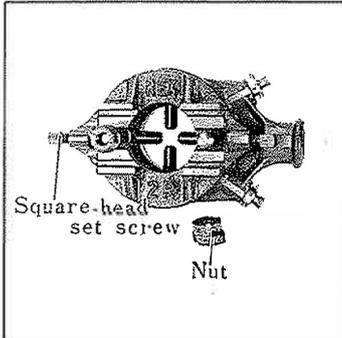


## Instructions for use

- 2 R3 ( $\frac{1}{2}$ "~1")
- 2 R4 ( $\frac{1}{2}$ "~ $\frac{1}{4}$ "")
- 2 R5 ( $\frac{3}{4}$ "~1")
- 2 R6 ( $\frac{1}{4}$ "~ $\frac{1}{4}$ "")
- 2 RC ( $\frac{3}{8}$ "~ $\frac{1}{2}$ "") (for conduit pipe)

# 2R Baby Reed-Type Ratchet Threader



### Assembling the Dies:

1. Undo the square-head set screws and remove the nut.
2. Place the dies in position on the threader, making sure the side indicating the pipe size faces upwards.

#### Caution:

The dies come in sets of 2. Make sure that the dies are from the same set or it may not be possible to produce perfect threads.

3. Align the mark on the dies with the graduation line on the main body of the threader and tighten the nut firmly with a spanner.
4. Tighten the square-head set screw, at first by hand and then lightly using a spanner, taking care not to move the graduation marks out of alignment.

### Removing the Dies:

1. Loosen the square-head set screws.
2. Undo the nuts with a spanner and remove.
3. Remove the dies.

### Threading:

1. Place the pipe in the pipe vice.
2. Fix the handle to the threader.
3. Turn the scroll anticlockwise to open the jaws a little wider than the size of the pipe to be threaded.
4. Place the threader over the pipe from the scroll end.
5. Insert the pipe until it lightly touches the back of the dies.

#### Caution:

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

6. Ensure the tapering ends of the ratchet pins point in the direction of rotation so that the handle cannot move when turned clockwise.
7. 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.

8. Add a few drops of cutting oil to the end of the pipe. (Do not use an excessive amount).
9. 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.
10. 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.
11. When the required length of thread has been cut, pull out the 2 ratchets and turn them 180° so that the tapering ends of the pins point in the opposite direction.
12. Move the handle up and down several times again and then turn the body of the threader in the opposite direction with your left hand and release the pipe.

#### Caution:

Before performing to above, make sure the scroll has not worked itself loose. If it has, damage to the threader and the threads may occur.

### REMARKS:

1. If the pipe face is irregular, uneven threads may be produced. Make sure the pipe face is cut squarely.
2. 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.

