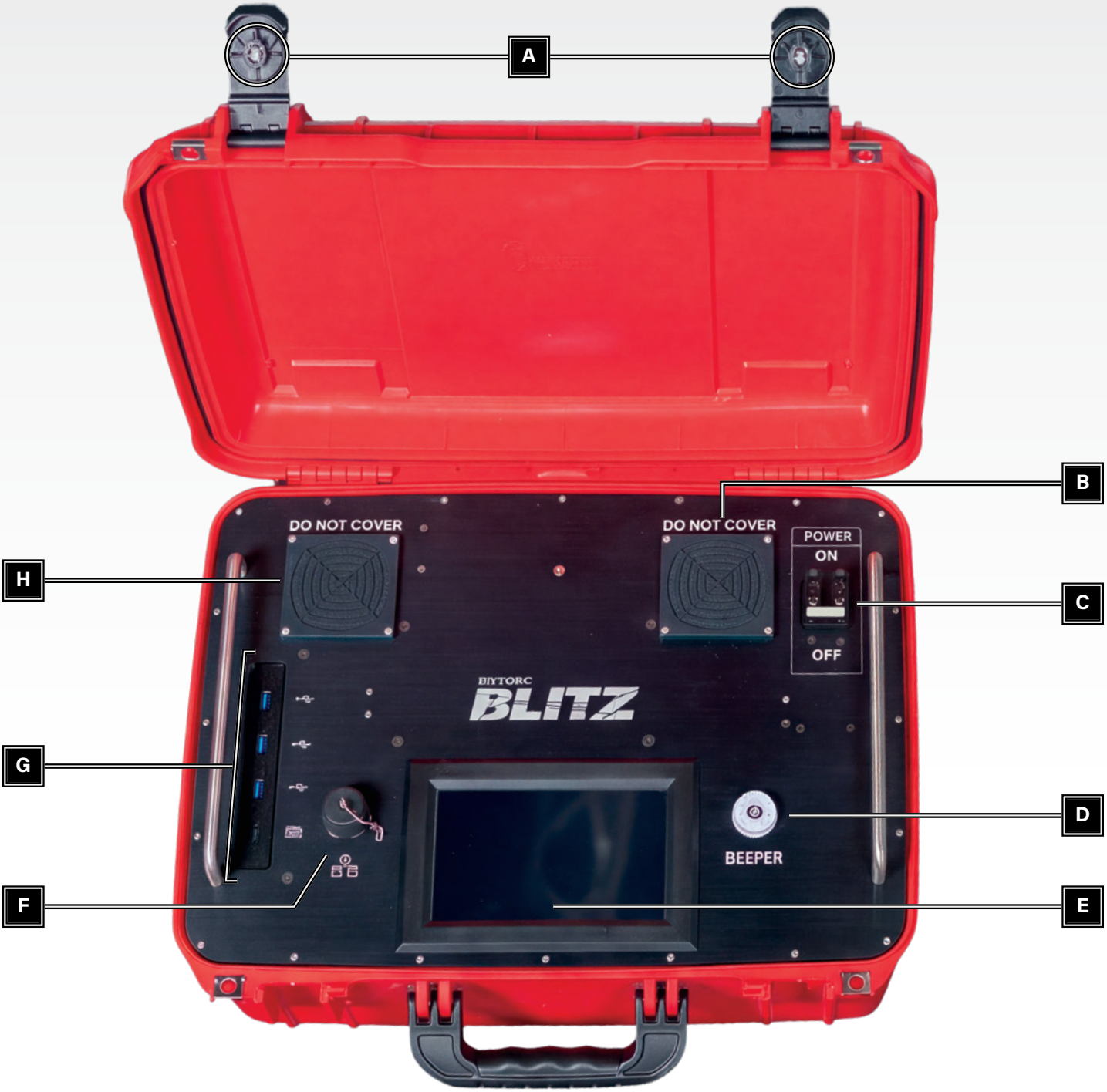


2

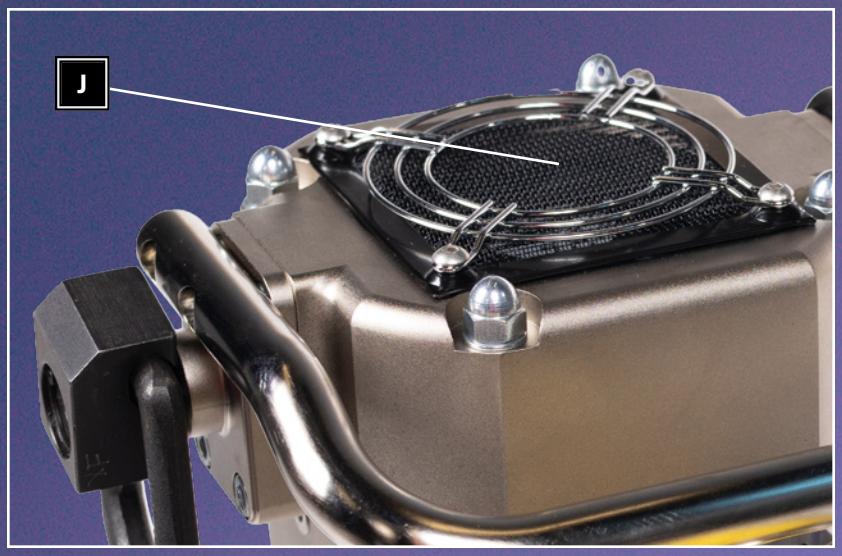
TOOL DESCRIPTION

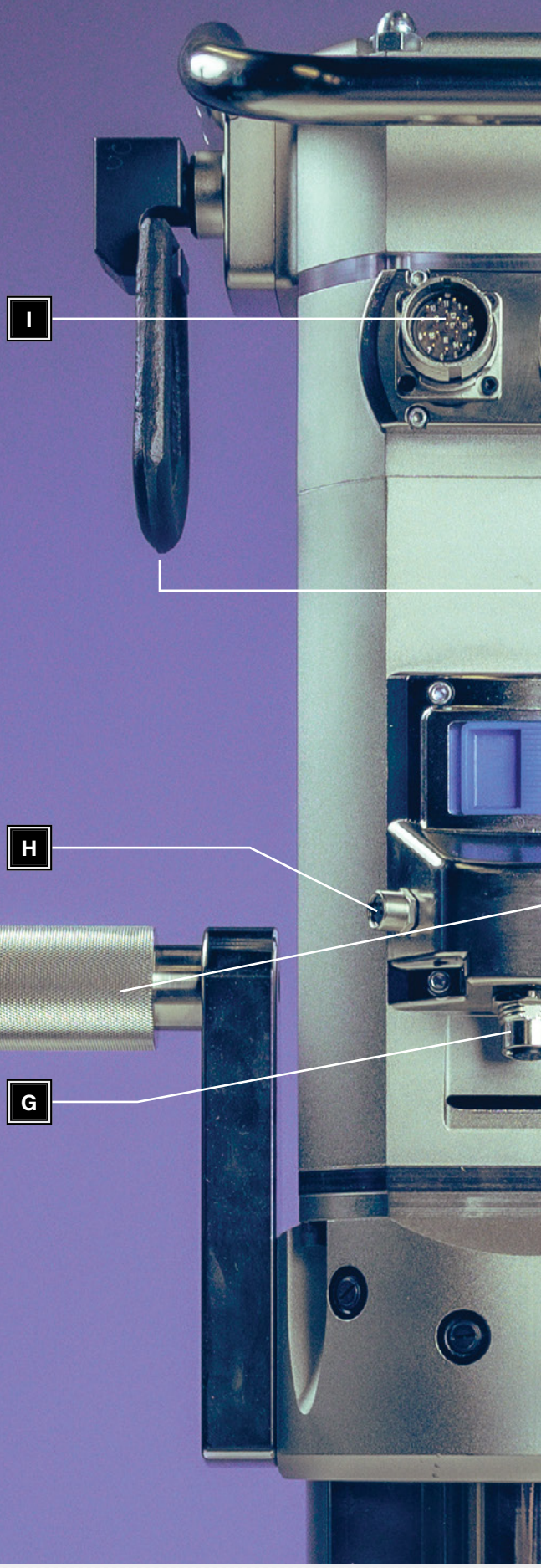
2. Tool Description

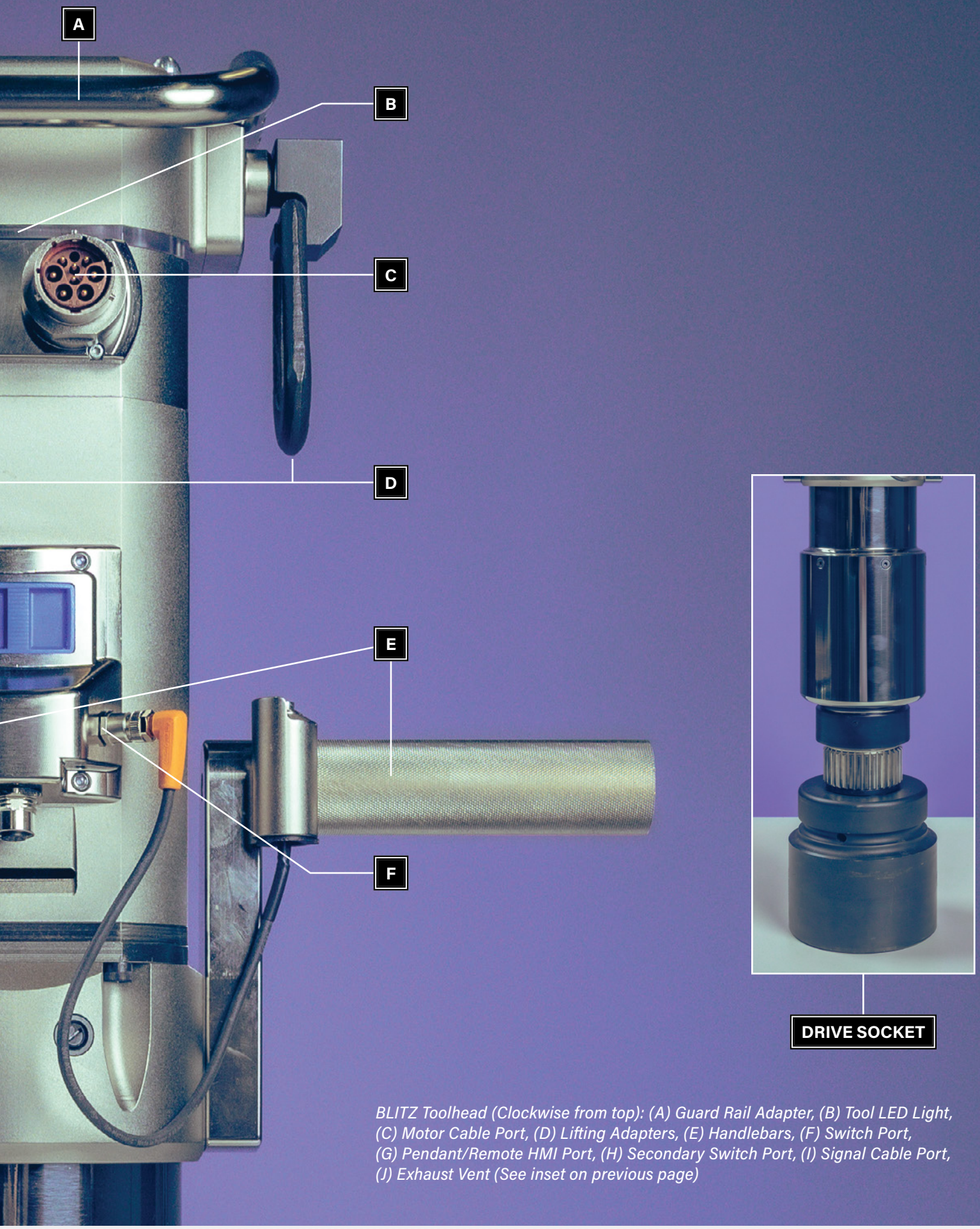
The **BLITZ** is a plug-in electric tool specially designed to reach high torque levels. It has a capacity to reach up to 15,500 ft.-lbs. (21,015 Nm) and a transducer at the square drive to assure accurate repeatable torque. There is a separate control box with a touchscreen and data capture capabilities. This tool is compatible with conventional sockets, the HYTORC Washer, and the HYTORC Nut.



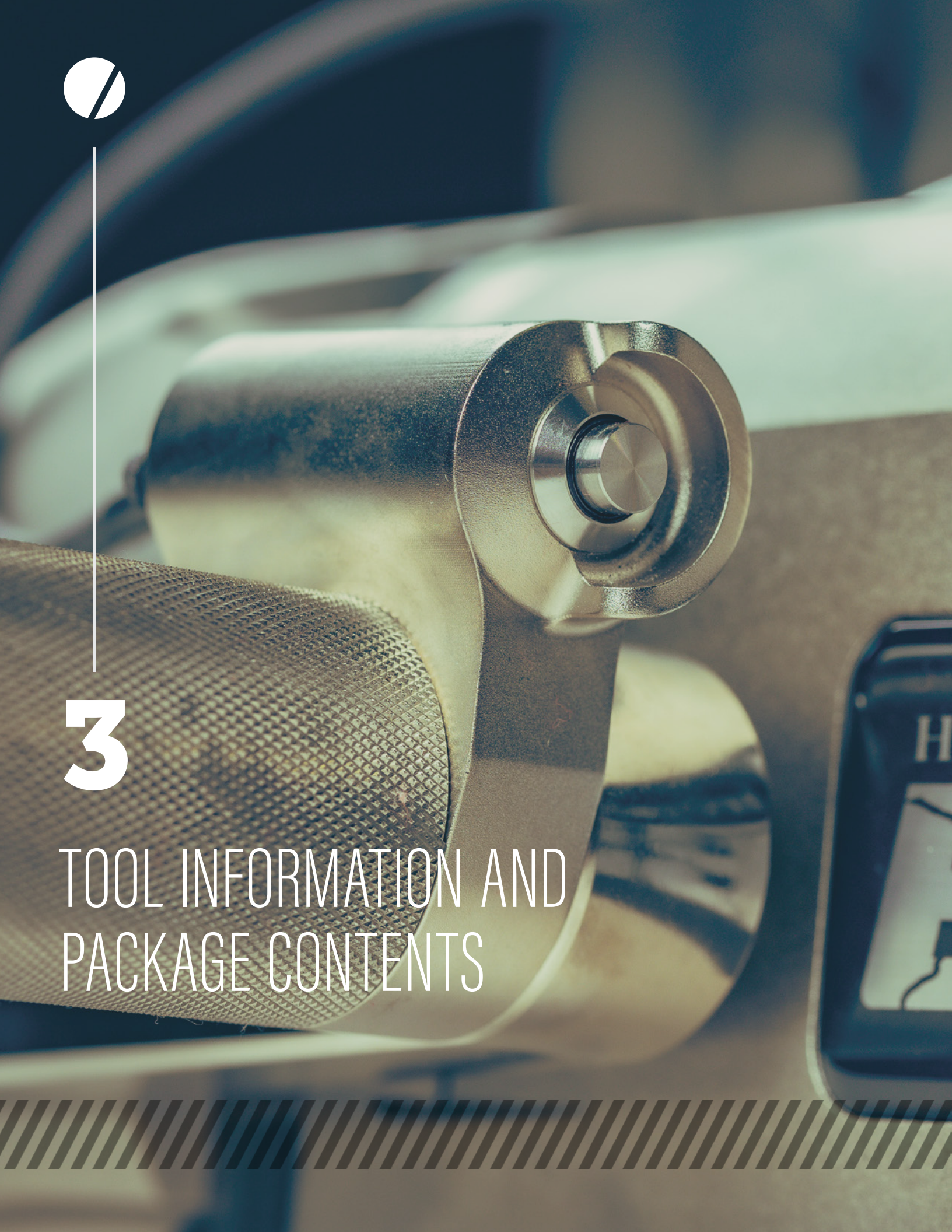
BLITZ Control Case (Clockwise from top): (A) Latches, (B) Fan Vent, (C) Power Switch, (D) Beeper, (E) Touchscreen, (F) Ethernet Port, (G) USB Hub, (H) Exhaust Vent


J


I
H
G



BLITZ Toolhead (Clockwise from top): (A) Guard Rail Adapter, (B) Tool LED Light, (C) Motor Cable Port, (D) Lifting Adapters, (E) Handlebars, (F) Switch Port, (G) Pendant/Remote HMI Port, (H) Secondary Switch Port, (I) Signal Cable Port, (J) Exhaust Vent (See inset on previous page)



3

TOOL INFORMATION AND PACKAGE CONTENTS

TOOL INFORMATION AND PACKAGE CONTENTS

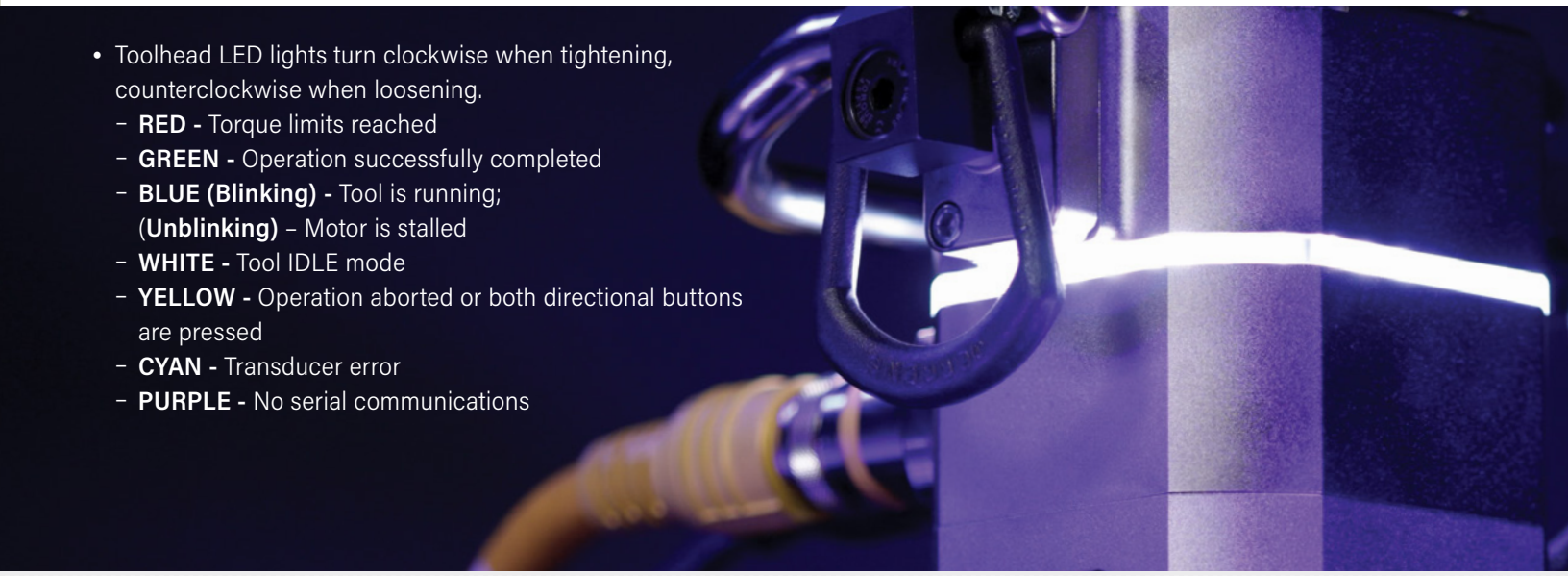
- Control Box
- Cables and Cords
  - Motor Cable (yellow)
  - Signal Cable (black)
  - Power Cord
- Toolhead
  - Guard Rail Adapter
  - Lifting Adapter[1]
  - Side Lift Switch Adapter[2]
  - Optional Add-Ons:
    Remote HMI
    Pendant Assembly[2]
    Forward Lift Handle Assembly[1]
    LH Handlebar Switch Assembly[2]

1 Only one lifting option can be used at a time.
2 Only one tool control option can be used at a time.





- Toolhead LED lights turn clockwise when tightening, counterclockwise when loosening.
  - **RED -** Torque limits reached
  - **GREEN -** Operation successfully completed
  - **BLUE (Blinking) -** Tool is running;
    (**Unblinking**) – Motor is stalled
  - **WHITE -** Tool IDLE mode
  - **YELLOW -** Operation aborted or both directional buttons are pressed
  - **CYAN -** Transducer error
  - **PURPLE -** No serial communications



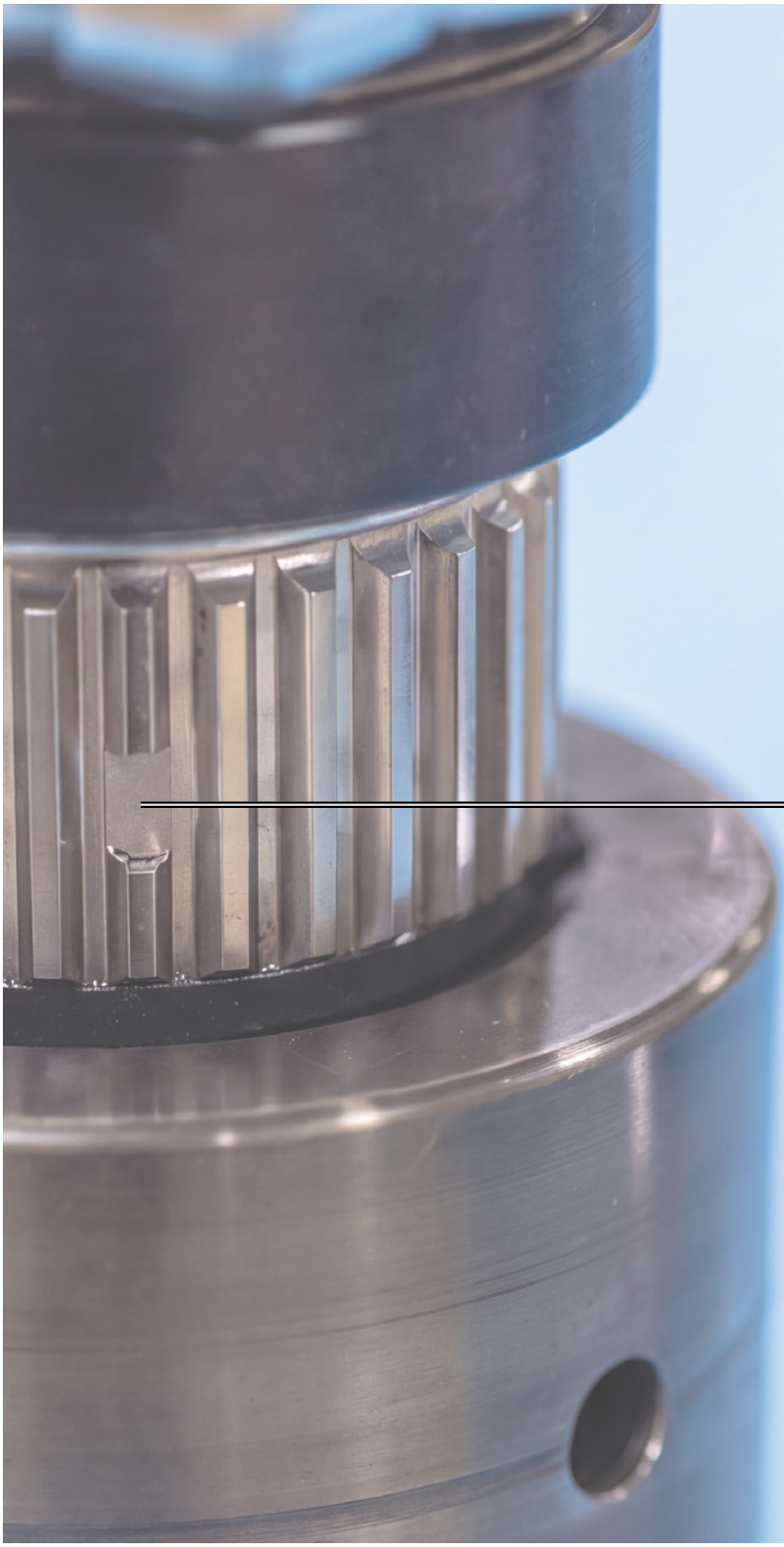


4

OPERATION AND USAGE

TOOL SETUP

Installing The Reaction Arm and Socket



Installing The Reaction Arm

- Slide the reaction arm over the drive while aligning the screw with the spot face (circular indentation) on the spline.
- Tighten the screw to attach the reaction arm.
- Pull firmly on the reaction arm to make sure it is properly secured.
- Position the reaction arm against a firm, flat surface flat surface that can handle the load. At least 0.5" (12 mm) of the reaction arm must contact the flat surface.
- DO NOT place the reaction arm against a round or inclined reaction point.
- DO NOT use an adjustable reaction arm.
- Only use HYTORC reaction arms.
- DO NOT modify a reaction arm as this may lead to personal injury or damage to the tool.
- Contact your HYTORC rep for more accessory options.

Installing The Socket

- Make sure the O-ring is installed on the socket.
- Insert the pin partway into the socket.
- Slide socket onto the drive while aligning the pinhole in the socket with the hole in the square drive.
- Push the pin through socket and square drive and seat the pin flush against the socket.
- Slide O-ring back on to keep the pin in place.

Installing HYTORC Accessories

Installing the HYTORC Washer Driver

- Identify the appropriate size of HYTORC Washer Driver.
- Slide the driver over the square drive and spline while aligning the screw with the spot face (circular indentation) on the spline.
- Tighten the screw to secure the driver. (For longer term use HYTORC recommends pinning the driver to the square drive.)
- Pull firmly on the driver to make sure it is securely attached.
- Contact your HYTORC rep for more accessory options.

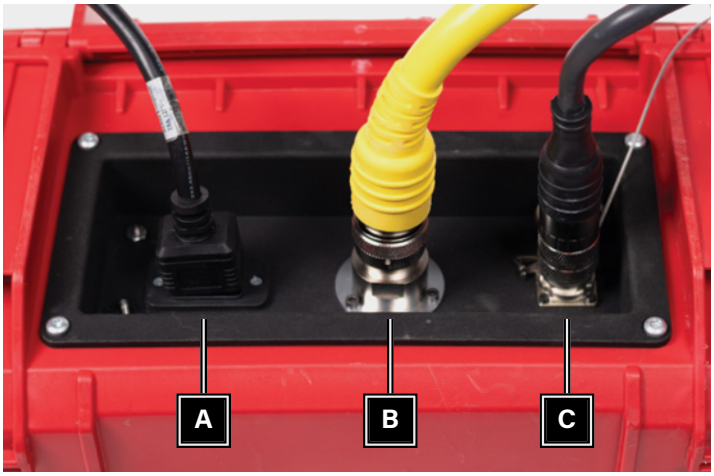
Installing the HYTORC Nut Driver

- Identify the appropriate size of HYTORC Nut Driver.
- Slide the driver over the square drive and spline while aligning the screw with the spot face (circular indentation) on the spline.
- Tighten the screw to secure the driver. (For longer term use HYTORC recommends pinning the driver to the square drive.)
- Pull firmly on the driver to make sure it is securely attached.
- Contact your HYTORC rep for more accessory options.

Before Powering on the Tool



Motor and signal cables plugged into toolhead.



(A) power cable, (B) motor cable, (C) signal cable.

- Plug cables into toolhead.
  - Remove caps from ports.
  - Motor cable (yellow) – Insert into the larger port with the yellow circle around it and twist to the right until the collar locks.
  - Signal cable (black) – Insert into smaller port and twist the collar to the right until the connection is hand tight.
  - Pendant (Optional Add-On)
    - Connect pendant by inserting it into the port on the toolhead or bottom of the HMI screen and twist the collar until it is hand tight.

- Plug cables into back of the control box.
  - Remove caps from ports.
  - Motor cable (yellow) – Insert into the larger port and twist to the right until the collar locks.
  - Signal cable (black)– Insert into the smaller port and twist the collar to the right until the connection is hand tight.
  - Power cable
    - Insert the power cable into the power port on back of control box.
    - Then insert the plug end of the power cable into an outlet (120V or 240V).

⚠ WARNING

- Do not plug the power cord into outlet receptor until all other cables have been plugged in to the control box and the toolhead.
- The power switch must be off when plugging cables in on both the case and the toolhead.
- Do not turn the tool on until all cables have been plugged in securely to both the control box and the toolhead.
- Do not unplug cables when the toolhead and control box is powered on.



Opening and Closing the Case

- Open - Turn the knobs on the latches counterclockwise until the line goes from horizontal (locked) to vertical (unlocked). Then pull up on the latches.



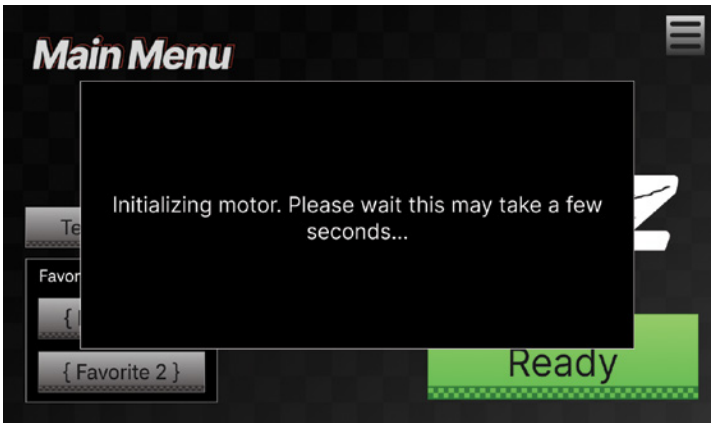
- Close - Push the latches down. Turn the knobs on the latches clockwise until the line goes from vertical (unlocked) to horizontal (locked).



Powering the Tool On and Off



Power On



Power Off

- Flip power switch up towards the hinges of the case.
- The screen will boot up. (This may take up to 40 seconds.)
- The toolhead LED light will turn purple and the fan will turn on.

After the "initializing motor" screen appears, the toolhead LED light will turn white.

- Flip power switch down towards the case handle.

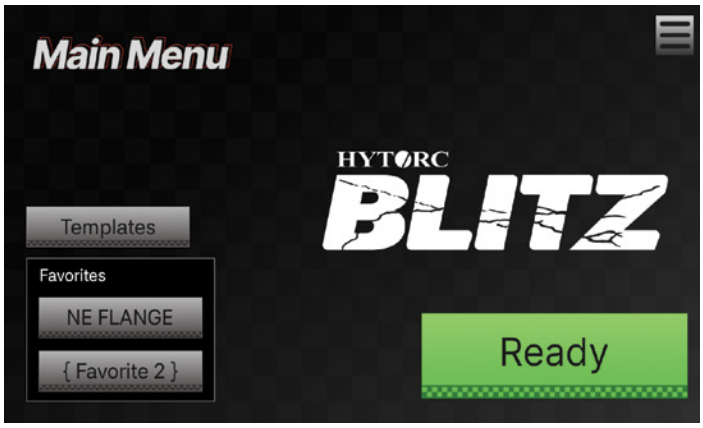
Icon Guide

Side Dropdown Menu		▶ Opens the Side Dropdown Menu.
Home		▶ Shortcut to the Home screen.
Keypad		▶ Brings up the keypad.
Increase Value		▶ Increases the values.
Decrease Value		▶ Decreases the values.
Nut Direction		▶ Shows the tool's current drive direction
Favorite - Selected		▶ Indicates a template has been favorited.
Favorite – Deselected		▶ Indicates that a template not been favorited.
Right-Hand Fastener		▶ Selecting this icon means the tool will tighten in a clockwise direction.
Left-Hand Fastener		▶ Selecting this icon means the tool will tighten in a counterclockwise direction.
HYTORC Nut		▶ Indicates the use of a HYTORC Nut, with the tool operating in a counterclockwise direction.
HYTORC Washer		▶ Indicates the use of a HYTORC Washer, compatible with both left- and right-hand functions.
Toggle		▶ Indicates a choice between two options.
Add Image		▶ Select to upload an image to use for a template.

Touchscreen Keypad and Keyboard

- Values can be changed using [ ] or by typing them on the keypad.
- After entering a value or text, click on [ ].
- To pull up the keypad, tap on the value directly instead of using [ ].
- When using [ ] (after using the keypad to input a value) the value should go up or down by a preset amount of 50 ft.-lbs.

Main Menu



At any time, click on [ ] to return to the Main Menu.

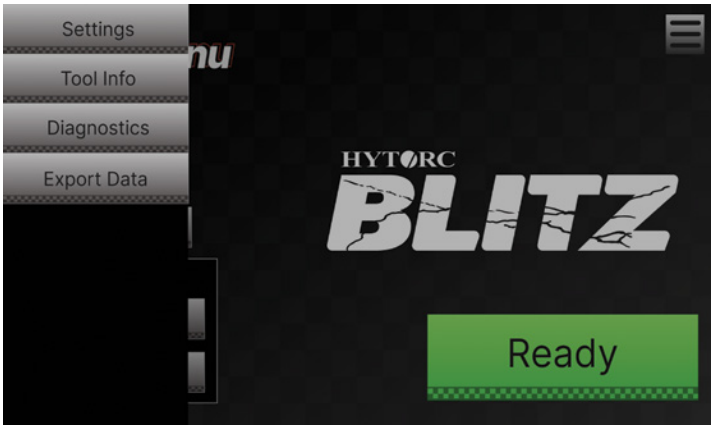
When the tool powers on it will take you to the Main Menu. The Main Menu should display the last used template and serial numbers for both the control box and the toolhead it is plugged into.



Main Menu with uncalibrated tool warning.

If the tool is not calibrated, you will see the message WARNING: UNCALIBRATED TOOL. Call your HYTORC rep to schedule tool calibration. Click on Close to go back to the Main Menu.

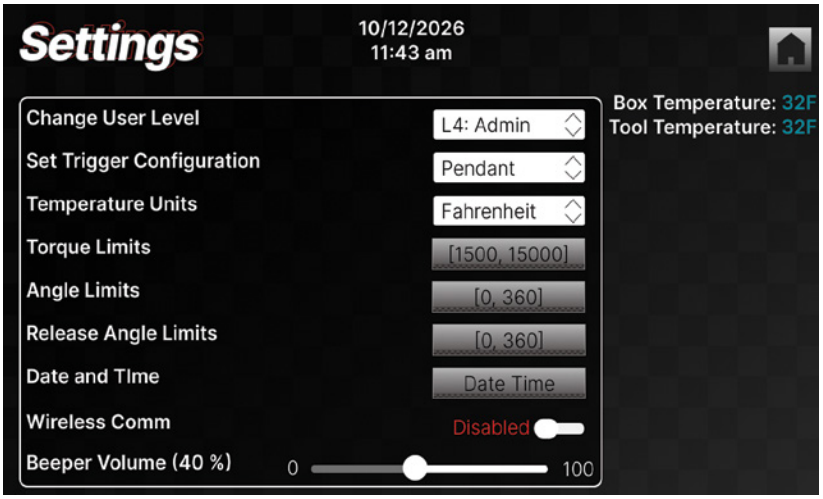
- READY: Takes you to the Quick Start screen
- TEMPLATES: Takes you to the Templates menu.
- FAVORITE 1: Displays "FAVORITE 1" if no template name is set. If a template has been saved, selecting it opens that template. If no template has been created, nothing will happen when you click on this.
- FAVORITE 2: Displays "FAVORITE 2" if no template name is set. If a template has been saved, selecting it opens that template. If no template has been created, nothing will happen when you click on this.
- Side dropdown menu: Click on [ ] on the top right to access the Settings, Tool Info, Diagnostics, and Export Data options.



Main Menu with the side menu open

Settings

From Main Menu screen, click on [☰] and then click on Settings.



Settings Menu (L4 Admin view) screen

Change User Level

- Use dropdown menu to choose user level.
  - L1: User- Only has access to pre-set templates. All values are locked and cannot be changed.
  - L4: Admin- Can access all menus (below Service level) and can create and edit templates.
  - L5: Service- HYTORC service users only. For password-only access, select L5 under the User Level dropdown.

Set Trigger Configuration

- Use the dropdown menu to choose from the options available.

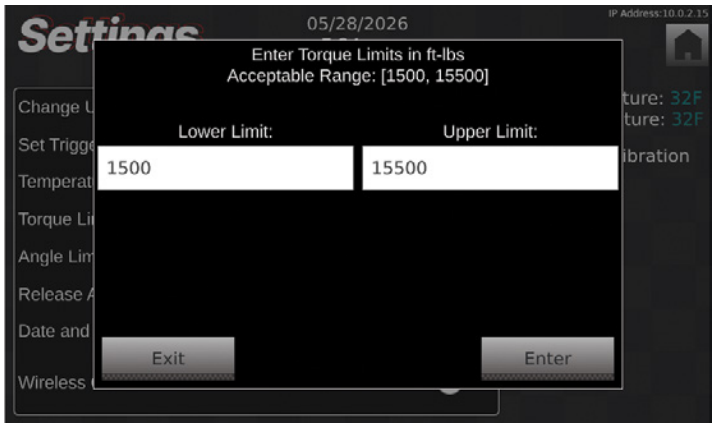
Temperature Units

- Use dropdown menu to choose Fahrenheit, Celsius, or Kelvin.

Torque Limit

Allows you to set a maximum torque value that the tool will not exceed. (This is set to the maximum torque value by default.)

- Click on Torque Limit, enter value(s), and then click Enter or Exit.



Entering torque limits screen

Angle Limit

Allows you to limit the angle that can be applied after torquing.

- Click on Angle Limit, enter values, and then click Enter or Exit.

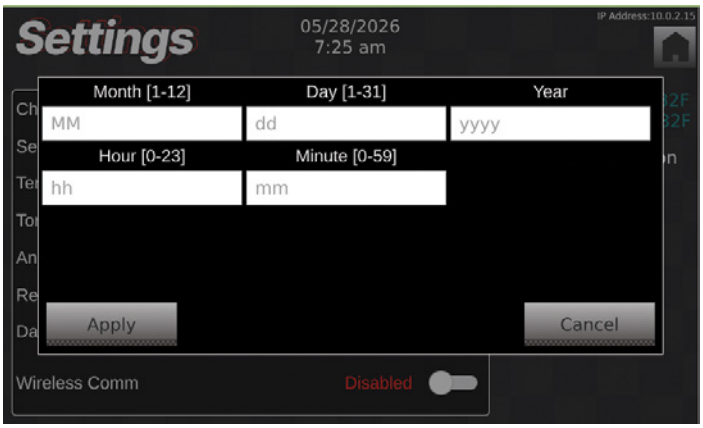
Release Angle Limit

Allows you to limit the release angle that can be applied after the torque or angle operation.

- Click on Release Angle Limit, enter values, and then click Enter or Exit.

Date and Time

- Click on Date and Time, enter values, and then click Enter or Exit.



Setting the date and time screen

Wireless Communications

This only works when a Bluetooth dongle is added to one of the USB drives. Dongle is not included. Please contact your HYTORC rep for purchase.

- Click on the toggle to enable or disable Wireless Communications.

Beeper

The beeper sounds after a bolting operation.

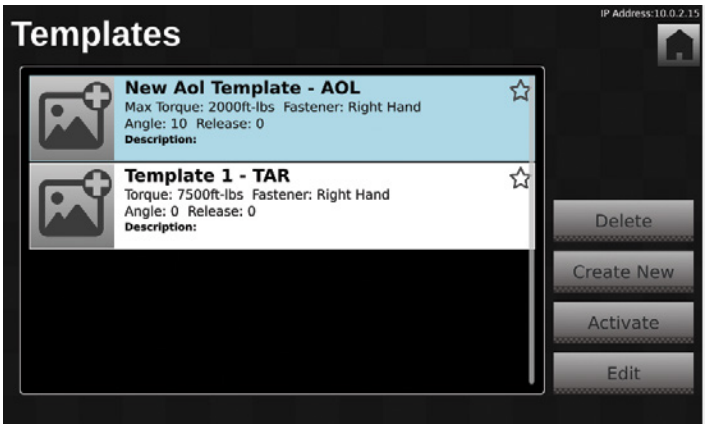
- Increase and decrease beeper volume by moving the slider back and forth.
- Setting the slider to 0% setting will turn off the beeper.
- Setting the slider to 100% will turn the beeper up to its maximum volume.

Templates

- A template is a reusable set of parameters that is stored in the tool and can be selected for a bolting task.
- Each template should have a name. Use the pop-up keyboard to create or edit a template name.
- Previously saved templates appear on the main Templates screen.
- Default template is set to 0 ft.-lbs.

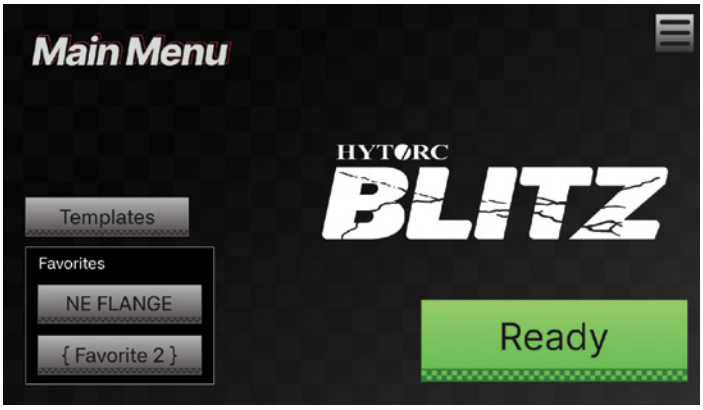
From the Main Menu, click on Templates.

- Favorites – Once you have created a template, tapping the star saves that template as a Favorite. It will be added to the Main Menu as a shortcut, replacing either Favorite 1 or Favorite 2.
- Delete – Click on this to delete a template.
- Activate – Applies the selected template to use for a bolting operation. Values cannot be changed at this stage.
- Edit – A box will pop up where you can edit the template.





Templates menu screen



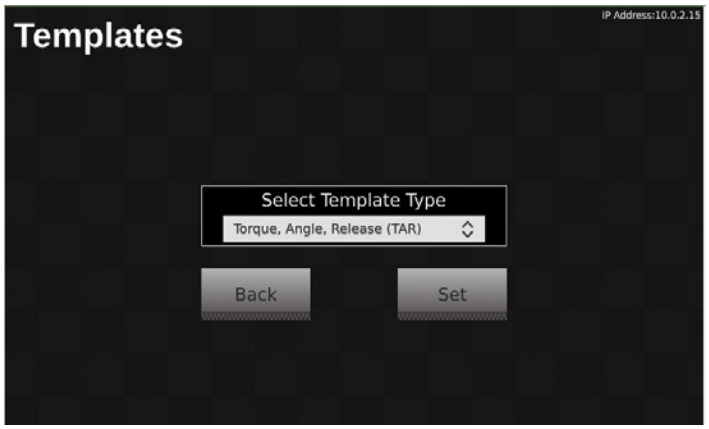
Main Menu showing Favorites menu with one named and one unnamed template

Create Template

- Click on CREATE NEW.
  - Choose template type from the dropdown menu - Torque, Angle, Release (TAR) or Angle Only (AOL) and press Set.
  - Click on Set.
  - Enter Template Title. This is the name that will appear on the control box screen.
  - Enter Torque, Angle, and/or Release values.
  - DESCRIPTION (Optional) - Enter description.
  - Choose fastener. (See section below for instructions).
  - Choose torque units. (See section below for instructions).

- Click on SAVE.
  - YES –Saves the template and adds it to the Templates list.
  - NO – Takes you back to the last screen.

- Favorites dropdown menu.
  - Basic – Template will not be favorited or starred.
  - Favorite 1 – This template will appear on Main Menu screen.
  - Favorite 2 – This template will appear on Main Menu screen.
- BACK – The screen will ask if you want to save your template before going back to the previous screen. Choose YES or NO.



Creating a new template



Dropdown menu for creating a new template

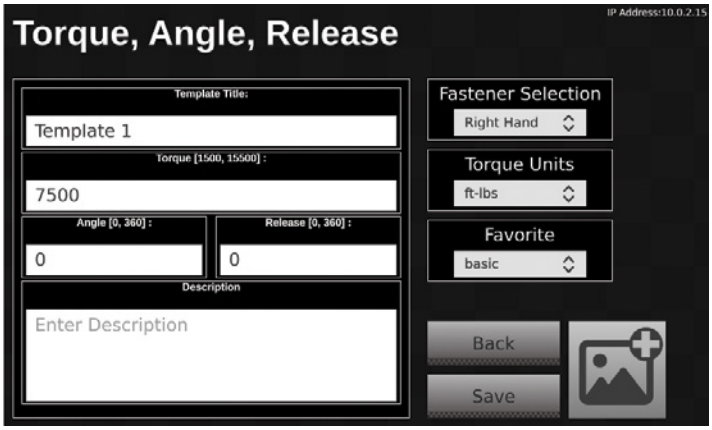
Edit Template

Go to the Templates menu and click on the template you want to edit.

- Use the keyboard to edit the template.
- Click on SAVE.
  - Click on YES to save or NO to go back to the Edit Template screen.
- BACK – The screen will ask if you want to cancel without saving. Choose YES or NO.



Editing an Angle Only template.



Editing a Torque, Angle, Release template.

Delete Template

- Go to Templates menu.
- Tap on the template to select it. It will turn blue.
- Click on Delete.
- A screen will pop up with two options - click YES to delete it or NO to keep it.

Set Image

Choose an image to be a template's thumbnail.

- Click [].
- Choose an image from the pop-up and click on it.
- Click X to exit.

Torque Units

- Use the dropdown menu to choose foot pounds (ft.-lbs.), Newton-meters (Nm), or kilogram force meter (kgf-m).

Fastener Type

Click on the dropdown menu and choose a default fastener type.

- This shows the default fastener type for bolting operations when you are not using a specific template. (If you are using a template, the tool will automatically adjust to use the fastener specified in that particular template.)
- DO NOT change the set fastener type during bolting operation when using a template. To change fastener type, go back and edit the template or create a new template.
- Right-hand (CW) – The drive turns in a clockwise direction.
- Left-hand (CCW) – The drive turns in a counterclockwise direction.
- HYTORC Nut (HN) – The HYTORC Nut turns in the counterclockwise direction by default.

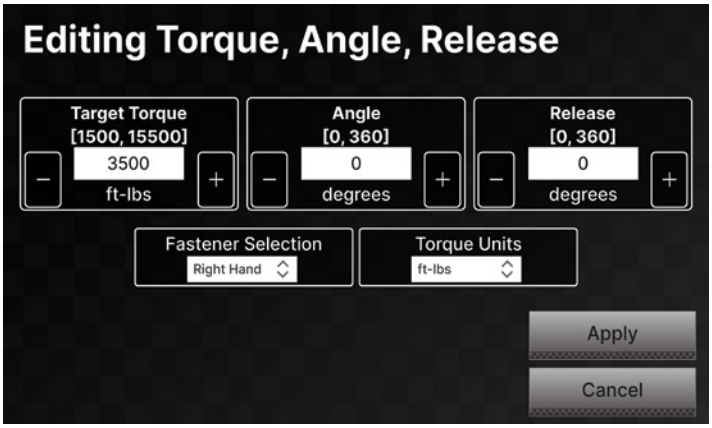
Tightening

Quick Start Bolting (Bolting Without Using a Template)

- From the Main Menu, click on READY. This will take you to the Quick Start screen.
- Move the directional switch on toolhead to the right (if you are facing the tool). The screen will now say Tighten.
- Choose EDIT VALUES.
  - Enter the desired values (type in the box or use [] and click on APPLY.
  - Click on CANCEL to stop editing. The screen will then go back to the Quick Start menu.
- Last Run Data – Click on Last Run Data to see the status of the most recently completed bolting operation.
  Note: Values for Angle and Release must not exceed the preset limits of the maximum or minimum amounts.
  - If a value entered here exceeds the maximum limit set for the tool, and the tool will reject the inputted value. The tool will default back to the closest acceptable value.



Quick Start screen



Edit values screen (Target Torque, Angle, Release, Fastener Selection, Torque Units)

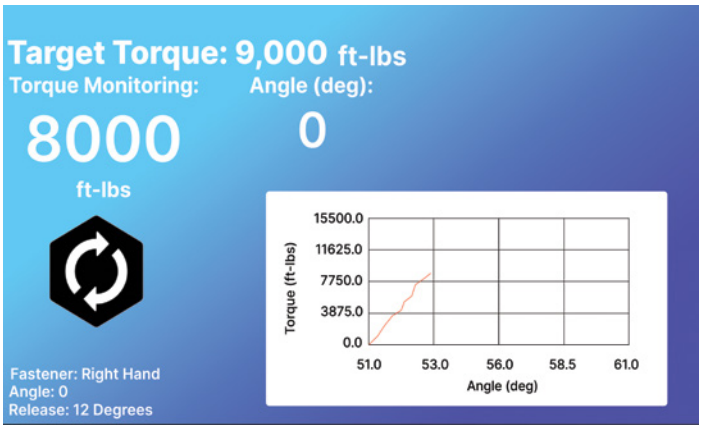
- Activate the tool using the previously specified trigger configuration.
  - Tool trigger activation method corresponds to the Trigger Configuration set earlier.
  - Handlebar
    - Side Lift Switch Adapter: (Default trigger configuration.) Push the right-hand switch on the handlebar until the bolting operation is finished.
    - LH Handlebar Switch Assembly (Optional Add-On): Push and hold both switches on the handlebar at the same time until the bolting operation is finished.
- Pendant (Optional Add-On.): Push and hold pendant button until the bolting operation is finished.



NOTE

TOOL TRIGGER ACTIVATION METHOD CORRESPONDS TO THE TRIGGER CONFIGURATION SET EARLIER.

- Screen color will be blue while bolting is in progress.
- A graph on the screen during tool operation shows a live torque readout. This allows you to see if the bolt is yielding.



Tightening screen with live torque graph (screen is blue).

- Toolhead LED color is BLUE and will rotate clockwise (if you are facing the tool).
- A success or failure screen will appear at the end of the operation.
  - Green – The operation was successful.
  - Red – The operation failed.
- Last Run Data – Click to see the status of the most recently completed bolting operation.



Last Run Results screen

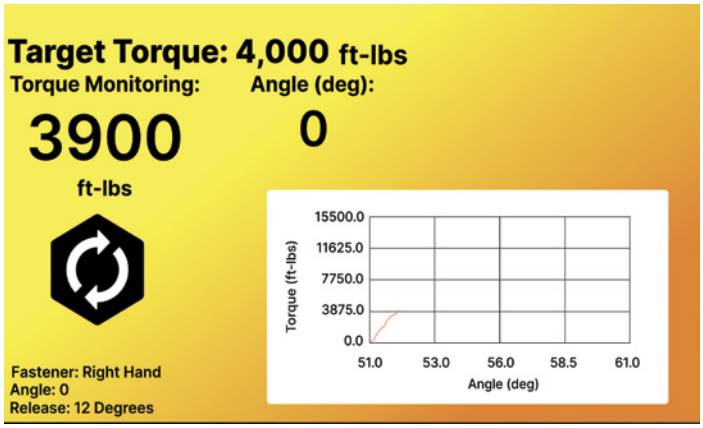
Note: Torque value should not exceed the maximum torque value registered or go below minimum torque value registered.

Bolting Using an Existing Template

- Move the directional switch on toolhead to the right (if you are facing the tool).
- From Main Menu, click on Templates.
- From the Templates menu, click on a template to choose it and then click ACTIVATE.
- Activate tool using the trigger specified in the template.
  - Tool trigger activation method corresponds to the Trigger Configuration set earlier.
  - Handlebar
    - Side Lift Switch Adapter: This is the default trigger configuration. Push the right-hand switch on the handlebar until the bolting operation is finished.
    - LH Handlebar Switch Assembly (Optional Add-On): Push and hold both switches on the handlebar at the same time until the bolting operation is finished.
  - Pendant (Optional Add-On): Push and hold pendant button until the bolting operation is finished.
- Screen color will be blue while bolting is in progress.
- Toolhead LED color is BLUE and will rotate clockwise (if you are facing the tool).
- A success or failure screen will appear at the end of the operation.
  - Green – The operation was successful.
  - Red – The operation failed.
- Last Run Data – Click to see the status of the most recently completed bolting operation.

Loosening

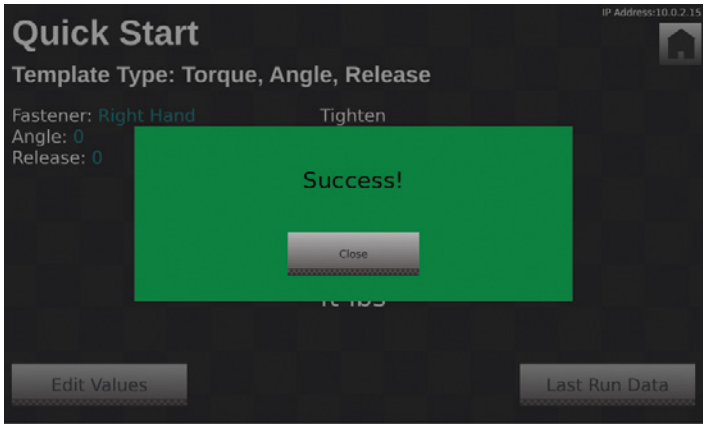
- Move the directional switch on toolhead to the left (if you are facing the tool). The screen will now say Loosen.
- Activate tool trigger.
  - Tool trigger activation method corresponds to the Trigger Configuration set earlier.
  - Handlebar
    - Side Lift Switch Adapter: This is the default trigger configuration. Push the right-hand switch on the handlebar until the loosening operation is finished.
    - LH Handlebar Switch Assembly (Optional Add-On): Push and hold both switches on the handle at the same time until the loosening operation is finished.
  - Pendant (Optional Add-On): Push and hold pendant button until the loosening operation is finished.
- Screen color will be yellow during the loosening operation.
- Toolhead LED color is BLUE and will rotate counterclockwise (if you are facing the tool).
- The tool will loosen at maximum capacity.



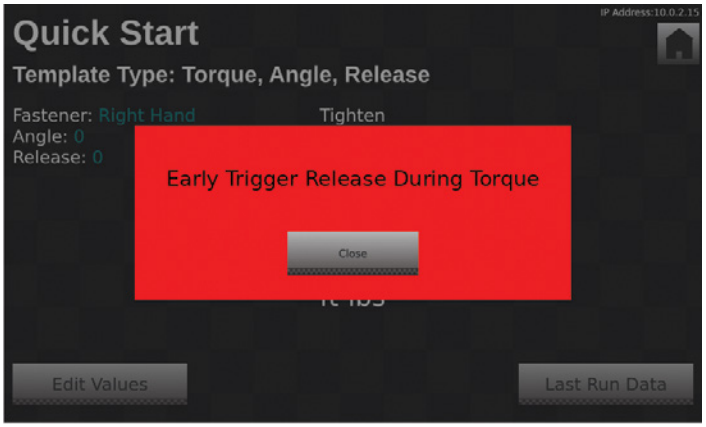
Loosening screen with live torque graph (screen is yellow)

Success and Failure Screens

- After the end of a bolting operation, you will see either a Success screen or a Failure screen.
- The error type will be displayed in the red box at the center of the screen. It will also be reflected in the final data. (See Appendix for error list.)



Success screen.



Failure screen.

Last Run Results screen

Last Run Results Screen

This appears after bolting is complete. It shows relevant information measured during the operation.

- Click on Close to dismiss Last Run Results screen.

- The data from this operation will be saved to the toolhead's internal memory and to the control box. It can be retrieved via USB or Bluetooth connection.

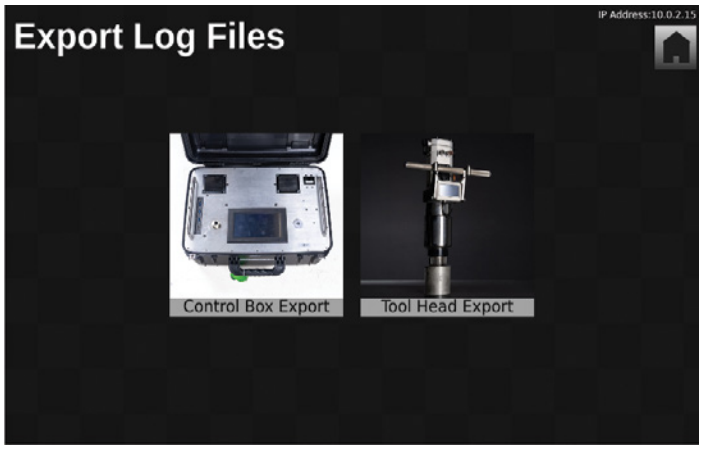


Last Run Results Screen



Export Data

You must insert a USB drive to export files.

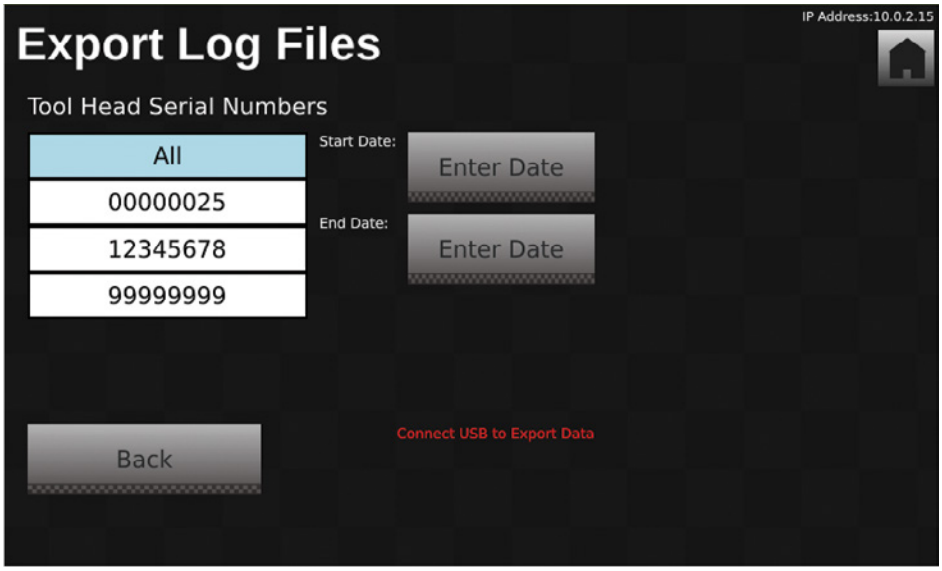


Export Log Files screen

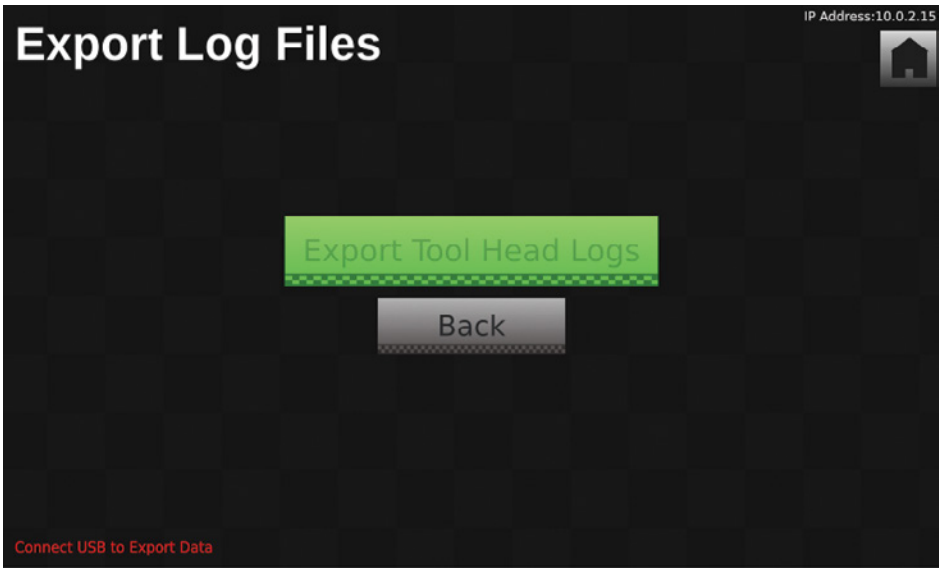
- From Home screen, click [☰].
- Click on Export Data.
- After selecting Export Data, you can choose to export from the two locations where that data is stored – the control box and the toolhead.

  Control box data export - Exports data saved on this specific control box. This is data from any job done using that control box, regardless of toolhead.
  - Click on Control Box Export. You have two options:
    1. All data sets: Choose ALL to download job data from all toolheads used this specific control box.
    2. Select data sets: Select the serial number for the associated toolhead(s) you want to export data for.
  - Enter start date.
  - Enter end date.
  - Click on USB Export.

  Toolhead data export - Exports data saved within the physical toolhead itself.
  - Click on Toolhead Export.
  - Click on Export Toolhead Logs.
    If nothing is selected, then all job data will be downloaded by default.



Control box data export screen



Toolhead data export screen



5

APPENDIX: FAILURE AND ERROR CONDITIONS

5. Appendix: Failure and Error Conditions

SCREEN	CONDITION
CRITICAL ERRORS	**ERRORS THAT WILL PREVENT THE TOOL FROM RUNNING.**
Toolhead Serial Communication Error	Cable communications error on the toolhead.
Motor Drive Serial Communication Error	Cable communications error on the motor drive board.
Motor Drive Under/Over Voltage	Voltage on motor drive is not within acceptable range.
Motor Drive Over Current	Electrical current on motor drive is above acceptable threshold.
Motor Drive broken PWM/DIR wire	PWM/DIR cable has malfunctioned or disconnected.
Motor Drive Phase Detect Error	Motor drive start-up operations incomplete.
Toolhead Invalid Direction	Directional switch is not fully engaged to tighten or loosen.
CRITICAL ERRORS	Errors that will prevent the tool from running.
Toolhead Serial Communication Error	Cable communications error on the toolhead.
Motor Drive Serial Communication Error	Cable communications error on the motor drive board.
Motor Drive Under/Over Voltage	Voltage on motor drive is not within acceptable range.
Motor Drive Over Current	Electrical current on motor drive is above acceptable threshold.
Motor Drive broken PWM/DIR wire	PWM/DIR cable has malfunctioned or disconnected.
Motor Drive Phase Detect Error	Motor drive start-up operations incomplete.

RESULT ERRORS	**ERRORS THAT OCCUR DURING THE TIGHTENING PROCESS.**
Torque Out Of Range	The chosen template has torque that is higher than the set torque limit.
Early Trigger Release	Operator has released the button(s) before bolting operation was completed.
Motor Has Stalled	Motor slowed down unexpectedly or was unable to power up sufficiently.
Toolhead Temperature Too High	Temperature of the tool is too high for it to run effectively.
Toolhead Temperature Too Low	Temperature of the tool is too low for it to run effectively.
Uncalibrated Tool	Operation attempted without proper calibration.
Exceeded Maximum Allowed Value	User has entered a value that exceeds the set limits.
All Run Parameters Set to Zero	Torque, angle and release are all set to 0, so there is nothing for the tool to run.
Low Input Power	Power supply connected to the tool is below a certain threshold and cannot power the toolhead.
PFC Input Voltage Too Low	Input voltage to the control box power supply (PFC) is below the level needed to run the tool.
Maintenance Required	Tool needs maintenance. Contact HYTORC.
Transducer Failure	Toolhead reported transducer failure.
Toolhead Trigger Failure	Toolhead reported a fault with the trigger input (pendant or handlebar buttons).
Torque has reached limit for this tool	Measured torque on toolhead exceeds upper torque limit.
Run Aborted	Run was aborted.
Operation Stopped for Unknown Reason	Received unknown completion code from toolhead.
Toolhead Serial Communication Error	HMI detected communication error with toolhead.
Motor Drive Serial Communication Error	HMI detected communication error with motor drive.
Motor Drive Phase Detect Error	Motor drive failed to complete phase detect.
Motor Drive Over Current	Motor drive read over current.
Error Preventing Tightening Operations	Active "no tighten" error.

CHANGELOG

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HYTORC

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