



3/8in. to 2in. Ratcheting Pipe Threader Set

OWNER'S MANUAL



WARNING:

Read carefully and understand all ASSEMBLY AND OPERATION INSTRUCTIONS before operating. Failure to follow the safety rules and other basic safety precautions may result in serious personal injury.

Item# 49714



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Thank you very much for choosing a Klutch product. For future reference, please complete the owner's record below:
Serial Number/Lot Date Code: _____ Purchase Date: _____
Save the receipt, warranty and these instructions. It is important that you read the entire manual to become familiar with this product before you begin using it.

This Ratcheting Pipe Threader Set is designed for certain applications only. Northern Tool and Equipment cannot be responsible for issues arising from modification or use of this product in an application for which it was not designed. We strongly recommend that this product not be modified and/or used for any application other than that for which it was designed.

For technical questions please call 1-800-222-5381.

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Intended Use

The Klutch Ratcheting Pipe Threader Set is designed for threading pipes and has seven different threading dies ranging in size from 3/8" to 2".

Technical Specifications

Property	Specification
Handle length	16"
Die Sizes	3/8" (18 TPI), 1/2" (14 TPI), 3/4" (14 TPI), 1" (11.5 TPI), 1-1/4" (11.5 TPI); 1-1/2" (11.5 TPI); 2" (11.5 TPI)

Important Safety Information

WARNING:

- Read and understand all instructions. Failure to follow all instructions may result in serious injury or property damage.
- The warnings, cautions, and instructions in this manual cannot cover all possible conditions or situations that could occur. Exercise common sense and caution when using this tool. Always be aware of the environment and ensure that the tool is used in a safe and responsible manner.
- Do not allow persons to operate or assemble the product until they have read this manual and have developed a thorough understanding of how it works.
- Do not modify this product in any way. Unauthorized modification may impair the function and/or safety and could affect the life of the product. There are specific applications for which the product was designed.

- Use the right tool for the job. DO NOT attempt to force small equipment to do the work of larger industrial equipment. There are certain applications for which this equipment was designed. It will do the job better and more safely at the capacity for which it was intended. DO NOT use this equipment for a purpose for which it was not intended.
- Industrial or commercial applications must follow OSHA requirements.

⚠ WARNING:

- This product may contain chemicals known to the State of California to cause cancer, birth defects or other reproductive harm.

⚠ WARNING:**WORK AREA SAFETY**

- Inspect the work area before each use. Keep work area clean, dry, free of clutter, and well lit. Cluttered, wet, or dark work areas can result in injury. Using the tool in confined work areas may put you dangerously close to other cutting tools and rotating parts.
- Do not use the product where there is a risk of causing a fire or an explosion; e.g., in the presence of flammable liquids, gases, or dust. The product can create sparks, which may ignite the flammable liquids, gases, or dust.
- Do not allow the product to come into contact with an electrical source. The tool is not insulated and contact will cause electrical shock.
- Keep children and bystanders away from the work area while operating the tool. Do not allow children to handle the tool.
- Be aware of all power lines, electrical circuits, water pipes, and other mechanical hazards in your work area. Some of these hazards may be hidden from your view and may cause personal injury and/or property damage if contacted.

PERSONAL SAFETY

- Stay alert, watch what you are doing, and use common sense when operating the tool. Do not use the tool while you are tired or under the influence of drugs, alcohol, or medication. A moment of inattention while operating the tool may result in serious personal injury.
- Dress properly. Do not wear loose clothing, dangling objects, or jewelry. Keep your hair, clothing and gloves away from moving parts. Loose clothes, jewelry, or long hair can be caught in moving parts. Air vents on the tool often cover moving parts and should be avoided.
- Wear the proper personal protective equipment when necessary. Use ANSI Z87.1 compliant safety goggles (not safety glasses) with side shields, or when needed, a face shield. Use a dust mask in dusty work conditions. Also use non-skid safety shoes, hardhat, gloves, dust collection systems, and hearing protection when appropriate. This applies to all persons in the work area.
- Do not overreach. Keep proper footing and balance at all times.
- Remove keys or wrenches before connecting the tool to an air supply, power supply, or turning on the tool. A wrench or key that is left attached to a rotating part of the tool may cause personal injury.
- Secure the work with clamps or a vise instead of your hand when practical. This safety precaution allows for proper tool operation using both hands.

**⚠ CAUTION:
TOOL USE AND CARE**

- Do not force the tool. Tools do a better and safer job when used in the manner for which they are designed. Plan your work, and use the correct tool for the job.
- Check for damaged parts before each use. Carefully check that the tool will operate properly and perform its intended function. Replace damaged or worn parts immediately. Never operate the tool with a damaged part.
- Store the tool when it is not in use. Store it in a dry, secure place out of the reach of children. Inspect the tool for good working condition prior to storage and before re-use.
- Use only accessories that are recommended by the manufacturer for use with your tool. Accessories that may be suitable for one tool may create a risk of injury when used with another tool. Never use an accessory that has a lower operating speed or operating pressure than the tool itself.
- Keep guards in place and in working order. Never operate the tool without the guards in place.
- Inspect the tool, hose, and accessories for damage or excessive wear before each use. If you find damage do not use the tool.

Specific Operation Warnings**⚠ WARNING:**

- Check to make sure that the pipe ends and threads of the die are sufficiently oiled at all times.
- Make sure the pipe is secure before threading.

Assembly

1. Assemble the Connecting Rod parts and insert threaded portion of Connecting Rod into Ratchet Holder.
2. Determine the size of the pipe to be threaded.
3. Pick the appropriate die to be used. Die sizes are stamped on the outside of each die.
4. Insert the die into the Ratchet Holder. (See Figure 1) It is a force fitting, and once the die is in the Ratchet Holder, it may require light tapping with a wooden mallet to remove the die.



Figure 1

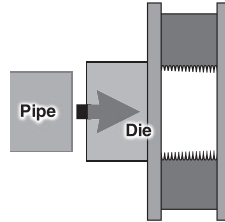
5. Have one oil can available to be used during the threading operation.
6. The pipe to be threaded must be properly secured during the threading operation.
7. To reverse the threading direction, pull out the reversing knob, turn it 180 degrees until the arrow points in the opposite direction and drop it back into place.

Operating Instructions

Caution: Make sure the pipe end and threads of the die are sufficiently oiled at all times. Otherwise, die life will be shortened and the threads will be rough.

Once the proper die is installed, you are ready to attach the Ratchet Holder to the pipe, and begin cutting threads.

1. Place the rear of the die over the end of the pipe to be threaded. Verify that the inside diameter of the die matches the outside diameter of the pipe.
2. Make sure that the pipe to be threaded is properly held in place.
3. While applying pressure to the end of the pipe, begin rotating the Handle around the pipe to engage the die to the pipe end. Continue this operation until the desired thread length is achieved.
4. To disengage the Ratchet Holder after threading is complete, follow steps discussed in #7 above to reverse the direction, and then rotate the Connecting Rod until the die is disengaged from the pipe end.
5. When sliding the pipe out of the Ratchet Holder, be careful not to damage newly cut threads.

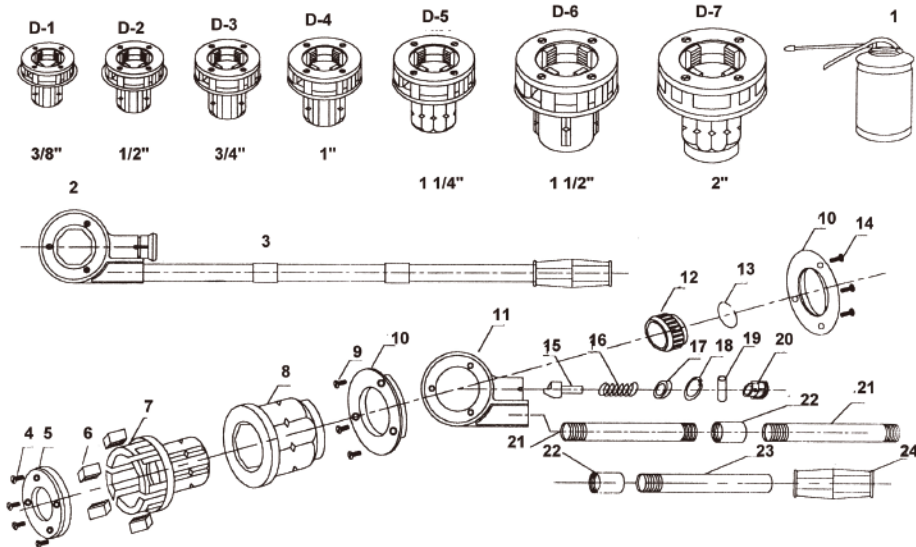


Maintenance

Maintain your tool. It is recommended that the general condition of any tool be examined before it is used. Keep your tool in good repair by adopting a program of conscientious repair and maintenance in accordance with the recommended procedures found in this manual. Keep all cutting tools sharp and clean. Properly maintained cutting tools with sharp cutting edges are less likely to bind and are easier to control. Keep handles dry, clean, and free from oil and grease.

1. Clean the Pipe Threading tool after each use. Clean dies after each use. Check for broken teeth or pipe material between teeth.
2. When not in use, store all parts in the case, and store the case in a dry location.

Parts Diagram



Parts List

Part No.	Description	Q'ty	Part No.	Description	Q'ty
D-1	DIES THREADER 3/8"	1	10	PLASTIC GLAND	2
D-2	DIES THREADER 1/2"	1	11	RATCHET HOLDER	1
D-3	DIES THREADER 3/4"	1	12	RATCHET	1
D-4	DIES THREADER 1"	1	13	STEEL RETAINING RING	1
D-5	DIES THREADER 1-1/4"	1	14	SCREW	3
D-6	DIES THREADER 1-1/2"	1	15	PAWL	1
D-7	DIES THREADER 2"	1	16	PRESS SPRING	1
1	OIL CAN	1	17	TIGHTENING RING	1
2	DIES FRAME	1	18	RETAINING RING	1
3	WORK HANDLE	1	19	SPRING BOLT	1
4	SCREW	4	20	KNOB	1
5	COVER	1	21	CONNECTING ROD	2
6	DIES	4	22	ROD CONNECTER	2
7	DIES HEAD	1	23	CONNECTING ROD	1
8	RATCHET COUPLING	1	24	PLASTIC HANDLE	1
9	SCREW	3			

Replacement Parts

- For replacement parts and technical questions, please call Customer Service at 1-800-222-5381.
- Not all product components are available for replacement. The illustrations provided are a convenient reference to the location and position of parts in the assembly sequence.
- When ordering parts, the following will be required: model number, serial number/lot date code, and description.
- The distributor reserves the rights to make design changes and or improvements to product lines and manuals without notice.

Limited Warranty

Northern Tool and Equipment Company, Inc. ("We" or "Us") warrants to the original purchaser only ("You" or "Your") that the Klutch product purchased will be free from material defects in both materials and workmanship, normal wear and tear excepted, for a period of one year from date of purchase. The foregoing warranty is valid only if the installation and use of the product is strictly in accordance with product instructions. There are no other warranties, express or implied, including the warranty of merchantability or fitness for a particular purpose. If the product does not comply with this limited warranty, Your sole and exclusive remedy is that We will, at our sole option and within a commercially reasonable time, either replace the product or product component without charge to You or refund the purchase price (less shipping). This limited warranty is not transferable.

Limitations on the Warranty

This limited warranty does not cover: (a) normal wear and tear; (b) damage through abuse, neglect, misuse, or as a result of any accident or in any other manner; (c) damage from misapplication, overloading, or improper installation; (d) improper maintenance and repair; and (e) product alteration in any manner by anyone other than Us, with the sole exception of alterations made pursuant to product instructions and in a workmanlike manner.



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Obligations of Purchaser

You must retain Your product purchase receipt to verify date of purchase and that You are the original purchaser. To make a warranty claim, contact Us at 1-800-222-5381, identify the product by make and model number, and follow the claim instructions that will be provided. The product and the purchase receipt must be provided to Us in order to process Your warranty claim. Any returned product that is replaced or refunded by Us becomes our property. You will be responsible for return shipping costs or costs related to Your return visit to a retail store.

Remedy Limits

Product replacement or a refund of the purchase price is Your sole remedy under this limited warranty or any other warranty related to the product. We shall not be liable for: service or labor charges or damage to Your property incurred in removing or replacing the product; any damages, including, without limitation, damages to tangible personal property or personal injury, related to Your improper use, installation, or maintenance of the product or product component; or any indirect, incidental or consequential damages of any kind for any reason.

Assumption of Risk

You acknowledge and agree that any use of the product for any purpose other than the specified use(s) stated in the product instructions is at Your own risk.

Governing Law

This limited warranty gives You specific legal rights, and You also may have other rights which vary from state to state. Some states do not allow limitations or exclusions on implied warranties or incidental or consequential damages, so the above limitations may not apply to You. This limited warranty is governed by the laws of the State of Minnesota, without regard to rules pertaining to conflicts of law. The state courts located in Dakota County, Minnesota shall have exclusive jurisdiction for any disputes relating to this warranty.



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