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TITLE OF THE INVENTION
METHOD OF TIGHTENING THREADED MEMBERS

BACKGROUND OF THE INVENTION

The present invention relates to a threaded member
5 tightening method of simultaneously tightening up a
plurality of threaded members such as hexagon socket
head bolts, hexagon head bolts and nuts, and more
particularly to a method of tightening up threaded
members which method is suitable for tightening up
10 threaded members for installing, for example, massflow
controllers which are to be provided in gas control
apparatus for fabricating semiconductors and which must
be held highly gastight.

Controllers such as massflow controllers which
15 are provided in such gas control apparatus for
fabricating semiconductors and which need to be given
high air- or gas-tightness include a member fastened to
a base plate with four bolts having a hexagon socket
head and arranged on one side of the member, usually
20 with a gasket or like seal disposed between the butting
faces. If the bolt tightening torque is too weak, a
faulty seal will result, whereas excessive torque
deforms the gasket to entail an improper seal, so that
each bolt needs to be tightened up with proper torque.

Further if one bolt only is tightened with a greater force than the other bolts to result in uneven fastening, the gasket will be deformed to produce a faulty seal. The bolts must therefore be tightened up equivalently. In installing the massflow controller, accordingly, the following tightening method is used. The bolts are first tightened manually, and one of the four bolts is then tightened with a wrench by a fraction of the required or specified amount of tightening. Next, the second bolt, which is positioned diagonally of the first bolt, is tightened by the same amount, the third bolt adjacent to the second bolt is subsequently tightened by the same amount, the fourth bolt positioned diagonally of the third bolt is tightened by the same amount, and the first bolt is thereafter tightened to repeat the same procedure as above. Thus, the bolts are tightened equivalently by a small amount at a time and eventually screwed up by the specified amount.

20 The following problems are encountered in the conventional method of tightening up threaded members using a wrench for hexagon head bolts.

1. The work of turning the bolts individually by a small amount at a time is cumbersome.

2. The amount the bolt is tightened at a time, if increased, facilitates the tightening work but
5 increases the possibility of deforming the gasket by uneven fastening, hence increased likelihood of making the seal faulty.

3. Although the angle through which the bolt is to be rotated by the wrench after manual tightening is
10 predetermined, the accuracy of the angle of rotation is insufficient because of the manual work involved. This entails the likelihood that the bolt will not be tightened up by the proper amount to cause a fault in the seal.

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SUMMARY OF THE INVENTION

An object of the present invention is to provide a method of tightening up threaded members, for example, for use in installing a massflow controller which is to be provided for a gas control apparatus for producing
20 semiconductors and which needs to be held highly gastight, the method being adapted to tighten up threaded members with proper torque without necessitating the cumbersome procedure of rotating the threaded members one by one through a specified small
25 angle at a time and free of the likelihood of producing

a faulty seal.

The present invention provides a method of tightening up a plurality of threaded members by drive means, the method being characterized by tightening
5 each of the threaded members while detecting the amount of tightening of the threaded member and the tightening torque thereof, stopping tightening upon the amount of tightening of each threaded member reaching a specified value based on the time when the tightening torque
10 reaches a predetermined value, and judging each threaded member to be properly tightened when the tightening torque of the threaded member is within a predetermined range, with the difference in tightening torque between the threaded members within a
15 predetermined range.

The threaded member tightening method of the invention assures that each of the threaded members as tightened is at a proper absolute level by judging that the tightening torque of the threaded member is within
20 a predetermined range upon the amount of tightening (e.g., the number of revolutions) of the threaded member reaching a specified value. The method further assures that the threaded members are equivalently tightened by judging whether the difference in
25 tightening torque between the threaded members is

within a predetermined range. Consequently, only when the absolute level of each threaded member is within the specified limits without giving rise to unequivocal tightening or uneven fastening, the threaded members are judged to be properly tightened and can therefore be tightened up at the same time. Accordingly, the threaded members can be tightened up with proper tightening torque without necessitating the cumbersome procedure of rotating the threaded members one by one by a small amount at a time, with uneven fastening precluded.

The specified value for the amount of tightening is smaller than a proper value for the final amount of tightening. Preferably, the control means for the method has main tightening means for finally tightening up each threaded member to the proper value when the threaded member is judged to be properly tightened. Faults in tightening can then be detected early to discontinue the tightening operation before the seal member, for example, is broken.

The present invention provides a method of tightening up a plurality of threaded members by drive means, the method being characterized by tightening each of the threaded members while detecting the amount of tightening of the threaded member and the tightening

torque thereof, stopping tightening upon the tightening torque of each threaded member reaching a predetermined value with the amount of tightening within a specified range, and judging each threaded member to be properly
5 tightened when the difference in tightening amount between the threaded members is within a specified range.

The threaded member tightening method of the invention assures that each of the threaded members as
10 tightened is at a proper absolute level, by completing tightening upon the tightening torque of the threaded member reaching a predetermined value with the amount of tightening within a specified range. The method further ensures that the threaded members are tightened
15 equivalently by judging whether the difference in tightening torque between the threaded members is within a predetermined range. Consequently, only when the absolute level of each threaded member is within the specified limits without giving rise to
20 unequivalent tightening or uneven fastening, the threaded members are judged to be properly tightened and can therefore be tightened up at the same time. Accordingly, the threaded members can be tightened up with proper tightening torque without
25 necessitating the cumbersome procedure of rotating the

threaded members one by one by a small amount at a time, with uneven fastening precluded.

The predetermined value for the tightening torque is smaller than a proper value for final tightening torque. Preferably, the control means for the method further comprises main tightening means for tightening up each threaded member until the proper final torque value is reached when the threaded member is judged to be properly tightened. Faults in tightening can then be detected early to discontinue the tightening operation before the seal member, for example, is broken.

The number of threaded members to be tightened up by the method described above may be two, three or at least four. A plurality of threaded members may be rotated all at the same time, one by one, or two of them at a time. The cumbersome work of rotating at least two threaded members one by one by a small amount at a time can be eliminated by rotating these threaded members at the same time.

When a plurality of threaded members are to be tightened up at the same time, all the threaded members are tightened at the same time. When the tightening torque on one of the members has reached the predetermined value with the tightening amount within

the specified range, it is desired to stop tightening the member at this moment. This obviates the likelihood that one the threaded members will be overtightened, making it possible to tighten up the threaded members more equivalently.

When at least four threaded members are to be tightened up, it is desired to divide these threaded members into sets of at least two and to tighten up each of the sets by the method described. At least four threaded members can then be tightened up by using the tightening method employed for tightening two threaded members at the same time. This permits use of a simpler judging or checking program than when at least four threaded members are tightened at the same time.

When four threaded members are to be tightened up, it is desired to divide these threaded members into a set of two members positioned diagonally and a set of two members positioned diagonally reversely. At this time, the threaded members are tightened preferably by pretightening two diagonally positioned members by a specified amount first, then pretightening the other two members positioned diagonally reversely by a specified amount, thereafter rotating the first two members to a specified final range for main tightening

and finally rotating the other two members to a specified final range for main tightening. In this way, the threaded members can be progressively tightened up more equivalently than when the first two
5 members are tightened up to the final extent at a time.

It is desired that a judgment of abnormality be made to discontinue tightening upon the tightening torque of one of the threaded members exceeding the predetermined value before the amount of tightening of
10 the threaded member reaches a specified lower limit. It is also desired to make a judgment of abnormality to discontinue tightening when the tightening torque of one of the threaded members is below the predetermined value even if the amount of tightening of the threaded
15 member reaches a specified upper limit.

Furthermore, the tightening operation may be divided into a plurality of steps, each of which is executed by the threaded member tightening method described.

20 BRIEF DESCRIPTION OF THE DRAWINGS

FIG. 1 is a perspective view partly broken away and showing a method of tightening threaded members according to the invention;

FIG. 2 is a flow chart showing the primary routine
25 of tightening up bolts by the method of the invention

in a bolt revolution number control mode;

FIG. 3 is a flow chart of a pretightening routine of the same;

FIG. 4 is a flow chart of a main tightening
5 routine of the same;

FIG. 5 is a graph of the relationship between the bolt revolution number and the bolt torque to show an overall checking procedure in the same mode;

FIG. 6 is a flow chart of the primary routine of
10 tightening up bolts by the method of the invention in a bolt tightening torque control mode;

FIG. 7 is a is a flow chart of a pretightening routine of the same;

FIG. 8 is a flow chart of a main tightening
15 routine of the same; and

FIG. 9 is a graph of the relationship between the bolt revolution number and the bolt torque to show an overall checking procedure in the same mode.

DESCRIPTION OF THE PREFERRED EMBODIMENTS

20 Embodiments of the invention will be described below with reference to the drawings. In the following description, the term "forward end" refers to an end closer to the threaded member to be tightened up, and the term "base end" to the other end.

25 FIG. 1 shows an example of device for use in the

threaded member tightening method of the invention.

The tightening device 1 is used for tightening up and loosening threaded members such as hexagon socket head bolts 44 for installing a massflow controller 42 for use in a gas control apparatus 41 shown in FIG. 1. The massflow controller 42 has a seal comprising a gasket 43. Flanges 42a provided respectively at opposite sides of the controller 42 are each formed with four tapped bores 45, in which four hexagon socket head bolts 44 are screwed. The tightening device 1 is adapted to simultaneously tighten up two of the four bolts 44 which are positioned diagonally.

The device 1 comprises a body 2, right and left motors 3 disposed inside the body 2, a spur gear 4 attached by a joint 5 to the forward end of the drive shaft 3a of each motor 3, right and left rotary shafts 6 each carrying at its base end a pinion 7 in mesh with the spur gear 4, right and left wrench portions 8 provided at the forward ends of the respective shafts 6, and a control unit 9 disposed inside the body 2 for controlling the motors 3. The body 2 is rectangular parallelepipedal and has a base end wall 2a, which is provided with a handle 23, connector 24, forward-reverse change-over switch 25 and on-off button switch 26. Play is provided between the spur gear 4 and the

drive shaft of the motor 3 for permitting the gear 4 to idly rotate slightly relative to the motor shaft. The right and left rotary shafts 6 extend through the forward end wall 2b of the body 2 and are each

5 rotatably supported at a portion thereof close to its based end by the forward end wall 2b of the body 2. A bearing portion 10 accommodating the opposite shafts 6 is joined to the forward end wall 2b of the body 2. Each rotary shaft 6 has at its forward end a small-

10 diameter portion 11 coaxial with the shaft 6. Since the spur gear 4 plays relative to the drive shaft of the motor 3, the rotary shaft 6 starts to rotate a short period of time after the start of rotation of the motor shaft, following the rotation of the motor shaft.

15 The wrench portion has at its forward end a hexagonal prism 18 shaped in cross section in conformity with the hexagon socket of the bolt 44. The wrench portion 8 is connected to the rotary shaft 6 by stepped bolts 21 axially movably. The hexagonal prism 18 of the wrench

20 portion 8 is provided with a bolt holder 22 comprising three plate springs. The hexagon socket head of the bolt 44 can be held by the bolt holder 22. The control unit 9 comprises, for example, a microcomputer and controls the motors 3 while judging whether each bolt

25 44 as tightened is at a proper level and also checking

the bolts 44 for relative level to judge whether the bolts are equivalently tightened.

The angle of rotation of the bolt 44 or the displacement thereof is used as the amount of tightening of the threaded member. The angle of rotation of the bolt 44 can be determined, for example, by an encoder. The rotational angle of the bolt 44 can of course be determined from the angle of rotation of the rotary shaft 6. Alternatively, the angle of rotation can be detected by using a potentiometer and converting an analog signal to an angle. The displacement of the bolt 44 can be determined by measuring the distance between the bolt 44 and the massflow controller 42 with a potentiometer, eddy current displacement sensor, laser displacement sensor or the like. The tightening torque can be determined by using a strain gauge affixed to the rotary shaft 6 and converting the strain of the shaft 6 by a tightening torque detector. Alternatively, the tightening torque can be determined by a magnetostrictive torque sensor. Further alternatively, the tightening torque can be calculated from the current for driving the motor 3 utilizing the fact that the current exhibits the same tendency as the tightening torque on a graph.

FIGS. 2 to 4 are flow charts showing one mode of practicing the method of tightening up four bolts arranged at four corners of the member to be fastened using the tightening device 1 (bolt revolution number control mode). FIG. 5 shows the relationship between the bolt revolution number and the bolt torque, as established for two bolts positioned diagonally and each provided with a spring washer when the bolts were tightened up normally.

With reference to FIG. 5, the bolt is tightened with constant small torque after the bolt starts to rotate and until the bolt comes into contact with the spring washer. Upon the bolt coming into contact with the spring washer, the torque increases with an approximately constant gradient until the bolt intimately contacts the surface of the member to be fastened (flange). Upon the bolt coming into intimate contact with the flange, the gradient of torque increases, and the torque thereafter increases with the same gradient. Suppose the proper tightening torque upon the bolt coming into intimate contact with the flange is 10 kgf·cm, and the proper tightening torque at the time of complete tightening is 30 kgf·cm.

With reference to FIG. 2, the primary routine of the tightening method in the bolt revolution number

control mode will be described first.

First, the hardware of the microcomputer is initialized to set the parameters, ports and memory for the start of operation (step 1). The start key is then
5 pressed (step 2) to pretighten two of the four bolts which are positioned diagonally (step 3). In step 3, a bolt pretightening revolution number and start-point torque are set first (step 4). Specified as the start
10 point torque is a torque value immediately after the tightening torque starts to increase upon the bolt coming into contact with the spring washer. The predetermined bolt pretightening revolution number is based on, and counted from, the revolution number
15 giving this torque value and is a revolution number that brings the bolt into intimate contact with the flange (see FIG. 5). Subsequently based on the pretightening routine to be described below, the bolts in the diagonal position are checked as to whether they are pretightened properly (step 5).

20 When the bolts positioned diagonally (diagonal bolts) are judged to be pretightened properly, the tightening device 1 is removed from the diagonal bolts and then fitted to the other bolts positioned along the other or reverse diagonal line (reverse diagonal
25 bolts). When the start key is then pressed (step 6),

the reverse diagonal bolts are pretightened (step 7). Step 7 is similar to step 3; a bolt pretightening revolution number and start-point torque are set first (step 8). According to the pretightening routine, the
5 reverse diagonal bolts are checked as to whether they are pretightened properly (step 9). Since the reverse diagonal bolts differ from the first diagonal bolts in tightening torque curve, the bolt pretightening revolution number and the start-point torque set are
10 values determined for reverse diagonal bolts by actual tightening.

When the reverse diagonal bolts are completely pretightened, the device 1 is removed from these bolts and fitted to the first diagonal bolts. Depression of
15 the start key (step 10) is followed by the main tightening of the diagonal bolts in accordance with the main tightening routine to be described below (step 11). The device 1 is then removed from the first diagonal bolts and set on the reverse diagonal bolts.
20 Depression of the start key (step 12) is followed by the main tightening of the reverse diagonal bolts according to the main tightening routine, whereby a sequence of tightening operations is completed for the four bolts (step 13). Step 2 follows again to repeat
25 the foregoing steps when another set of four bolts are

to be tightened up.

In the foregoing process, the bolt is rotated at a high speed for pretightening and at a low speed for main tightening. In the pretightening operation, the first half of the operation may be effected at a high speed, and the second half thereof at a low speed. Although the torque value at a time immediately after the tightening torque starts to increase following the contact of the bolt with the spring washer is selected as the predetermined start-point torque, the predetermined torque may be the value at the time when the bolt is engaged in the tapped bore or the value given when the bolt has been rotated by one turn or two turns.

Next, the pretightening routine of the tightening method will be described with reference to FIG. 3.

First, bolt (1) and bolt (2) are rotated at a high speed for the start of tightening, and flags for torque (1), torque (2), revolution number (1) and revolution number (2) are reset (step 21). The flags for torque (1) and torque (2) are set when the torque of bolt (1) and bolt (2) reaches a value not smaller than the predetermined start-point torque. The flags for revolution number (1) and revolution number (2) are set when bolt (1) and bolt (2) are rotated at least to the

predetermined pretightening revolution number.

Next, the flag for torque (1) is checked as to whether it is set (step 22). When the flag is found to be set, whether the flag for torque (2) is set is
5 checked (step 23). If the flag for torque (2) is found to be on, this is interpreted as indicating that bolt (1) and bolt (2) are both at the start point, and the sequence proceeds to step 30. If the flag for torque (1) is not found to be on in step 22, the torque of
10 bolt (1) is read (step 27) and checked as to whether it is not smaller than the predetermined start-point torque (step 28). When the torque is found to be not smaller than the start-point torque in step 28, the flag for torque (1) is set, and tightening of bolt (1)
15 is discontinued (step 29), followed by step 23. If the torque of bolt (1) is found to be smaller than the start-point value in step 28, step 23 directly follows. If the flag for torque (2) is not found to be set in step 23, the torque of bolt (2) is read (step 24) and
20 checked as to whether it is not smaller than the start-point value (step 25). If the torque of bolt (2) is found to be at least the start-point value in step 25, the flag for torque (2) is set, and tightening of bolt (2) is discontinued (step 26), followed by step 22. If
25 the torque of bolt (2) is found to be smaller than the

start-point value in step 25, step 22 directly follows.

Upon the torque of one of the bolts reaching the predetermined value in the foregoing steps 22 to 29, tightening of that bolt is discontinued, and the other
5 bolt is continuously tightened until the predetermined torque value is reached. With the two bolts thus tightened with the predetermined torque, the sequence proceeds to step 30 and the following for pretightening on the basis of the bolt revolution number.

10 In step 30 et seq., an inquiry is made as to whether the flag for revolution number (1) is set (step 30). If the answer is negative, tightening of bolt (1) is started (step 31), and the number of revolutions of bolt (1) is read (step 32). An inquiry is made as to
15 whether the number is at least the predetermined pretightening revolution number (step 33). When the answer to the inquiry is affirmative, bolt (1) is judged to be pretightened normally, the flag for revolution number (1) is set, and the tightening of
20 bolt (1) is discontinued (step 34), followed by step 35. When the flag for revolution number (2) is not found to be set in step 35, step 36 starts to tighten bolt (2), and the number of revolutions of bolt (2) is read (step 37). An inquiry is made as to whether the
25 number is at least the predetermined pretightening

revolution number (step 38). When the answer is affirmative, bolt (2) is judged to be pretightened normally, the flag for revolution number (2) is set, and tightening of bolt (2) is discontinued (step 39),
5 followed by step 30. If the flag for revolution number (2) is found on in step 35, this is interpreted as indicating that the pretightening revolution number (absolute level) of each of bolts (1), (2) is within a predetermined range, followed by checking as to whether
10 the bolts are tightened normally. First, an inquiry is made as to whether torque (1) is within a predetermined range (step 40). If the answer is negative, torque abnormality is indicated (step 42), and the routine is changed over to a manual mode routine (step 49). If
15 the answer is affirmative, an inquiry is made as to whether torque (2) is within the predetermined range (step 41). When the answer is negative, torque abnormality is indicated (step 42), followed by a change-over to the manual mode routine (step 49). When
20 torque (1) and torque (2) are both within the predetermined range, torque (1) is compared with torque (2) (step 43). In the case where torque (1) is greater, torque (2) is subtracted from torque (1) to calculate the torque difference ΔT (step 44). If
25 torque (1) is not greater than torque (2), torque (1)

is subtracted from torque (2) to calculate the torque difference ΔT (step 45). An inquiry is then made as to whether the torque difference ΔT is within a predetermined range (step 46). When the answer is affirmative, this is interpreted as indicating that the bolts are tightened properly, and the sequence comes to an end (step 47). If the answer is negative, the bolts are judged to be tightened unequivalently, and an unequivalent tightening error is indicated (step 48), followed by a change-over to the manual mode routine (step 49).

Upon the torque of one of the bolts reaching the predetermined revolution number first in the foregoing steps 30 to 39, tightening of that bolt is discontinued, and the other bolt is continuously tightened until the predetermined revolution number is reached. With the two bolts thus tightened at least to the predetermined revolution number, the sequence proceeds to step 40 and the following.

Next, the main tightening routine of the present tightening method will be described with reference to FIG. 4.

First, bolt (1) and bolt (2) are rotated at a low speed for the start of tightening, and flags for revolution number (1) and revolution number (2) are

reset (step 51). The flags for revolution number (1) and revolution number (2) are set when bolt (1) and bolt (2) are rotated at least to the predetermined main tightening revolution number. This number is an
5 eventual bolt tightening revolution number based on and counted from the bolt pretightening revolution number. The flag for revolution number (1) is checked as to whether it is set (step 52). If the flag for
revolution number (1) is found to be on in step 52, the
10 flag for revolution number (2) is checked as to whether it is on (step 53). If it is found to be on in step 53, the bolts are judged to be tightened properly to terminate the routine.

In the case where the flag for revolution number
15 (1) is not found to be on in step 52, revolution number (1) of bolt (1) is read, and an inquiry is made as to whether the number is at least the main tightening revolution number (step 58). If the answer is
affirmative, main tightening of bolt (1) is judged to
20 be effected normally, tightening of bolt (1) is discontinued (step 59), the flag for revolution number (1) is set (step 60), and step 53 follows to check whether the flag for revolution number (2) is set. If
the revolution number (1) is smaller than the main
25 tightening revolution number, bolt (1) is continuously

tightened, followed by step 53 to check whether the flag for revolution number (2) is set. If the flag is not found to be on in step 53, revolution number (2) of bolt (2) is read, and an inquiry is made as to whether this number is at least the main tightening revolution number (step 55). If the answer is affirmative, main tightening of bolt (2) is judged to be effected normally, tightening of bolt (2) is discontinued (step 56), the flag for revolution number (2) is set (step 57), and the sequence returns to step 52 to check whether the flag for revolution number (1) is on. In this way, the flags for revolution numbers (1), (2) are eventually set, and the sequence proceeds to step 54 to terminate the routine.

Thus, the four bolts can be tightened up equivalently with proper torque using the device 1 for tightening two bolts at the same time.

Since the tightening torque is checked in the pretightening routine as to whether the torque is within the predetermined range, it is not necessary to check in the main tightening torque whether the tightening torque is within a predetermined range, and the program can be simplified by a corresponding amount. Whether the eventual torque is within the predetermined torque may of course be checked, or the

main tightening routine may be performed in exactly the same manner as the pretightening routine.

FIGS. 6 to 8 are flow charts showing another mode (bolt tightening torque control mode) of the method of tightening four bolts at four corners of the member to be fastened by the tightening device. FIG. 9 shows a graph corresponding to the graph of FIG. 5 which shows the relationship between the bolt revolution number and the bolt torque and in which the scales of abscissa and ordinate are altered in conformity with the present mode of tightening method. It is seen that when rotated n turns, the bolt comes into intimate contact with the flange, and the proper tightening torque (pretightening torque) at this time is 10 kgf·cm.

With reference to FIG. 6, a description will be given first of the primary routine of the tightening method in the bolt tightening torque control mode.

First, the hardware of the microcomputer is initialized to set the parameters, ports and memory for the start of operation (step 1). The start key is then pressed (step 2) to pretighten two of the four bolts which are positioned diagonally (step 3). In step 3, a predetermined bolt pretightening revolution number and predetermined diagonal bolt torque are set (step 4).

In connection with the predetermined revolution number

which is based on one revolution of the bolt, a required range is added to obtain a predetermined upper limit of revolution numbers and a predetermined lower limit thereof for use as reference values. The

5 predetermined torque is the tightening torque resulting from exactly one revolution of the bolt. According to the pretightening routine to be described below, an inquiry is then made as to whether the tightening torque for the first revolution of the bolt is within

10 the range of predetermined torque (step 5). If the answer is affirmative, an inquiry is made as to whether the tightening torque has reached the pretightening torque (10 kgf·cm) (step 6). When the pretightening torque is not reached, the next predetermined bolt

15 revolution number and predetermined diagonal bolt torque are set (step 7), followed by step 5. The predetermined bolt revolution number is based on one revolution of the bolt, predetermined torque is set for each revolution of the bolt. The pretightening routine

20 of step 5 is repeated until the bolt is rotated n turns. Incidentally, in the second half of the pretightening procedure, the predetermined bolt revolution number may be based, for example, on half

25 more accurate result. When no abnormality occurs in

the pretightening routine, the tightening torque reaches the pretightening torque (10 kgf·cm), and the pretightening of step 3 for the diagonal bolts is completed.

- 5 The tightening device 1 is removed from the diagonal bolts and then set on the reverse diagonal bolts. Depression of the start key (step 8) starts pretightening of the reverse diagonal bolts (step 9). In step 9 which is the same as step 3, a predetermined
- 10 bolt revolution number and predetermined torque for the reverse diagonal bolts are set (step 10). According to the pretightening routine, the tightening torque is checked as to whether it is in the range of predetermined torque (step 11). If the result is
- 15 acceptable, an inquiry is made as to whether the tightening torque has reached the pretightening torque (10 kgf·cm) (step 12). When the pretightening torque is not reached, the next predetermined bolt revolution number and predetermined torque for the reverse diagonal
- 20 bolts are set (step 13), followed by pretightening routine of step 11. When no abnormality occurs in the pretightening routine, the tightening torque reaches the pretightening torque (10 kgf·cm), and the pretightening of step 9 for the reverse diagonal bolts
- 25 is completed. As to the predetermined torque values in

steps 10 and 13, the first diagonal bolts differ from the reverse diagonal bolts in torque curve, so that torques are predetermined based on the actual result of tightening operation for the reverse diagonal bolts.

5 When the reverse diagonal bolts are completely pretightened, the device 1 is removed from these bolts and fitted to the first diagonal bolts. Depression of the start key (step 14) is followed by the main tightening of the diagonal bolts in accordance with the
10 main tightening routine to be described below (step 15). The diagonal bolts are tightened in step 15 with main tightening torque (30 kgf·cm). The device 1 is then removed from the first diagonal bolts and set on the reverse diagonal bolts. Depression of the start
15 key (step 16) is followed by the main tightening of the reverse diagonal bolts according to the main tightening routine, and the reverse diagonal bolts are tightened with the main tightening torque (30 kgf·cm), whereby a sequence of tightening operations is completed for the
20 four bolts (step 17). Step 2 follows again to repeat the foregoing steps when another set of four bolts are to be tightened up.

 In the foregoing process, the bolt is rotated at a high speed for pretightening and at a low speed for
25 main tightening. In the pretightening operation, the

first half of the operation may be effected at a high speed, and the second half thereof at a low speed.

Next, the pretightening routine of the tightening method will be described with reference to FIG. 7.

5 First, bolt (1) and bolt (2) are rotated at a high speed for the start of tightening, and flags for torque (1) and torque (2) are reset (step 21). The flags for torque (1) and torque (2) are set when the torque of bolt (1) and bolt (2) becomes not smaller than a value
10 corresponding to a predetermined revolution number. Next, an inquiry is made as to whether the flag for torque (1) is set (step 22). If the answer is affirmative, the flag for torque (2) is checked as to whether it is set (step 23).
15 If the flag for the torque (2) is on, this indicates that the absolute level of tightening torque of bolts (1) and (2) is within a predetermined range, followed by checking of relative level. More specifically, revolution number (1) of bolt (1) is
20 compared with revolution number (2) of bolt (2) (step 24). If the number (1) is greater, the number (2) is subtracted from the number (1) to calculate the difference ΔP in bolt revolution number (step 25). If the number (1) is not greater than the number (2), the
25 number (1) is subtracted from the number (2) to

determine the difference ΔP in bolt revolution number (step 26). An inquiry is then made as to whether the bolt revolution number difference ΔP is within a predetermined range (step 27). When the answer is affirmative, the bolts are judged to be properly tightened, whereupon the sequence comes to an end (step 42). When the answer to the inquiry of step 27 is negative, bolts are judged to be unequivally tightened, and an unequivocal tightening error is indicated (step 43), followed by a change-over to a manual mode routine (step 45).

If the flag for torque (1) is not found to be on in step 22, revolution number (1) is read, and an inquiry is made as to whether the number is at least the predetermined revolution number lower limit (step 35). When the answer to the inquiry of step 35 is affirmative, an inquiry is further made as to whether revolution number (1) is up to the predetermined revolution number upper limit (step 36). If the answer to the inquiry of step 36 is affirmative, torque (1) of bolt (1) is read (step 37) and checked as to whether torque (1) is not lower than the predetermined torque (step 38). When torque (1) is not lower than the predetermined torque, this is interpreted as indicating that bolt (1) is normally tightened, tightening of bolt

(1) is discontinued (step 39), the flag for torque (1) is set (step 40), and the sequence proceeds to step 23 wherein flag (2) is checked as to whether it is set. If torque (1) is found to be lower than the
5 predetermined torque in step 38, an inquiry is made in step 23 as to whether the flag for torque (2) is set, with bolt (1) continuously tightened. If revolution number (1) is found to be lower than the predetermined lower limit in step 35, torque (1) is read, and an
10 inquiry is made as to whether it is up to the predetermined torque (step 41). When the answer is affirmative, step 23 follows in which the flag for torque (2) is checked as to whether it is set, with bolt (1) continuously tightened. If the answer to the
15 inquiry of step 41 is negative, this is interpreted as indicating that torque (1) has reached the predetermined torque before revolution number (1) reaches the predetermined lower limit, whereupon abnormal torque is indicated (step 44), followed by a
20 change-over to the manual mode routine (step 45).

In the case where the flag for torque (2) is not found to be on in step 23, revolution number (2) is read, followed by the same procedure as steps 35 to 41 for bolt (1). More specifically, an inquiry is made as
25 to whether revolution number (2) is at least the

predetermined revolution number lower limit (step 28).
When the number (2) is at least the predetermined
revolution number lower limit, an inquiry is further
made as to whether revolution number (2) is up to the
5 predetermined revolution number upper limit (step 29).
If the answer to the inquiry of step 29 is affirmative,
torque (2) of bolt (2) is read (step 30) and checked as
to whether torque (2) is not lower than the
predetermined torque (step 31). When torque (2) is not
10 lower than the predetermined torque, this is
interpreted as indicating that bolt (2) is normally
tightened, tightening of bolt (2) is discontinued (step
32), the flag for torque (2) is set (step 33), and the
sequence returns to step 22 wherein the flag for torque
15 (2) is checked as to whether it is set. If torque (2)
is found to be lower than the predetermined torque in
step 31, the sequence returns to step 22 in which the
flag for torque (1) is checked as to whether the flag
set, with bolt (1) continuously tightened. If
20 revolution number (2) is found to be lower than the
predetermined lower limit in step 28, torque (2) is
read, and an inquiry is made as to whether it is up to
the predetermined torque (step 34). When the answer is
affirmative, step 22 follows again in which the flag
25 for torque (1) is checked as to whether it is set. If

the answer to the inquiry of step 34 is negative, this is interpreted as indicating that torque (2) has reached the predetermined torque before revolution number (2) reaches the predetermined lower limit, whereupon torque abnormality is indicated (step 44), followed by a change-over to the manual mode routine (step 45).

When torque (1) and torque (2) are not abnormal, the flags for torque (1) and torque (2) are both eventually set, followed by step 24 in which revolution number (1) is compared with revolution number (2) for the checking of relative level.

For example if torque (1) of bolt (1) reaches the predetermined torque first in the pretightening routine described, tightening of bolt (1) is discontinued, and bolt (2) only is tightened. Accordingly, bolt (1) is unlikely to be overtightened. Upon revolution number (2) of bolt (2) exceeding the predetermined upper limit before torque (2) reaches the predetermined torque, the bolts are judged to be unequivally tightened.

Further if torque (2) reaches the predetermined torque before revolution number (2) of bolt (2) reaches the predetermined upper limit, the bolts are judged to be unequivally tightened in step 27 in the case where revolution number (2) of bolt (2) is excessively

greater than that of bolt (1). Further even with
torques (1), (2) of bolts (1), (2) reaching the
predetermined torque, an abnormality is recognized in
step 34 or 41 if revolution number (1) or (2) is below
5 the predetermined lower limit in this case. This
eliminates the likelihood of the operator forgetting to
insert the gasket to be installed in the sealed
portion. Thus, the bolt is judged to be properly
tightened only when the predetermined torque is
10 reached, with the revolution number within the
predetermined limits. When the bolts are thus found
properly tightened, the sequence proceeds to the
subsequent step.

Next, the main tightening routine of the present
15 tightening method will be described with reference to
FIG. 8.

First, bolt (1) and bolt (2) are rotated at a low
speed for the start of tightening, and flags for torque
(1) and torque (2) are reset (step 51). The flags for
20 torque (1) and torque (2) are set when the torque of
bolt (1) and bolt (2) increases least to the
predetermined final tightening torque value. The flag
for torque (1) is subsequently checked as to whether it
is set (step 52). If the flag is found on in step 52,
25 the flag for torque (2) is checked as to whether it is

on (step 53). If it is found to be on in step 53, the bolts are judged to be tightened properly to terminate the routine (step 54).

In the case where the flag for torque (1) is not
5 found to be on in step 52, torque (1) of bolt (1) is read (step 59), and an inquiry is made as to whether the torque is at least the final tightening torque value (step 60). If the answer to the inquiry of step 60 is affirmative, main tightening of bolt (1) is
10 judged to be effected normally, tightening of bolt (1) is discontinued (step 61), the flag for torque (1) is set (step 62), and step 53 follows to check whether the flag for torque (2) is set. If the torque (1) is smaller than the final tightening torque in step 60,
15 bolt (1) is continuously tightened, followed by step 53 to check whether the flag for torque (2) is set. If the flag is not found to be on in step 53, torque (2) of bolt (2) is read (step 55), and an inquiry is made as to whether the torque is at least the final tightening
20 torque value (step 56). If the answer to the inquiry of step 56 is affirmative, main tightening of bolt (2) is judged to be effected normally, tightening of bolt (2) is discontinued (step 57), the flag for torque (2) is set (step 58), and the sequence returns to step 52
25 to check whether the flag for torque (1) is on. If the

torque (2) is smaller than the final tightening value in step 56, step 52 follows again to check whether the flag for torque (1) is set, with bolt (2) continuously tightened. In this way, the flags for torques (1), (2)
5 are eventually set, and the sequence proceeds to step 54 to terminate the routine.

The pretightening routine increases the torque of the bolt to the predetermined torque, with the number of revolutions thereof within the predetermined range,
10 so that it is unnecessary to check in the main tightening routine whether the revolution number is within the predetermined range. This serves to simplify the program by a corresponding amount. The final revolution number may be checked as to whether it
15 is within a predetermined range, or the main tightening routine may of course be performed in exactly the same manner as the pretightening routine.

The four bolts can be tightened up equivalently with proper torque by the above mode of tightening
20 method in the same manner as in the bolt revolution number control mode using the device 1 for tightening two bolts at the same time.

According to the tightening method as practiced in the bolt tightening torque control mode unlike the bolt
25 revolution number control mode, the bolt is checked in

the initial stage of tightening and subsequently several times as to whether it is tightened properly. The torque control mode therefore has the advantage that abnormalities in tightening are detectable early
5 to preclude the deformation of the bolts and the member to be fastened.

With the tightening method in the bolt revolution number control mode, as well as in the bolt tightening torque control mode, the two bolts as positioned on one
10 diagonal line or on the other diagonal line are rotated at the same time, whereas these bolts can be individually rotated not at the same time. In corresponding relation to this case, the tightening device may be so adapted as to rotate the two rotary
15 shafts individually. Although the tightening method as practiced in either of the two modes comprises a pretightening routine and main tightening routine separate therefrom, the entire tightening operation may be carried out in the same manner as the pretightening
20 routine shown in FIG. 3 or 7 without resorting to the main tightening routine. The flow chart of FIG. 3 or 7 is concerned with a case where two bolts are tightened up, whereas the flow chart can be readily expanded for tightening up three or four bolts. Three or four bolts
25 can be tightened up at the same time according to the

expanded flow chart. Although the device 1 described is adapted to tighten up two bolts 44 at the same time, a multishaft tightening device is readily available for tightening up three or four bolts at the same time by using three or four sets of rotary shafts 6, wrench portions 8 and motors 3. Three or four bolts can be tightened up simultaneously by using the multishaft device. For example, four bolts can be tightened at the same time by using a four-shaft tightening device and using a method of tightening the four bolts while checking these bolts for absolute level and relative level. With this method of tightening up threaded members, it is also possible to tighten up the members at a time until the eventual tightening torque is reached with the pretightening procedure omitted, hence a simplified tightening procedure. On the other hand, the tightening device 1 described in detail and adapted to simultaneously tighten up two bolts has the advantage of being simpler in construction and in control program than is the case with the method of tightening four threaded members.



What is claimed is:

1. A threaded member tightening method of
tightening up a plurality of threaded members by drive
means, the method being characterized by tightening
5 each of the threaded members while detecting the amount
of tightening of the threaded member and the tightening
torque thereof, stopping tightening upon the amount of
tightening of each threaded member reaching a specified
value based on the time when the tightening torque
10 reaches a predetermined value, and judging each
threaded member to be properly tightened when the
tightening torque of the threaded member is within a
predetermined range, with the difference in tightening
torque between the threaded members within a
15 predetermined range.

2. A threaded member tightening method of
tightening up a plurality of threaded members by drive
means, the method being characterized by tightening
each of the threaded members while detecting the amount
20 of tightening of the threaded member and the tightening
torque thereof, stopping tightening upon the tightening
torque of each threaded member reaching a predetermined
value with the amount of tightening within a specified
range, and judging each threaded member to be properly
25 tightened when the difference in tightening amount



between the threaded members is within a specified range.

3. A threaded member tightening method as defined in claim 1 which is characterized in that the threaded
5 members are all tightened up at the same time.

4. A threaded member tightening method as defined in claim 2 which is characterized in that the threaded members are all tightened up at the same time, and that
10 when the tightening torque on one of the members has reached the predetermined value with the tightening amount within the specified range, tightening of the threaded member is discontinued at that time.

5. A threaded member tightening method characterized in that at least four threaded members
15 are tightened up by dividing the threaded members into sets of at least two and tightening up each of the sets by a threaded member tightening method as defined in claim 3 or 4.

6. A threaded member tightening method as defined
20 in claim 5 which is characterized in that in tightening up four threaded members, the threaded members are divided into a set of two threaded members positioned diagonally and a set of two threaded member positioned diagonally reversely.

25 7. A threaded member tightening method as defined



in claim 1 which is characterized in that the specified value for the amount of tightening is smaller than a proper value for the final amount of tightening, and that each threaded member is finally tightening up to
5 the proper value when the threaded member is judged to be properly tightened.

8. A threaded member tightening method as defined in claim 2 which is characterized in that the predetermined value for the tightening torque is
10 smaller than a proper value for final tightening torque, and that each threaded member is tightened up until the proper final torque value is reached when the threaded member is judged to be properly tightened.

9. A threaded member tightening method as defined
15 in claim 2 which is characterized in that a judgment of abnormality is made to discontinue tightening upon the tightening torque of one of the threaded members exceeding the predetermined value before the amount of tightening of the threaded member reaches a specified
20 lower limit.

10. A threaded member tightening method as defined in claim 9 which is characterized in that a judgment of abnormality is made to discontinue tightening when the tightening torque of one of the threaded members is
25 below the predetermined value even if the amount of



tightening of the threaded member reaches a specified upper limit.

11. A threaded member tightening method which is characterized by effecting tightening in a plurality of divided steps and executing each of the steps by a threaded member tightening method as defined in claim 1 or 2.