

RGD Manual pipe threader operation instruction

RGD Manual Enclosed type Ratchet threader set- 6 die heads (1/2" ~2") is deigned to thread pipe using individual die head for each size of pipe and a manual ratchet.

1. Inspect all dies in head before use. Worn die can result poor thread quality and high threading force.
2. Mount the pipe in vise and grip it firmly. When threading the pipe, ensure it will not move. Cut the end of pipe squarely & cleanly with pipe cutter.



3. Screw short handle down to long handle firmly.



4. Screw the handle set in swiveling panel, Then imbed the adaptor in the panel.



5. Select the correct die head to thread the pipe and drop it into adaptor.



6. Turning the arrow pins as the picture shown.



7. Slip the pipe guide at the rear of the threader over the pipe and gently apply pressure to the front end of the die head and moving the handle down at the same time in order to make the dies engage into pipe



8. Before applying force to start threading the pipe, ensure the ratchet pawl is engaged properly.

9. Keep on moving the handle up and down to thread the pipe, and stop threading when the end of dies are flush with the end of the pipe. Remember to apply cutting oil during the threading process.



10. Reverse the arrow pins, then move the handle up and down to remove the threader set from threaded pipe.

