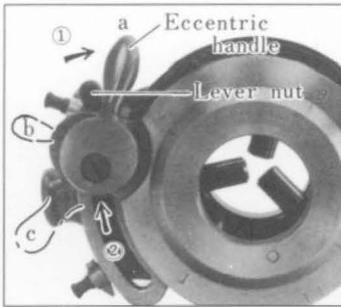


## Instructions for use

112R (1/4 ~ 1 1/4")  
 114R (1/2 ~ 2")  
 115R (1 1/2 ~ 3")  
 117R (2 1/2 ~ 4")

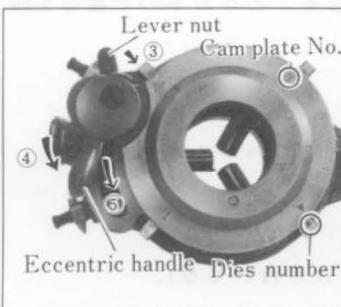
# REX Oster-Type Ratchet Threader

Model	Size	Material	Weight
112R	1/4 ~ 1 1/4"	Steel	1.5 kg
114R	1/2 ~ 2"	Steel	2.5 kg
115R	1 1/2 ~ 3"	Steel	4.5 kg
117R	2 1/2 ~ 4"	Steel	8.5 kg



### ■ Assembling the Dies:

- Loosen the lever nut. Move the cam plate to the right as far as it will go. (In line with A)
- Turn the eccentric handle to the right (clockwise) (position "a" in the diagram).
- Insert the dies fully, making sure that they are facing the right way and that the number on the dies matches the number on the cam plate. If they are inserted in the wrong order, uneven threads will be produced.
  - 3-1 Insert dies No.1, 2, 3 and 4.
  - 3-2 Turn the eccentric handle to position "c" (see diagram).



- Move the cam plate to the left and align the line on the retaining ring with the required pipe size on the cam plate.
- Tighten the lever nut.

### ■ Removing the Dies:

- Loosen the lever nut. Move the cam plate to the right as far as it will go. (In line with A)
- Turn the eccentric handle to the right (clockwise) (position "a" in the diagram).
- Remove the dies.

### ■ Threading:

- Place the pipe in the pipe vice.
- Fix the handle to the threader.
- Turn the scroll anti-clockwise to open the jaws a little wider than the size of the pipe to be threaded.
- Place the threader over the pipe from the scroll end.
- Insert the pipe until it lightly touches the back of the dies.

#### Caution:

If the pipe is inserted too strongly it may cause damage.

- Ensure the tapering end of the ratchet pins points in the direction of rotation so that the handle cannot move when turned clockwise.
- Turn the scroll in the direction of the arrows to tighten the scroll jaws lightly on the pipe.

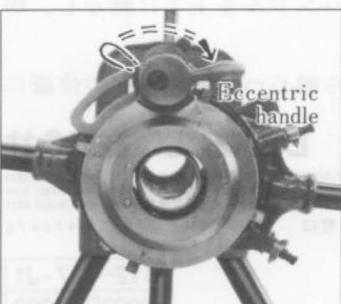
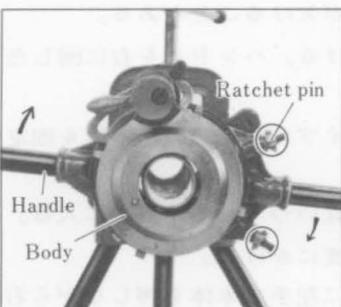
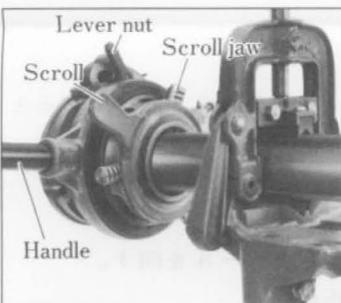
#### Caution:

Make sure the pipe is properly centered and rests firmly in the jaws.

- Add a few drops of cutting oil to the end of the pipe. (Do not use an excessive amount.)
- With your left hand on the body of the threader apply pressure evenly over the four cutting edges of the dies and move the handle up and down with your right hand to start threading.
- Make 2 or 3 threads and stop applying pressure with your left hand. Continue moving the handle up and down, adding a little oil regularly.
- Once the required length of thread has been produced, return the eccentric handle to position "a" with your left hand while moving the handle up and down with your right hand. This completes the threading.
- Loosen the scroll (in the opposite direction to the arrow) and remove the body of the threader from the pipe.

### REMARKS:

- If the pipe face is irregular, uneven threads may be produced. Make sure the pipe face is cut squarely.
- Do not force the handle. If it does not cut smoothly, remove the pipe, cut off any threads made, and start the procedure from the beginning again.



**REX INDUSTRIES CO., LTD.**