

# Owner's Manual & Safety Instructions

**Save This Manual** Keep this manual for the safety warnings and precautions, assembly, operating, inspection, maintenance and cleaning procedures. Write the product's serial number in the back of the manual near the assembly diagram (or month and year of purchase if product has no number). Keep this manual and the receipt in a safe and dry place for future reference.

22a



## 3/8 - 2" 10 PC. RATCHETING PIPE THREADER SET



Visit our website at: <http://www.harborfreight.com>  
Email our technical support at: [productsupport@harborfreight.com](mailto:productsupport@harborfreight.com)

**58352**

When unpacking, make sure that the product is intact and undamaged. If any parts are missing or broken, please call 1-888-866-5797 as soon as possible.

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No portion of this manual or any artwork contained herein may be reproduced in any shape or form without the express written consent of Harbor Freight Tools. Diagrams within this manual may not be drawn proportionally. Due to continuing improvements, actual product may differ slightly from the product described herein.  
Tools required for assembly and service may not be included.

### **⚠ WARNING**

Read this material before using this product.  
Failure to do so can result in serious injury.  
**SAVE THIS MANUAL.**

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| WARNING SYMBOLS AND DEFINITIONS |  |
|---------------------------------|--|
|                                 | This is the safety alert symbol. It is used to alert you to potential personal injury hazards. Obey all safety messages that follow this symbol to avoid possible injury or death. |
|                                 | Indicates a hazardous situation which, if not avoided, will result in death or serious injury.   |
|                                 | Indicates a hazardous situation which, if not avoided, could result in death or serious injury.  |
|                                 | Indicates a hazardous situation which, if not avoided, could result in minor or moderate injury.   |
|                                 | Addresses practices not related to personal injury.  |

## Specifications

|              |   |
|--------------|---|
| Die Sizes    | 3/8" (18 TPI)<br>1/2" (14 TPI)<br>3/4" (14 TPI)<br>1" (11.5 TPI)<br>1-1/4" (11.5 TPI)<br>1-1/2" (11.5 TPI)<br>2" (11.5 TPI) |
| Pipe Type    | Steel, galvanized, and black pipe   |
| Kit Includes | Ratchet Head with Coupler. 3 Handles, 7 Dies.   |

# IMPORTANT SAFETY INFORMATION

1. Wear ANSI-approved safety goggles and heavy-duty work gloves during use.
2. Keep work area clean and well lit.
3. Keep bystanders out of the area during use.
4. Do not use when tired or when under the influence of alcohol, drugs or medication.
5. This product is not a toy. Do not allow children to play with or near this item.
6. Use as intended only. Do not use handle extension to increase force.
7. Inspect before every use; do not use if parts are loose or damaged.
8. Maintain product labels and nameplates. These carry important safety information. If unreadable or missing, contact Harbor Freight Tools for a replacement.
9. Keep pipe lubricated with cutting oil (not included).
10. Secure pipe to be threaded in clamp before use.
11. Read manual before set up and/or use.
12. **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.
13. **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.
14. **Dress properly.** Do not wear loose clothing or jewelry as they can be caught in moving parts. Protective, electrically nonconductive clothes and nonskid footwear are recommended when working. Wear restrictive hair covering to contain long hair.
15. **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.
16. **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.
17. The warnings, precautions, and instructions discussed in this instruction manual cannot cover all possible conditions and situations that may occur. It must be understood by the operator that common sense and caution are factors which cannot be built into this product, but must be supplied by the operator.

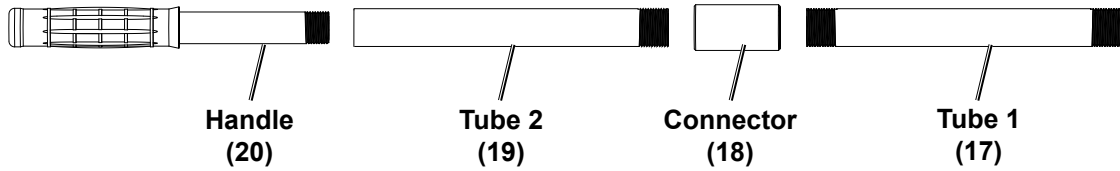
## Operating Instructions

### **⚠ WARNING**

#### **TO PREVENT SERIOUS INJURY:**

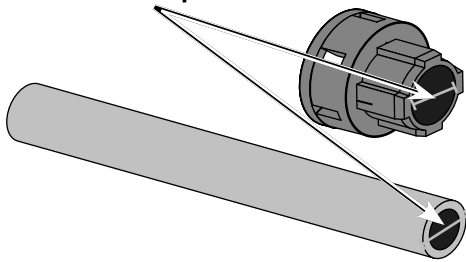
**Wear ANSI-approved safety goggles and heavy-duty work gloves during use.**

1. Assemble the Handle (20). For smaller pipes attach Tube 2 (19) to Handle. For larger pipes add Connector (18) and Tube 1 (17).

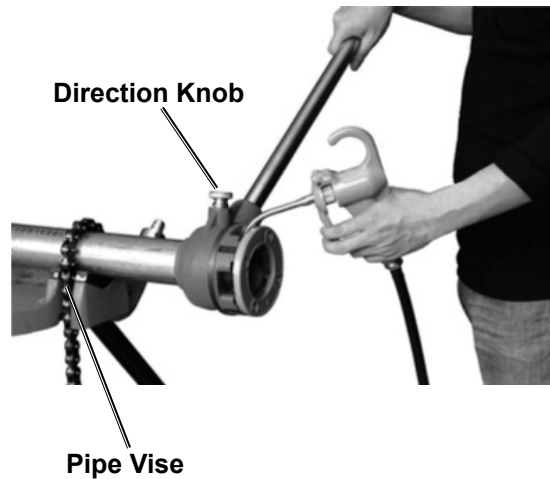
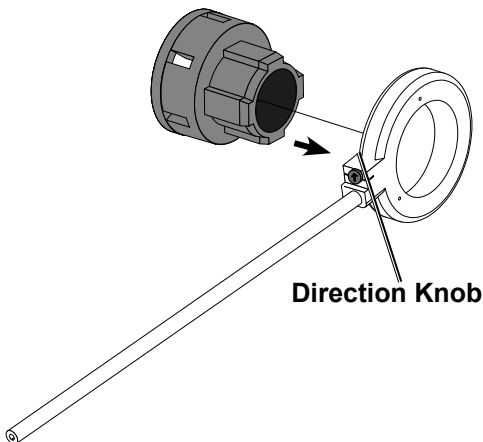


2. Thread completed Handle into Ratchet Holder.
3. Determine the size of the pipe to be threaded.
4. Pick the appropriate Die to be used. Die sizes are stamped on the outside of each Die.
5. Properly secure the pipe in a pipe vise (not included). Place a bucket underneath the pipe to collect the oil.
6. Place the rear of the Die over the end of the pipe to verify that the inside diameter of the Die matches the outside diameter of the pipe.
8. Place the Die onto the pipe. Apply pressure to die to secure.
9. Fill the Oil Can with Thread Cutting Oil (not included). Keep it nearby during the threading operation.
10. Generously oil pipe end and threads of the Die. Otherwise, Die life will be shortened and the threads will be rough.
11. While applying pressure to the end of the die, rotate the Ratchet Holder. Continue this operation until the desired thread length is achieved.

**These measurements should be equal.**



7. Insert the Die into the Ratchet Holder. Pull Direction Knob out. Then rotate knob until arrow is pointing down. Push knob in to lock.



12. To remove Die pull Direction Knob out, rotate knob until arrow is pointing up. Push knob in to lock. Rotate the Ratchet Holder until Die disengages fully from the pipe end.

**Caution:** To prevent damage to threads, remove Die carefully.

## Maintenance and Servicing



Procedures not specifically explained in this manual must be performed only by a qualified technician.

### **WARNING**

**TO PREVENT SERIOUS INJURY FROM TOOL FAILURE:**

Do not use damaged equipment. If abnormal noise or vibration occurs, have the problem corrected before further use.

## Cleaning, Maintenance, and Lubrication

1. **BEFORE EACH USE**, inspect the general condition of the tool. Check for:
  - loose hardware,
  - misalignment or binding of moving parts,
  - cracked or broken parts, and
  - any other condition that may affect its safe operation.
2. **DURING USE**, ensure that pipe end and die threads are oiled with Thread Cutting Oil (not included) at all times.
3. **AFTER USE**, wipe external surfaces of the tool with clean cloth.

### To replace the Die Blades

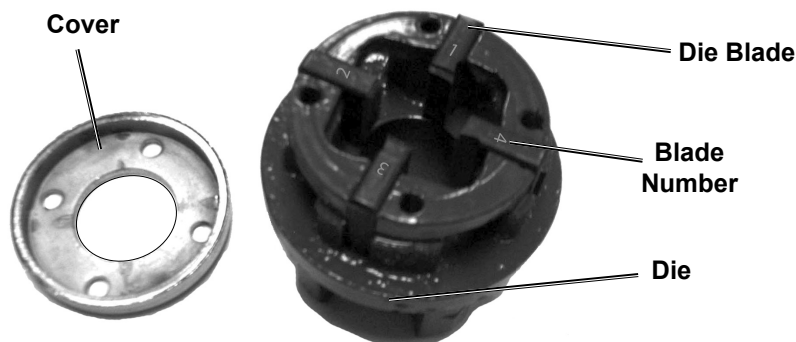
### **WARNING**

**TO PREVENT SERIOUS INJURY:** Wear ANSI-approved safety goggles and heavy-duty work gloves when replacing blades.

Worn Die Blades can result in poor thread quality. When replacing Die Blades, verify that the size of the new Die Blades corresponds to the size of the Die. To replace the Die Blades:

1. Remove the four Screws on the Cover.
2. Remove the Cover.
3. Remove all four Die Blades.
4. Insert four new Die Blades into the Die.
5. Once the Die Blades are properly inserted, replace the Cover and secure with the four Screws.

**NOTE:** When inserting the Die Blades, make sure the cutting edges of the Die Blades face inward and that the number on each Die Blade is at the top and in sequence.



**Record Serial Number Here:**

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**Note:** If product has no serial number, record month and year of purchase instead.

**Note:** Some parts are listed and shown for illustration purposes only, and are not available individually as replacement parts. Specify UPC 193175437723 when ordering parts.

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**PLEASE READ THE FOLLOWING CAREFULLY**

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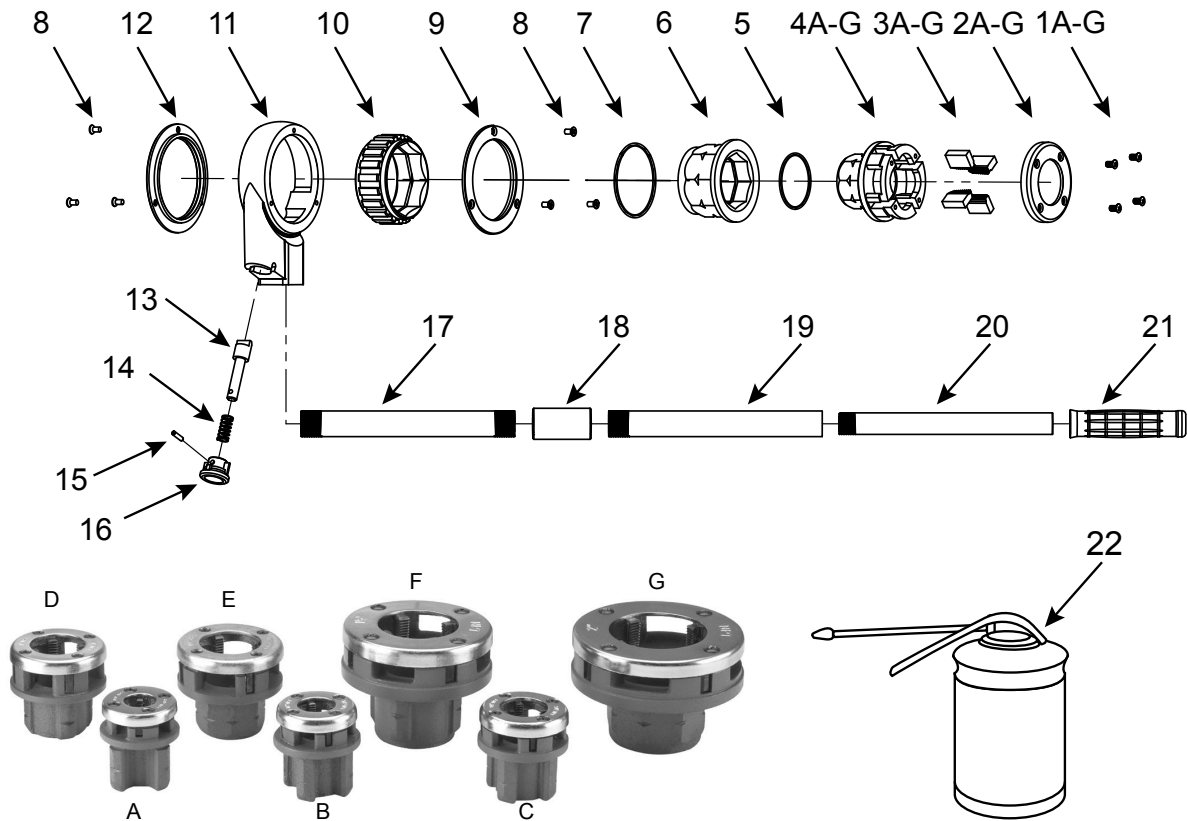
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# Parts List and Diagram

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

| Part | Description                    | Qty |
|------|--------------------------------|-----|
| 4F   | 1-1/2" Die Ratchet Coupling    | 1   |
| 1G   | 2" Die Screw                   | 4   |
| 2G   | 2" Die Cover                   | 1   |
| 3G   | 2" Die Blade Set               | 4   |
| 4G   | 2" Die Ratchet Coupling        | 1   |
| 5    | Small Retaining Ring           | 1   |
| 6    | Die Ratchet Coupling Connector | 1   |
| 7    | Large Retaining Ring           | 1   |
| 8    | Screw                          | 6   |
| 9    | Plate                          | 1   |
| 10   | Ratchet                        | 1   |
| 11   | Ratchet Holder                 | 1   |
| 12   | Plate                          | 1   |
| 13   | Pawl                           | 1   |
| 14   | Spring                         | 1   |
| 15   | Pin                            | 1   |
| 16   | Knob                           | 1   |
| 17   | Tube 1                         | 1   |
| 18   | Connector                      | 1   |
| 19   | Tube 2                         | 1   |
| 20   | Handle                         | 1   |
| 21   | Handle Sleeve                  | 1   |
| 22   | Oil Can                        | 1   |



## Limited 90 Day Warranty

Harbor Freight Tools Co. makes every effort to assure that its products meet high quality and durability standards, and warrants to the original purchaser that this product is free from defects in materials and workmanship for the period of 90 days from the date of purchase. This warranty does not apply to damage due directly or indirectly, to misuse, abuse, negligence or accidents, repairs or alterations outside our facilities, criminal activity, improper installation, normal wear and tear, or to lack of maintenance. We shall in no event be liable for death, injuries to persons or property, or for incidental, contingent, special or consequential damages arising from the use of our product. Some states do not allow the exclusion or limitation of incidental or consequential damages, so the above limitation of exclusion may not apply to you. THIS WARRANTY IS EXPRESSLY IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING THE WARRANTIES OF MERCHANTABILITY AND FITNESS.

To take advantage of this warranty, the product or part must be returned to us with transportation charges prepaid. Proof of purchase date and an explanation of the complaint must accompany the merchandise. If our inspection verifies the defect, we will either repair or replace the product at our election or we may elect to refund the purchase price if we cannot readily and quickly provide you with a replacement. We will return repaired products at our expense, but if we determine there is no defect, or that the defect resulted from causes not within the scope of our warranty, then you must bear the cost of returning the product.

This warranty gives you specific legal rights and you may also have other rights which vary from state to state.



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