WARNING HAND THREADER

Any piece of equipment can be dangerous if not operated properly. **YOU** are responsible for the safe operation of this equipment. The operator must carefully read and follow any warnings, safety signs and instructions provided with or located on the equipment. Do not remove, defeat, deface or render inoperable any of the safety devices or warnings on this equipment. If any safety devices or warnings have been removed, defeated, defaced, or rendered inoperable, **DO NOT USE THIS EQUIPMENT!!!**

⚠ **WARNING**: This threader can expose you to chemicals including naphthalene and sulfur from cutting oil products which are known to the State of California to cause cancer and birth defects or other reproductive harm. For more information go to **www.P65warnings.ca.gov**

Caution: The threading process creates burs and sharp edges on the ends of the pipe. Handle cut pipe carefully.

APPLICATION

Threads steel pipe from 1/2" to 2"

Note: If you are threading Black Steel Pipe you must use a good quality Sulfur Based Cutting Oil, or the threads will pull out.

Warning! Read these instructions carefully before using this tool. Failure to follow all instructions may result in property damage and/or serious injury.

1. Inspect the threader before use. Replace dies or any other part that shows damage or wear. To ensure a high-quality thread, only use authorized replacement dies. Worn dies can result in poor thread quality and high handle forces.
2. Mount the pipe firmly in a pipe vise. When threading an existing pipe, make sure it is secure and will not move. Cut the end of the pipe cleanly and squarely using a pipe cutter (Figure 1). When working on a scaffold or lift, the operator should be properly secured to prevent injury in the event of a fall.

Figure 1 – Cutting End of Pipe

3. Ream the end of the pipe to remove any burrs that may have been produced during the cutting of the pipe (Figure 2).

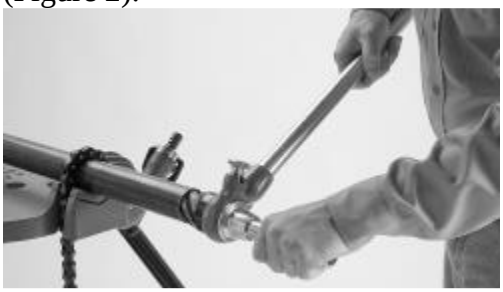

Figure 2 – Reaming End of Pipe

4. Select the correct die head for the size and type of pipe to be threaded and the thread form you require. Insert die head into the ratchet. Slip the pipe guide at the rear of the threader over the pipe and gently apply pressure to the front of the die head at the same time moving the handle down in order to start the threader (Figure 3). Make sure the handle is clean and free from oil and grease. This allows for better control of the tool.

Figure 3 – Sliding Threader on Pipe

5. Before applying force to the handle, ensure that the ratchet pawl is engaged. Pawl may fail to engage if pushed against the side of the die head. Specific care should be taken when threading pipe that is vertical.
6. When hand threading, your weight should be above the handle ensuring maximum leverage. If possible, do not do all the work with your arms, use your weight. Do not overreach. Keep proper footing and balance to maintain better control. Do not slide a pipe or "cheater" over the handle to gain extra leverage. This practice can result in serious injury.
7. Apply a generous quantity of high-quality Thread Cutting Oil when threading (Figure 4). Use of a lubricating oil or a poor thread cutting oil can result in a poor-quality cut thread, leaky joints, short die life and high handle forces.

Figure 4 – Applying Thread Cutter Oil

8. Stop threading when the end of the dies are flush with the end of the pipe. At this point, the correct size has been reached to produce the proper joint. To continue beyond this point would make a straight or running thread.
9. When the thread is complete, back off the die head by reversing the ratchet mechanism and turning the die head in the opposite direction. When the dies are nearly removed from the thread, maintain close control of the threader so that the threads are not damaged when removing the die head.

NOTE! Clean any oil spill or splatter that is on the ground. At the end of each job, always clean your threader and store in a clean dry area to protect against damage.

IMPORTANT SAFETY RULES TO FOLLOW

1. Use plenty of Hi-Grade Thread Cutting Oil to insure clean and uniform threads.
2. Cut pipe should be reamed, before threading is commenced.
3. Lift and turn ratchet knob 180 degrees to reverse the direction of travel of ratcheting mechanism.
4. Pipe to be threaded must always be inserted in die assembly from the handle side of the die.
5. Do not wear loose clothing or jewelry. Wear rubber gloves and non-skid footwear.
6. Wear safety glasses at all times.
7. Secure work. Use clamps or vise to hold work. Do not use hands or legs.
8. Keep clear of all rotating parts.

If the person receiving this handout will not be the user of the equipment, forward these instructions to the operator. **If** there is any doubt as to the operation or safety of the equipment, **DO NOT USE!!! CALL A TOOL SHED IMMEDIATELY!!! FAILURE TO FOLLOW THESE INSTRUCTIONS COULD RESULT IN INJURY OR DEATH**