



Manual Pipe Threader

MODEL: 12R



WARNING!

To reduce the risk of injury, user must read instruction manual
Failure to understand and follow the contents of this manual may result in
electrical shock, fire and/or serious personal injury.

12-R manual pipe threader is designed to thread pipe or conduit using individual die heads for each size of pipe and a manually operated ratchet.

Warning! Read these instructions carefully before using this tool. Failure to follow the instructions may result in property damage and/or serious injury.



Fig 1

1. Inspect the threader before use. Replace dies or any other part that shows damage or wear. To ensure a high quality thread, only use high-quality replacement dies.

WARNING Worn dies can result in poor thread quality and high handle forces.

2. Mount the pipe firmly in a pipe vise. When threading an existing pipe, make sure it is secure and will not move. Cut the end of the pipe cleanly and squarely using a pipe cutter (Figure 1).

WARNING When working on a scaffold or lift, the operator should be properly secured to prevent injury in the event of a fall.

3. Select the correct die head for the size and type of pipe to be threaded and the thread type (like BSPT or NPT) you require. Insert die head into the ratchet. Slip the pipe guide at the rear of the threader over the pipe and gently apply pressure to the front of the die head at the same time moving the handle down to start the threader (Figure 2).

WARNING Make sure the handle is clean and free from oil and grease. This allows for better control of the tool.



Fig 2

Fig 3



4. Before applying force to the handle, ensure that the ratchet pawl is engaged.

WARNING Pawl may fail to engage if pushed against the side of the die head. Specific care should be taken when threading pipe that is vertical.

5. When hand threading, your weight should be above the handle ensuring maximum leverage.

If possible, do not do all the work with your arms, use your weight. Do not overreach. Keep proper footing and balance to maintain better control.

WARNING Do not slide a pipe or “cheater” over the handle to gain extra leverage. This practice can result in serious injury.

6. Apply a generous quantity of Thread Cutting Oil when threading (Figure 3). Use of a lubricating oil or a poor thread cutting oil can result in a poor quality cut thread, leaky joints, short die life and high handle

forces.

7. Stop threading when the end of the dies are flush with the end of the pipe. At this point, the correct size has been reached to produce the proper joint. To continue beyond this point would make a straight or running thread.
8. When the thread is complete, back off the die head by reversing the ratchet mechanism and turning the die head in the opposite direction. When the dies are nearly removed from the thread, maintain close control of the threader so that the threads are not damaged when removing the die head.

NOTE! Clean any oil spill or splatter that is on the ground. At the end of each job, always clean your threader and store in a clean dry area to protect against damage.

HANGZHOU HONGLI PIPE MACHINERY CO., LTD

www.ccutting.cn