

PIPE THREADER

1. To adjust the threader: Place threader flat on surface and unscrew work-holder by turning counter clockwise until change plate is clear of posts. Move post to pipe size desired. Screw work holder clockwise until change plate slides over post.
2. For standard thread, set change plate between the two standard marks.
3. For oversized or shallow thread, set change plate slightly below the standard marks.
4. For undersized or deep threads, set change plate slightly above the standard marks.
5. To set workholder, turn gauge ring until desired size lines up with mark on top of workholder. Drip threads: Move gauge ring off mark to throw pipe off center. Tighten threader on pipe with workholder set in this position.
6. To thread pipe: Release cam lever must be at "close" position for cutting threads. With pipe held securely, slide threader on pipe, workholder end first. Center end of pipe in dies. Tighten clamp screw of workholder securely. To thread, use pipe handle in a pumping action. When threading with a power drive, turn die head approximately one turn manually, start motor, and cut desired length of thread. Flood dies with plenty of rigid thread cutting oil. For best results, all pipe should be cut off "square". Use a pipe cutter, not a hacksaw. Threader is jam proof. Automatic kick-out disengages ratchet action. Prevents jamming.
7. To remove threader from finished thread, turn release cam lever to open and spin threader back to the standard position. Loosen clamp screw and slide threader off. Or, turn release cam lever to open and loosen clamp screw. Pull threader straight off pipe.
8. To remove or insert dies, screw workholder upwards until change plate is clear of post. Turn release cam lever to open position. Push post all the way to the left past 2" mark. Turn over and remove dies. If dies stick, tap ratchet ring lightly behind die. To insert dies, place #1 die in the #1 slot, the #2 die in the #2 slot, etc. Move post to engage dies. Turn threader over. Set post to desired size. Screw workholder down so change plate rests between the standard size marks and you are ready to resume threading.