CENTRAL FORGE®

Item #30027 Pipe Threading Kit

(5 Piece Set)

Assembly and Operating Instructions

Distributed Exclusively by HARBOR FREIGHT TOOLS®

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For technical questions and replacement parts, please call 1-800-444-3353

Specifications

Kit includes Ratchet Head with Coupler, 2 Handles, 3 Dies, and Blowmold Case

Die Sizes: 1/2" (14 Threads per Inch); 3/4" (14 TPI); 1" (11-1/2 TPI)

Ratchet Head is Reversible; Dies Are Replaceable; Taper Threads: 3/4" Per Foot

Save This Manual

You will need the manual for the safety warnings and precautions, assembly instructions, operating and maintenance procedures, parts list and diagram. Keep your invoice with this manual. Write the invoice number on the manual for safekeeping. Keep the manual and invoice in a safe and dry place for future reference.

Safety Warnings and Precautions

WARNING: When using tool, basic safety precautions should always be followed to reduce the risk of personal injury and damage to equipment.

Read all instructions before using this tool!

1. **Keep work area clean**. Cluttered areas invite injuries.
2. **Observe work area conditions**. Do not use machines or power tools in damp or wet locations. Don't expose to rain. Keep work area well lighted. Do not use electrically powered tools in the presence of flammable gases or liquids.
3. **Keep children away**. Children must never be allowed in the work area. Do not let them handle machines, tools, or extension cords.
4. **Store idle equipment**. When not in use, tools must be stored in a dry location to inhibit rust. Always lock up tools and keep out of reach of children.
5. **Do not force tool**. It will do the job better and more safely at the rate for which it was intended. Do not use inappropriate attachments in an attempt to exceed the tool capacity.
6. **Use the right tool for the job**. Do not attempt to force a small tool or attachment to do the work of a larger industrial tool. Do not use a tool for a purpose for which it was not intended.
7. **Dress properly**. Do not wear loose clothing or jewelry as they can be caught in moving parts. Protective, electrically non-conductive clothes and non-skid footwear are recommended when working. Wear restrictive hair covering to contain long hair.
8. **Use eye and ear protection**. Always wear ANSI approved impact safety goggles. Wear a full face shield if you are producing metal filings or wood chips. Wear an ANSI approved dust mask or respirator when working around metal, wood, and chemical dusts and mists.
9. **Do not overreach**. Keep proper footing and balance at all times. Do not reach over or across running machines.
10. **Maintain tools with care**. Keep tools sharp and clean for better and safer performance. Follow instructions for lubricating and changing accessories. Inspect tool cords periodically and, if damaged, have them repaired by an authorized technician. The handles must be kept clean, dry, and free from oil and grease at all times.
11. **Stay alert**. Watch what you are doing, use common sense. Do not operate any tool when you are tired.
12. **Check for damaged parts**. Before using any tool, any part that appears damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for alignment and binding of moving parts; any broken parts or mounting fixtures; and any other condition that may affect proper operation. Any part that is damaged should be properly repaired or replaced by a qualified technician. Do not use the tool if any switch does not turn On and Off properly.

13. **Guard against electric shock**. Prevent body contact with grounded surfaces such as pipes, radiators, ranges, and refrigerator enclosures.

14. **Replacement parts and accessories**. When servicing, use only identical replacement parts. Use of any other parts will void the warranty. Only use accessories intended for use with this tool. Approved accessories are available from Harbor Freight Tools.

15. **Do not operate tool if under the influence of alcohol or drugs**. Read warning labels on prescriptions to determine if your judgment or reflexes are impaired while taking drugs. If there is any doubt, do not operate the tool.

Unpacking

When unpacking, check to make sure that all parts and accessories are included and in good condition. If any parts are missing or broken, please call Harbor Freight Tools at the number on the cover of this manual as soon as possible.

Preparation for Pipe Threading

1. Assemble the Handle parts (#2 and #3) and insert threaded portion of Handle (#2) into Holder (#1).
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 Holder. It is a force fitting, and once the die is in the Holder, it may require light tapping with a wooden mallet to remove the die.
5. Have an 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.

Operation

Now that the proper die is installed, you are ready to attach the 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.

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.

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 Holder after threading is complete, follow steps discussed in #8 on prior page.
5. When sliding the pipe out of the Holder, be careful not to damage newly cut threads.

Maintenance

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 Listing and Parts Diagram

Part #	Description	Qty	Part #	Description	Qty
1	Holder	1	4	Die Head, 1”	1
2	Handle	1	5	Die Head, 3/4”	1
3	End Handle	1	6	Die Head, 1/2”	1

