

# **VEVOR<sup>®</sup>**

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## **MANUAL RATCHET PIPE THREADER USER MANUAL**

**Model: KT1106A**

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## MANUAL RATCHET PIPE THREADER

Model: KT1106A



Thanks for purchasing one of our products, please read carefully the assembly instructions before the installation.

### NEED HELP? CONTACT US!

Have product questions? Need technical support? Please feel free to contact us:

✉ [CustomerService@vevor.com](mailto:CustomerService@vevor.com)

This is the original instruction, please read all manual instructions carefully before operating. VEVOR reserves a clear interpretation of our user manual. The appearance of the product shall be subject to the product you received. Please forgive us that we won't inform you again if there are any technology or software updates on our product.

# PRODUCT PARAMETERS

Model	Die Sizes			Screw Die Material
KT1106A	1/4" (18 TPI)	3/8" (18 TPI)	1/2" (14 TPI)	9SiCr
	3/4" (14 TPI)	1" (11.5TPI)	1-1/4"(11.5TPI)	

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

Suitable for copper pipes, aluminum pipes, galvanized pipes, iron pipes (not recommended for use with stainless steel pipes)

## ASSEMBLY AND USE PRECAUTIONS

- 1.Assemble needs to follow these instructions. Incorrect assembly can be a hazard.
- 2.Do not assemble when tired or under the influence of alcohol, drugs or medication.
- 3.Keep bystanders out of the area in use.
- 4.Use as intended only. Do not use handle extension to increase force.
- 5.Keep pipe lubricated with cutting oil (not included).
- 6.Secure pipe to be threaded in clamp before use.
- 7.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.
- 8.Maintain tools with care. Keep tools sharp and clean for better and safer performance. Follow instructions for lubricating and changing accessories. Check tool cords periodically. If they are damaged, have them repaired by an authorized technician. The handles must be kept clean, dry, and free from oil and grease at all times.
- 9.Replace parts and accessories. Only the same replacement parts are used for maintenance. Use of any other parts will void the warranty. Use only accessories that are compatible with this tool. Approved accessories

are available from Harbor Freight Tools.

10. The warnings, precautions, and instructions discussed in this instruction manual cannot cover all possible conditions and situations that may occur. The operator must understand that common sense and care are factors that cannot be built into the product but must be provided by the operator.



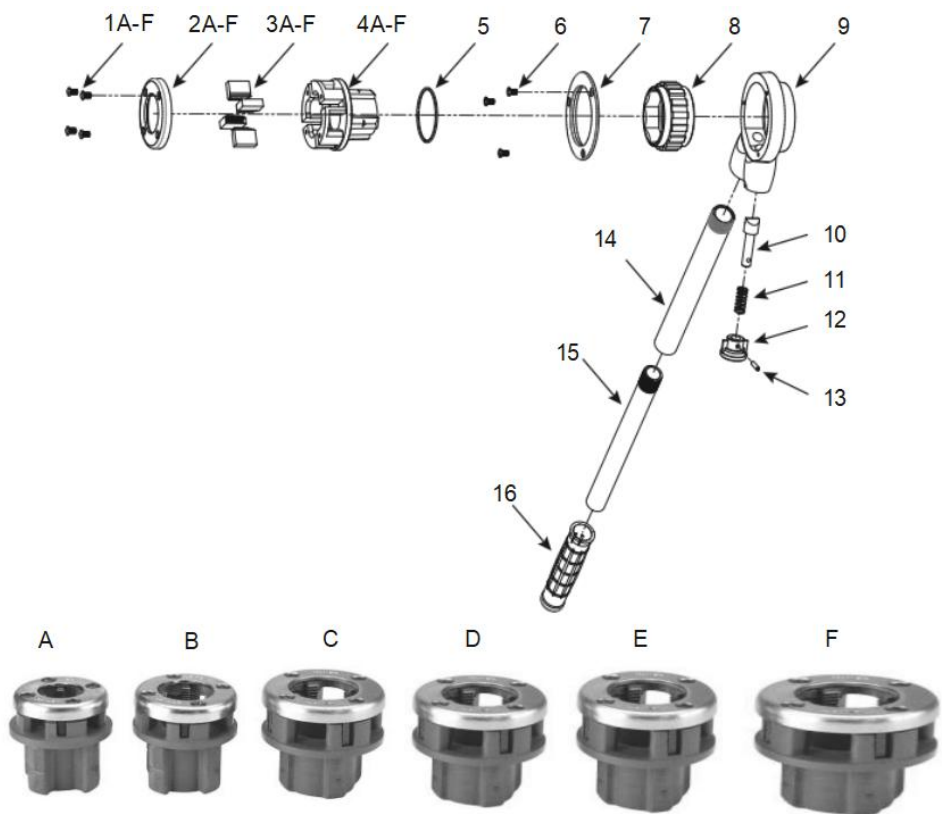
**WARNING: TO PREVENT SERIOUS INJURY AND DEATH FROM TIPPING:**

1. This product is not a toy. Do not allow children to play with or approach this item.
2. Check before each use. Do not use the parts if they are loose or damaged.
3. Wear safety goggles and heavy-duty work gloves in use.

**Parts List and Diagram**

Part	Description	Qty
1A	1/4" Die Screw	4
2A	1/4" Die Cover	1
3A	1/4" Die Blade Set	4
4A	1/4" Die Ratchet Coupling	1
1B	3/8" Die Screw	4
2B	3/8" Die Cover	1
3B	3/8" Die Blade Set	4
4B	3/8" Die Ratchet Coupling	1
1C	1/2" Die Screw	4
2C	1/2" Die Cover	1
3C	1/2" Die Blade Set	4
4C	1/2" Die Ratchet Coupling	1
1D	3/4" Die Screw	4
2D	3/4" Die Cover	1
3D	3/4" Die Blade Set	4
4D	3/4" Die Ratchet Coupling	1
1E	1" Die Screw	4
2E	1" Die Cover	1
3E	1" Die Blade Set	4
4E	1" Die Ratchet Coupling	1
1F	1-1/4" Die Screw	4
2F	1-1/4" Die Cover	1
3F	1-1/4" Die Blade Set	4
4F	1-1/4" Die Ratchet Coupling	1

Part	Description	Qty
5	Retaining Rind	1
6	Screw	3
7	Plate	1
8	Ratchet	1
9	Ratchet Holder	1
10	Pawl	1
11	Spring	1
12	Reversing Knob	1
13	Pin	1
14	Handle Tube	1
15	Handle	1
16	Handle Sleeve	1
17	Oil Can	1
18	Case (not shown)	1
A	1/4" NPT Die	1
B	3/8" NPT Die	1
C	1/2" NPT Die	1
D	3/4" NPT Die	1
E	1" NPT Die	1
F	1-1/4" NPT Die	1



# Operating Instructions

**NOTICE:** 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. See Figure A.

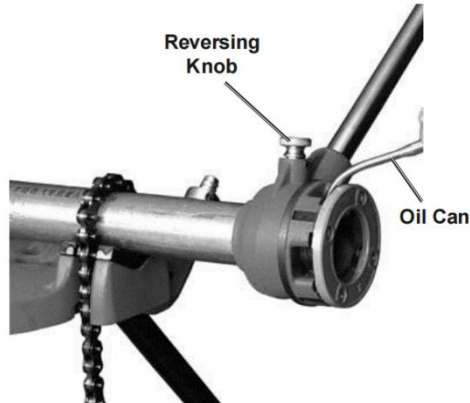


Figure A

1. Assemble the Handle and insert the threaded portion of the Handle Tube into the 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. Place the rear of the Die next to the end of the pipe to be threaded. Verify that the inside diameter of the Die matches the outside diameter of the pipe.
5. Insert Die into Ratchet Holder. It is a forced fitting, and once the Die is in the Ratchet Holder, it may require light tapping with a wooden mallet to remove the Die.
6. Fill the Oil Can with Thread Cutting Oil (sold separately). Keep it nearby during the threading operation.
7. Make sure that the pipe to be threaded is properly secured in a vise (sold separately), and make sure the pipe end to be threaded is cut cleanly and squarely.
8. Make sure that the Reversing Knob is seated all the way down into the grooves of the Ratchet Holder and its arrow is pointing away from the handle.

9. Slide the pipe guide at the end of the ratchet holder through the pipe. When pressure is applied to the front end of the die, the handle is used to rotate the ratchet support to engage the die to the pipe end. See Figure B. Continue this operation until the desired thread length is achieved.
10. Stop threading when the end of the Die is flush with the end of the pipe.
11. To disengage the Die after threading is complete, pull out the Reversing Knob, turn it 180 degrees until the arrow points in the opposite direction (toward the handle), and drop it back into place. This will reverse the Pawl.
12. Use the Handle to rotate the Ratchet Holder in the opposite direction until the Die disengages fully from the pipe end. Maintain control of the Ratchet Holder as the Die slides off the pipe. Be careful not to damage newly cut threads.
13. Clean any spilled oil off the ground. Clean the threader and store it indoors in a dry clean area.



Figure B

## Cleaning, Maintenance, and Lubrication

- For cleaning, wipe the surface with a damp (not wet) cloth or wipe dry with a clean lint free cotton cloth.
- DURING USE, ensure that pipe end and die threads are oiled with Thread Cutting Oil (not included) at all times.
- Worn die blades will result in poor thread quality. If the blade is worn, replace it with a qualified technician.

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