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				Approval Date: 19/03/2025
Quality Durability	Stud Torque Strength			Effective Date: 19/03/2025
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Departments Affected: Suppliers, 3 rd party labs, Development and Sourcing Teams			
Version	Date	Modifications	Page
01	20/01/2004	First Issue	All
02	11/11/2008	Procedure reviewed and reformatted	2-5
03	09/04/2010	Update Requirement Golf and T&F based on China Feedback	5
04	19/03/2010	Added Visual Evaluation (Fabienne Wendinger)	4-5
Remarks:			

1 Purpose

This test method ensures that the studs are screwed into the plates with the same torque strength in all factories, to get equivalent results.

2 Scope

Valid for all shoes with removable studs or spikes etc., except changeable TRX studs.

3 Roles & Responsibilities

User Group	Responsibilities	Section	Detail	Link
Suppliers/ 3 rd party labs	Test Execution and Evaluation	Entire file	Required Equipment; Sample Preparation and Conditioning; Test Execution; Data	5 ff.

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Quality Teams; Material Teams; Operation Teams	Ensure Standard is executed		Collection, Evaluation and Reporting.	

4 **Reference Documents/Terminology**



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5 **Specific Procedure**

5.1 **Equipment**

- Please use tools according to Table 1.

Table 1 - Equipment

Tool	Image
Torque spanner (i.e. TOHNICHI – DB6N)	
Tool connected to the Torque spanner: Football/soccer	

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Tool connected to the Torque spanner: Golf



Tool connected to the Torque spanner: Track & Field



5.2 Sample

- According to FGT-Matrix, 3 studs/1 shoe.

5.3 Procedure

- Connect the torque spanner and the tool as shown in Figure 1.

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Figure 1 – Connecting Torque Spanner and Tool

- Check the torque spanner, that the correct moving direction is fixed. For the highest strength it must work anticlockwise.
- Unscrew the studs anti clockwise – see Figure 2.



Figure 2 – Unscrewing the studs

- Read the force from the display according to Figure 3.

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Figure 3 – Torque Strength Result

- Repeat Screwing and unscrewing the studs for 10 times.

Note:

- Torque strength must be less than the required maximum force.
- If a figure higher than the maximum force shows up, the stud has been tightened too much
- If the torque spanner is used in the “clockwise” direction, you can then screw the stud to a higher force.

5.4 Data Collection, Evaluation and Reporting

- Read each value from the display of the torque spanner and compare the mean of the 10 measurements with the minimum requirements in Table 2.
- In addition, check the appearance of the spike seat and sole after 10 times disassembly and assembly.
- Enter the results to each Test Method Code in aTP according to Table 2.

Table 2 – Requirements Stud Torque

Category	Minimum Strength [Nm]	Maximum Strength [Nm]	Appearance
Football	0.8	1.2	Result: PASS: No damage or change around spike seat and sole
Golf	1.2	2.0	

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Track and Field	1.2	2.0	FAIL: Damage or change around spike seat and sole	
aTP Test Method Code	PHP-FW0734-STTO		PHP-FW0734-STVISUAL	

6 Further Information



In all cases, the instruction manual according to the manufacturer including calibration and maintenance must be followed to ensure safety and quality.

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