

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.



RATCHETING PIPE THREADER SET



Item 62353 shown.

Visit our website at: <http://www.harborfreight.com>
Email our technical support at: productsupport@harborfreight.com

ITEMS
62353 62354

REV 14d

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

Item	62353	62354
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)	1/2" (14 TPI), 3/4" (14 TPI), 1" (11.5 TPI)
Kit Includes	Ratchet Head with Coupler, 3 Handles, 7 Dies, and Blowmold Case	Ratchet Head with Coupler, 2 Handles, 3 Dies, and Blowmold Case

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. **Fully engage the direction switch in the “in” or “out” position before use.**
18. **WARNING:** Some dust created by power sanding, sawing, grinding, drilling, and other construction activities, contains chemicals known [to the State of California] to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:
 - Lead from lead-based paints
 - Crystalline silica from bricks and cement or other masonry products
 - Arsenic and chromium from chemically treated lumberYour risk from these exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals: work in a well ventilated area, and work with approved safety equipment, such as those dust masks that are specially designed to filter out microscopic particles.
(California Health & Safety Code § 25249.5, *et seq.*)
19. 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

1. Assemble the Handle Rod parts and insert threaded portion of 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 over the end of the pipe to be threaded. Verify that the inside diameter of the Die matches the outside diameter of the pipe (see Figure A).

These measurements should be equal.

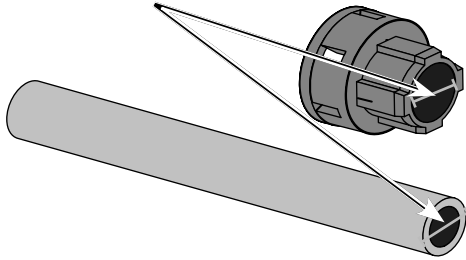


Figure A

5. Insert the Die into the Ratchet Holder. 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 (see Figure B).

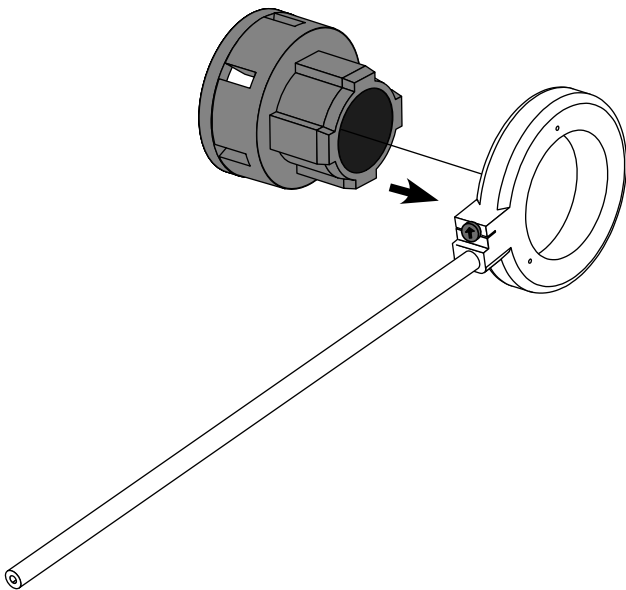


Figure B

6. Fill an Oil Can with Thread Cutting Oil (not included). Keep it nearby during the threading operation.

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.

7. Make sure that the pipe to be threaded is properly secured in a vise.
8. While applying pressure to the end of the pipe, use the Handle to rotate the Ratchet Holder around the pipe to engage the Die with the pipe end (see Figure C). Continue this operation until the desired thread length is achieved.

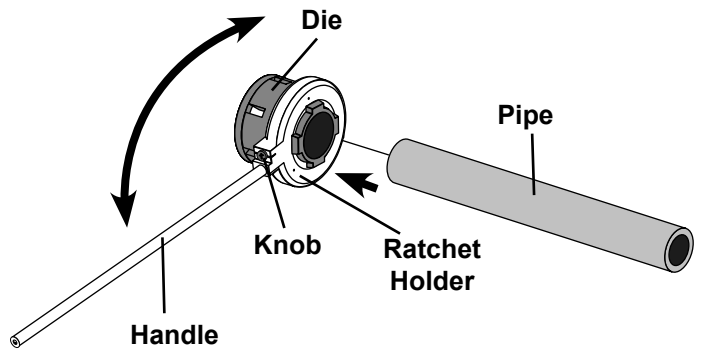


Figure C

9. 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 and drop it back into place. Use the Handle to rotate the Ratchet Holder until the Die disengages fully from the pipe end.
10. When sliding the pipe out of the Ratchet Holder, be careful not to damage newly cut threads.

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.

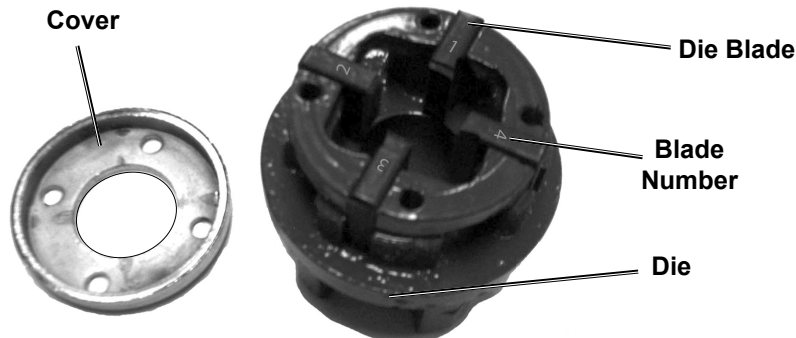
To replace the Die Blades

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 Die.
2. Remove the Cover from the Die.
3. Remove all four Die Blades.
4. Insert four new Die Blades into the Die.

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.

5. Once the Die Blades are properly inserted, replace the Cover and four Screws.



Record Serial Number Here:

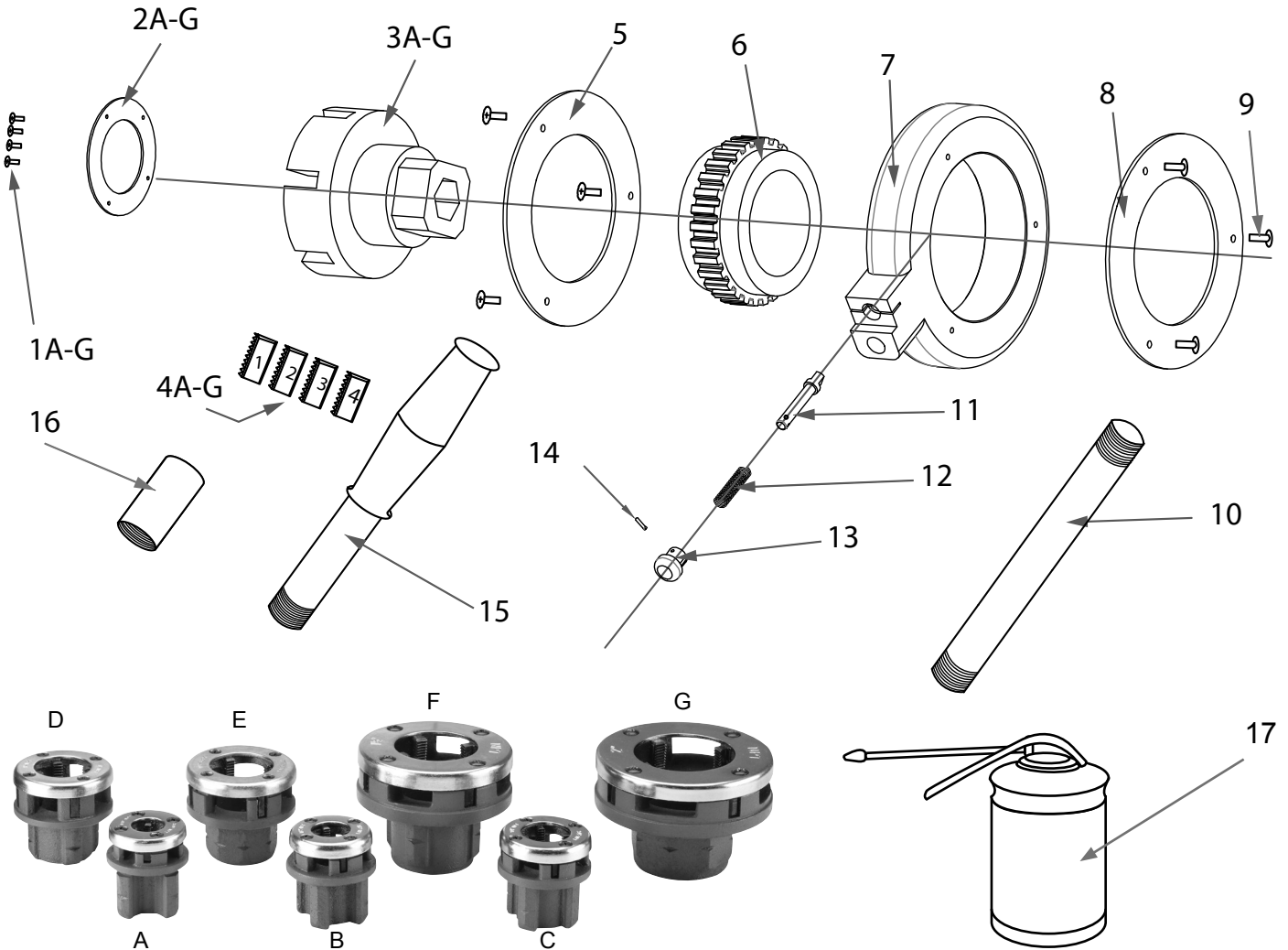
Note: If product has no serial number, record month and year of purchase instead.

Note: Some parts are listed and shown for illustration purposes only, and are not available individually as replacement parts.

Parts List and Diagram (62353)

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

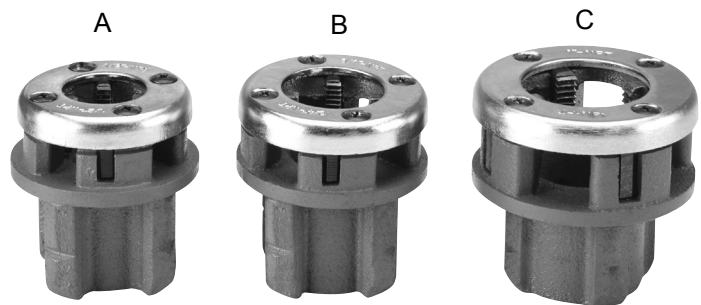
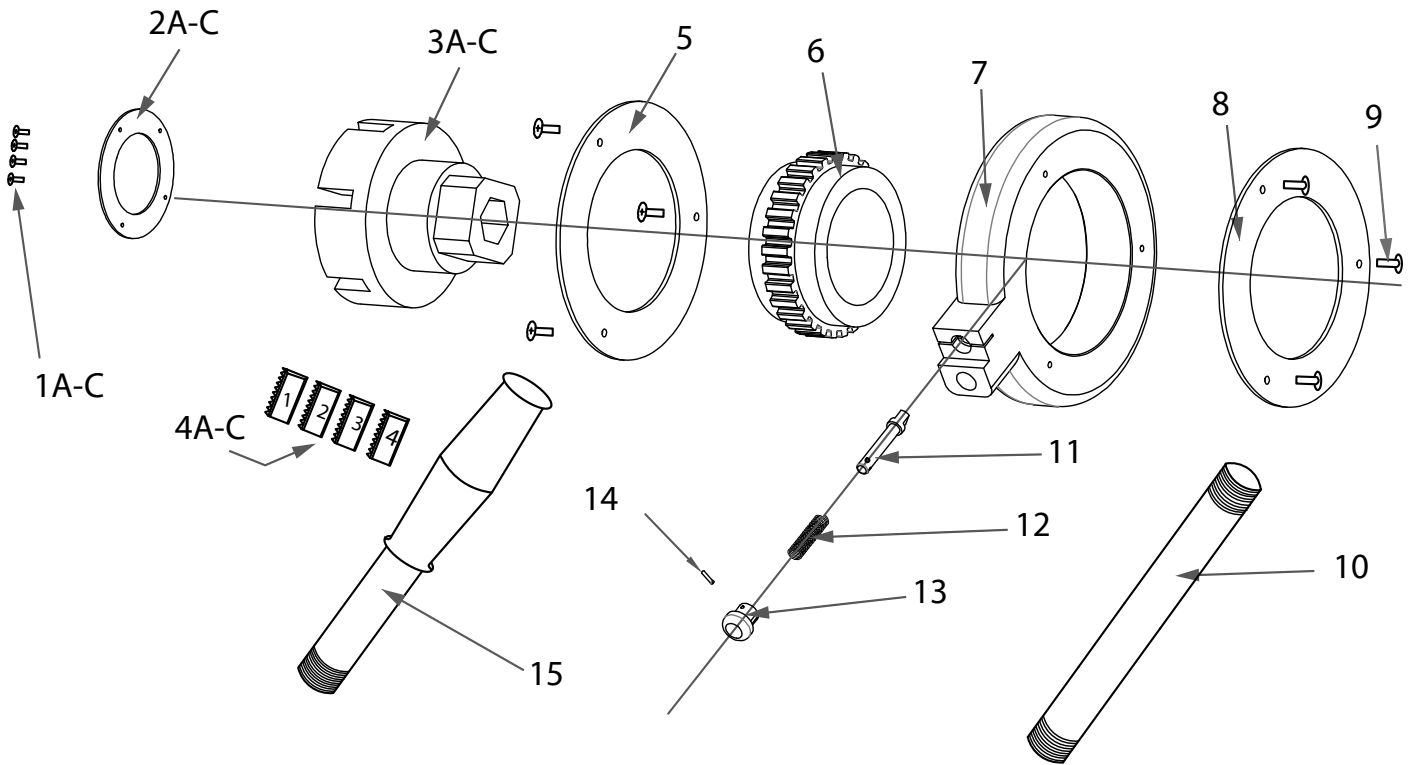
Part	Description	Qty
2F	1-1/2" Die Cover	1
3F	1-1/2" Die Ratchet Coupling	1
4F	1-1/2" Die Blade Set	4
1G	2" Die Screw	4
2G	2" Die Cover	1
3G	2" Die Ratchet Coupling	1
4G	2" Die Blade Set	4
5	Plate	1
6	Ratchet	1
7	Ratchet Holder	1
8	Plate	1
9	Screw	6
10	Handle Tube	2
11	Pawl	1
12	Spring	1
13	Knob	1
14	Pin	1
15	Handle	1
16	Handle Connector	2
17	Oil Can	1



Parts List and Diagram (62354)

Part	Description	Qty
1A	1/2" Die Screw	4
2A	1/2" Die Cover	1
3A	1/2" Die Ratchet Coupling	1
4A	1/2" Die Blade Set	4
1B	3/4" Die Screw	4
2B	3/4" Die Cover	1
3B	3/4" Die Ratchet Coupling	1
4B	3/4" Die Blade Set	4
1C	1" Die Screw	4
2C	1" Die Cover	1
3C	1" Die Ratchet Coupling	1
4C	1" Die Blade Set	4

Part	Description	Qty
5	Plate	1
6	Ratchet	1
7	Ratchet Holder	1
8	Plate	1
9	Screw	6
10	Handle Tube	2
11	Pawl	1
12	Spring	1
13	Knob	1
14	Pin	1
15	Handle	1



PLEASE READ THE FOLLOWING CAREFULLY

THE MANUFACTURER AND/OR DISTRIBUTOR HAS PROVIDED THE PARTS LIST AND ASSEMBLY DIAGRAM IN THIS DOCUMENT AS A REFERENCE TOOL ONLY. NEITHER THE MANUFACTURER OR DISTRIBUTOR MAKES ANY REPRESENTATION OR WARRANTY OF ANY KIND TO THE BUYER THAT HE OR SHE IS QUALIFIED TO MAKE ANY REPAIRS TO THE PRODUCT, OR THAT HE OR SHE IS QUALIFIED TO REPLACE ANY PARTS OF THE PRODUCT. IN FACT, THE MANUFACTURER AND/OR DISTRIBUTOR EXPRESSLY STATES THAT ALL REPAIRS AND PARTS REPLACEMENTS SHOULD BE UNDERTAKEN BY CERTIFIED AND LICENSED TECHNICIANS, AND NOT BY THE BUYER. THE BUYER ASSUMES ALL RISK AND LIABILITY ARISING OUT OF HIS OR HER REPAIRS TO THE ORIGINAL PRODUCT OR REPLACEMENT PARTS THERETO, OR ARISING OUT OF HIS OR HER INSTALLATION OF REPLACEMENT PARTS THERETO.

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.

