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User's manual	Manual del usuario	Manuel de l'utilisateur
Customer Service US: 1-800-645-2986	Servicio de atención al Cliente US: 1-800-645-2986	Service à la clientèle Canada: 888-645-2986

Portable Pipe Threading Machine

Model(s): 604049

Specifications

Pipe Diameter:	1/2" - 2"
Operating Speed:	30 RPM (55 Unloaded)
Motor Type:	Universal
Horsepower:	1700 Watts
Voltage:	110V/60Hz AC
Controls:	FOR/OFF/REV Switch and ON/OFF Foot Switch

SAFETY INSTRUCTIONS

1. Keep your work area clean and well lit. Always keep the work area free of obstructions, grease, oil, trash, and other debris.
2. Never operate this machine in the presence of flammable liquids, gases, or dust. Power tools create sparks which may ignite the dust or fumes.
3. Keep bystanders, children, and visitors away while operating this machine. Distractions can lead to serious injury or property damage. Protect others in the work area from debris such as chips and sparks. Provide barriers or shields as needed.
4. Never leave pipe threader unattended while running.
5. Do not touch grounded surfaces such as pipes, radiators, ranges, and refrigerators when operating on electrical components. There is an increased risk of electric shock if your body is grounded.
6. Do not expose the machine to water. Water entering a power tool will increase the risk of electric shock. When operating a power tool outdoors, use an extension cord suitable for outdoor use. Use of a cord suitable for outdoor use reduces the risk of electric shock. If operating a power tool in a damp location is unavoidable, use a residual current device (RCD), ground fault circuit interrupter (GFCI) or earth leakage circuit breaker (ELCB) protected supply.
7. Grounded tools must be plugged into an outlet properly installed and grounded in accordance with all local codes and ordinances. Never remove the grounding prong or modify the plug in any way. Do not use adapter plugs. Check with a qualified electrician if you are unsure if the outlet is properly grounded. If the tools should electrically malfunction, grounding provides a low resistance path to carry electricity away from the user.
8. Do not use pipe threader if power switch does not work. Cease operation and repair switch or replace pipe threader.
9. Secure pipe to bench or stand. Support long heavy pipe overhangs with pipe supports to prevent tipping or bending.
10. When threading 3/4" pipe or larger, use a support device to resist threading forces of machine.
11. Do not touch pipe while pipe threading machine is running, doing so can cause serious personal injury or permanent damage to the tool or workpiece. Allow the machine to come to a complete stop before wiping or cleaning any surfaces.
12. Do not use the machine to make or break pipe fittings, this is not an intended use of the pipe threader and can cause serious personal injury.
13. Keep the Power Cord away from heat, oil, sharp edges, or moving parts. Cease operation and replace Power Cords immediately if damaged.
14. Disconnect power cord before making any adjusments, maintenance, or storing the machine.
15. Never use this machine when tired or under the influence of drugs, alcohol, or medication.
16. Dress properly. Do not wear loose clothing or jewelry. Contain long hair. Keep your hair, clothing, and gloves away from moving parts. Loose clothes, jewelry, or long hair can be caught in moving parts and may cause serious personal injury.
17. Use safety equipment, pipe threading machines can produce sharp chips which can cause permanent eye damage if lodged in the eye. Wear ANSI Z87+ safety glasses or goggles for protection.
18. Do not use third party or aftermarket accessories, they may impare operation of the pipe threader or malfunction during normal use.
19. Maintain all labels and nameplates on the machine so that they are clearly visible and legible.

Portable Pipe Threader

PARTS LIST

Model No.	Description	Image	Quantity
	Pipe Threading Machine		1pc
11R	Die Head for 1/2"		1pc
11R	Die Head for 3/4"		1pc
11R	Die Head for 1"		1pc
11R	Die Head for 1 1/4"		1pc
11R	Die Head for 1 1/2"		1pc
11R	Die Head for 2"		1pc
NPT 21820302 BSPT 21810302	Threading Dies 1/2"Alloy (BSPT or NPT for Option)		1 set /4pcs
NPT 21820402 BSPT 21810402	Threading Dies 3/4" Alloy (BSPT or NPT for Option)		1 set /4pcs

Portable Pipe Threader

NPT 21820402 BSPT 21810402	Threading Dies 3/4" Alloy (BSPT or NPT for Option)		1 set /4pcs
NPT 21820502 BSPT 21810502	Threading Dies 1" Alloy (BSPT or NPT for Option)		1 set /4pcs
NPT 21820602 BSPT 21810602	Threading Dies 1 1/4" Alloy (BSPT or NPT for Option)		1 set /4pcs
NPT 21820702 BSPT 21810702	Threading Dies 1 1/2" Alloy (BSPT or NPT for Option)		1 set /4pcs
NPT 21820802 BSPT 21810802	Threading Dies 2" Alloy (BSPT or NPT for Option)		1 set /4pcs
	Pipe Clamp		1pc
	Oiler		1pc
	Adapter (1/2"-1")		1 pc
	Carbon Brush		1 set /2 pcs
	Blow Molded Case		1pc

OPERATION INSTRUCTIONS

Adapter Installation

Adapter is required for 1/2" through 1 1/4" 11-R Die Heads. Push Adapter into threader and tighten the ring at opposite side (figures 1 & 2). Installation can only be made from one side of the threader.

Fig. 1

Fig. 2

Installing Die Heads

For Larger 1 1/2" - 2" 11-R Die Heads, push die heads squarely into the threader, spline end first, until the spring engages securely. For smaller 1/2" - 1 1/4" 11R Die Heads, rotate adapter cap clockwise, then push die heads into adapter spline end first, then release the adapter cap to hold die head (figures 3 & 4).

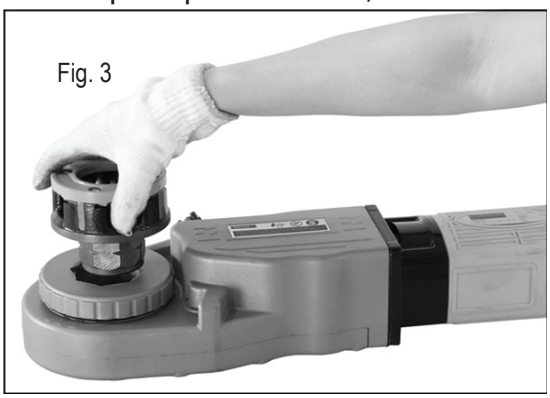


Fig. 3

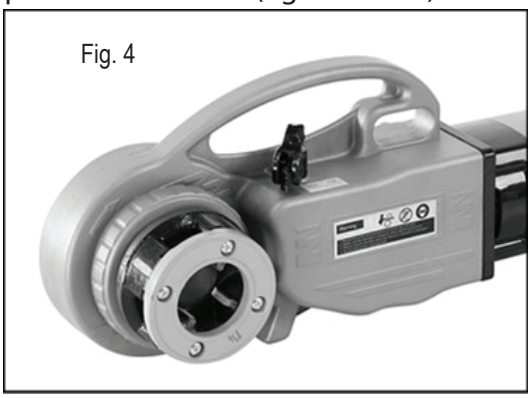


Fig. 4

Cutting Pipe Threads

1. If possible, secure the pipe in a portable tristand vise or a bench vise. Support long oerhanging ends of pipes to prevent tipping.
2. Fill the oiler with dedicated thread cutting oil.
3. Place pipe clamp on pipe. Position the clamp so that the support arm is in line with the end of the pipe (see figure 5). Make sure pipe clamp jaws contact the pipe squarely and are properly tightened to prevent slipping.

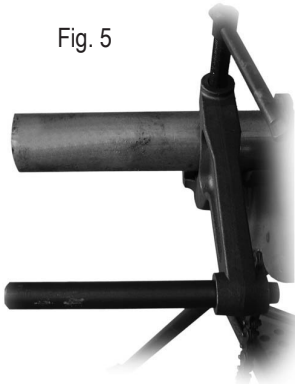


Fig. 5

⚠ WARNING

Support arm MUST be used when threading 3/4" Pipes or larger. When threading smaller pipes without support, hold onto the machine firmly with one hand to resist threading torque

4. Place die head over end of pipe and, if you are using it, insert support arm into gear case notch.
5. Apply thread cutting oil to pipe end and die teeth (see figure 6)
6. Begin cut by simultaneously pressing the power switch with one hand and pressing against the die head with the other until the die teeth catch the pipe end and start cutting.
7. Continue cut until pipe end reaches, but does not pass last set of die teeth. Doing so may create straight or running threads.
8. Reverse directional switch and press the power switch to back the threader off of the pipe. NOTE, Hold threader handle firmly to resist threading torque developed while backing off the pipe.

9. When dies clear the end of the pipe, hold the threader by the top handle to remove the device from the pipe. Remove support arm if it was used.

MAINTENANCE INSTRUCTIONS

Cleaning

- After each use, wipe off any chips and oil from the die heads.
- Wipe off any chips and oil from threading machine, especially the handles and controls.
- Wipe off any chips and oil from the support arm. If necessary, clean the support arm jaws with a wire brush.

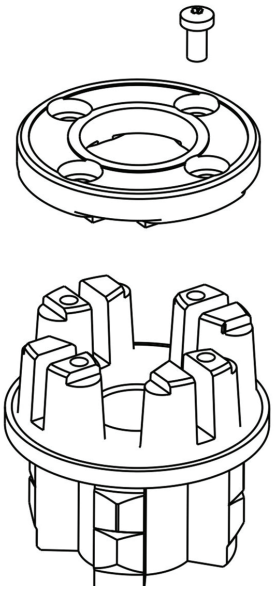
Motor

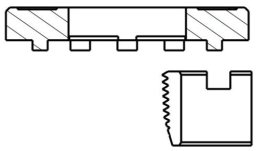
- Check motor brushes every 6 months. Replace when worn to less than 1/4".

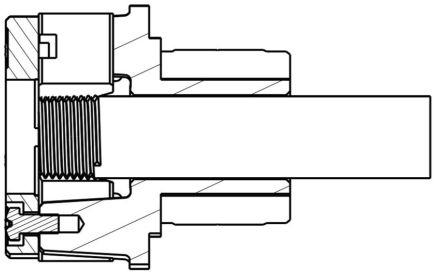
Changing Dies

If dies are worn, chipped, or otherwise damaged, replace dies.

1. Remove the four screws from cover and remove the cover plate.
2. Remove the old dies from the die head.
3. Insert new dies into slots – numbered edge up. Numbers on the dies must correspond with those on the die head slots. Always replace dies as a set.
4. Replace the cover plate and tighten the four screws lightly.
5. Place die head on already threaded pipe until dies begin to thread. This forces stop on dies outward against lugs on cover plate and properly sets the size.
6. Tighten the four screws securely. Remove the threaded pipe and make a test cut.







⚠ WARNING

Before performing any inspection, cleaning, or maintenance procedures, make sure the machine's power switch is in the "OFF" position and that the power cord is unplugged.

MAINTENANCE INSTRUCTIONS

PROBLEM	POSSIBLE CAUSE	CORRECTION
Motor does not start	Threader unplugged	Plug into power source
	Brushes do not touch armature	Check brushes, replace if worn
Motor sounds overloaded	Overload because of dull dies	Replace dies
	Bad quality or insufficient thread cutting oil	Use thread cutting oil in adequate quantity
Sparks forming at motor	Bad contact between brushes and brush holder	Tighten the screws, make sure brush is pressed firmly onto armature
	Brushes do not touch armature properly	Replace worn brushes
	Sharp edge on brush	Break edge with sand paper
Die head does not start threading	Dull or broken dies	Replace dies
	Machine running in wrong direction	Check setting of the direction switch
	Improperly set dies	Reset dies
Damaged Thread	Dull dies	Replace dies
	Dies not assembled in correct sequence	Put dies in correct sequence
	Low quality pipe	Make sure only pipe of good quality is used
	Bad quality or insufficient thread cutting oil	Use only thread cutting oil in adequate quantity
Support arm turns while threading	Support arm feed screw not tight	Tighten feed screw
	Support arm jaws dirty	Clean with wire brush
	Support arm not square on pipe	Make sure sits square on pipe
Die heads cannot be changed properly	Burr has occurred at the spline end of the die head	Eliminate burr with file