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User's manual

Manual del usuario

Manuel de l'utilisateur

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Ratcheting Pipe Threader

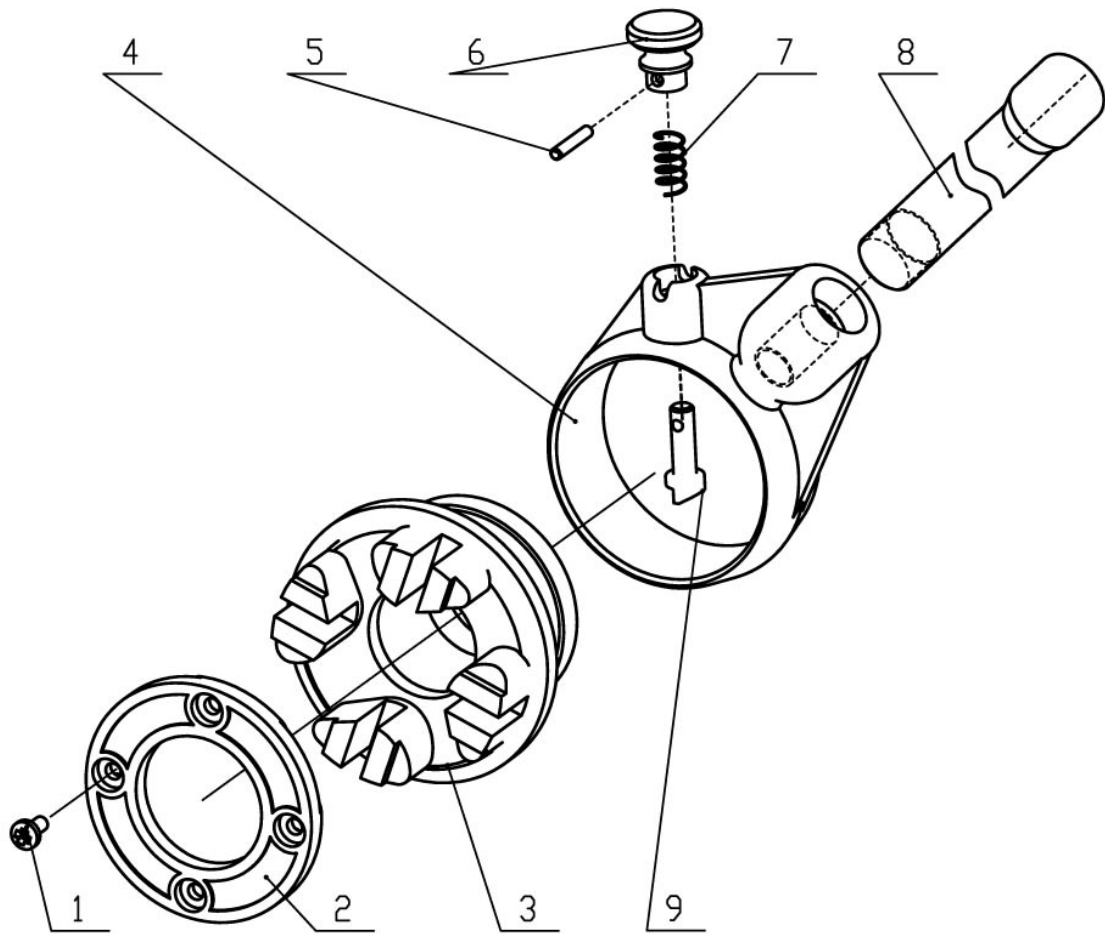
Model(s): 604053



Cuts 1/2", 3/4", 1", 1 1/4", 1 1/2" and 2" pipe threads

Ratcheting Pipe Threader

PACKING LIST



CONTENTS		
Ref.	Qty.	Description
1	4	M6 x 12mm Screw
2	6	Head Plate
3	6	Head Body
4	1	Ratchet Body
5	1	Roll Pin
6	1	Knob
7	1	Spring
8	1	Handle
9	1	Pawl

Ratcheting Pipe Threader

OPERATION INSTRUCTIONS

- Device features 6 different sized cutting dies, 1/2" to 2" threads. Ensure that the die you have selected is the correct thread size and type, and that it is not worn or damaged.
- Make sure the pipe is properly secured in the pipe vise. There should not be excessive overhang over the secured end of the pipe.
- Check that the tool is set to ratchet in the correct direction for your threads. If the ratchet pawl is not engaging, try to switch the ratchet direction until it engages.
- Slip the pipe guide at the back end of the tool over the pipe, take care to ensure that the tool is not crooked. To start cutting threads, apply pressure from the front end of the tool into the pipe and begin rotating the crank handle, you will feel when the die begins to "bite".

See picture below:



- Turn the crank handle to continue cutting threads. Keep the crank clean and free of thread cutting oil to maintain a proper grip. DO NOT place a pipe, tube or "cheater" over the crank handle to gain extra leverage, doing so can cause serious personal injury or permanently damage the tool or workpiece.
- Use a liberal amount of thread cutting oil. Apply the oil through gaps in the tool's head body. Do not use motor oil or gear oil in place of proper thread cutting oil, doing so can result in poor quality threads, leaky pipe joints, increased die wear and increased resistance when cutting.

See picture below:



- Continue cutting until the end of the pipe is just behind the last set of teeth on the die. At this point, the correct length of threads has been created. Continuing beyond this point will result in straight pipe threads which will create a poor seal.
- To remove the pipe, reverse the ratchet direction and continue turning the crank handle. Be careful when removing the pipe from the end of the die in order to avoid damaging the threads.
- Drain any oil and chips from the pipe and clean both the pipe threads and the die teeth using a clean shop rag.

NOTE: A burr may form inside the pipe, use a reamer or a deburring tool to clean the inside edge. Take care not to expand the pipe or damage the threads.