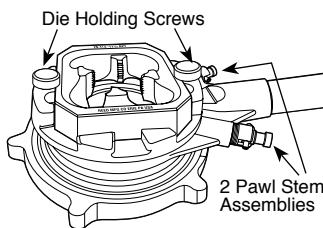




Adjustable Guide Threader Operating Instructions

1. Loosen the two die holding screws approximately two turns. Grasp the two sides of the die opposite the die holding screws and lift one side clear of the stock. Then slide the die out. (Just reverse the operation to insert the die to be used.)
2. Clean the stock of chips and dirt before inserting another die.
3. Tighten the die holding screws finger tight.
4. Turn the ratchet pawl to point in the direction to go.
5. The adjustable guide must be opened enough to slip the stock onto the pipe.
6. Center the piece to be threaded in the throat of the die. Tighten the guide jaws against the piece to be threaded and then open the guide jaws a little for the out-of-roundness.
7. If using a threading machine, start the machine and keep holding the die firmly against the piece being threaded until threads are well started. Make sure the die is covered with Reed Threadguard cutting oil.
8. If cutting by hand, use Threadguard cutting oil liberally. The dies will cut a better thread and last longer.



NOTE:

1. You can thread plastic-coated pipe without removing the plastic.
2. You can thread up to a coupling.
3. By removing the die holding screw and turning over the die, you can thread up to 1/2" of a wall.

Set Available Cat. No.	Pipe Capacity	Die	Size
SD81	1/8" - 1"	0S	2x2"
SD82	1/8" - 1 1/4"	1S	2 1/2"x 2 1/2"
SD84	1/2" - 2"	2S	4x4"

REED MANUFACTURING COMPANY

1425 West 8th Street, Erie, PA 16502 USA

Phone: 800-666-3691 or 814-452-3691

Fax: 800-456-1697 or 814-455-1697

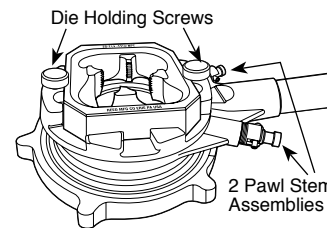
www.reedmfco.com

0119 - 50187



Adjustable Guide Threader Operating Instructions

1. Loosen the two die holding screws approximately two turns. Grasp the two sides of the die opposite the die holding screws and lift one side clear of the stock. Then slide the die out. (Just reverse the operation to insert the die to be used.)
2. Clean the stock of chips and dirt before inserting another die.
3. Tighten the die holding screws finger tight.
4. Turn the ratchet pawl to point in the direction to go.
5. The adjustable guide must be opened enough to slip the stock onto the pipe.
6. Center the piece to be threaded in the throat of the die. Tighten the guide jaws against the piece to be threaded and then open the guide jaws a little for the out-of-roundness.
7. If using a threading machine, start the machine and keep holding the die firmly against the piece being threaded until threads are well started. Make sure the die is covered with Reed Threadguard cutting oil.
8. If cutting by hand, use Threadguard cutting oil liberally. The dies will cut a better thread and last longer.



NOTE:

1. You can thread plastic-coated pipe without removing the plastic.
2. You can thread up to a coupling.
3. By removing the die holding screw and turning over the die, you can thread up to 1/2" of a wall.

Set Available Cat. No.	Pipe Capacity	Die	Size
SD81	1/8" - 1"	0S	2x2"
SD82	1/8" - 1 1/4"	1S	2 1/2"x 2 1/2"
SD84	1/2" - 2"	2S	4x4"

REED MANUFACTURING COMPANY

1425 West 8th Street, Erie, PA 16502 USA

Phone: 800-666-3691 or 814-452-3691

Fax: 800-456-1697 or 814-455-1697

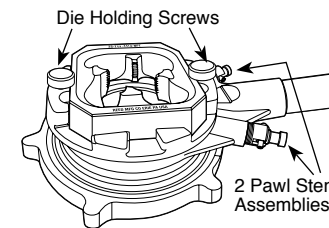
www.reedmfco.com

0119 - 50187



Adjustable Guide Threader Operating Instructions

1. Loosen the two die holding screws approximately two turns. Grasp the two sides of the die opposite the die holding screws and lift one side clear of the stock. Then slide the die out. (Just reverse the operation to insert the die to be used.)
2. Clean the stock of chips and dirt before inserting another die.
3. Tighten the die holding screws finger tight.
4. Turn the ratchet pawl to point in the direction to go.
5. The adjustable guide must be opened enough to slip the stock onto the pipe.
6. Center the piece to be threaded in the throat of the die. Tighten the guide jaws against the piece to be threaded and then open the guide jaws a little for the out-of-roundness.
7. If using a threading machine, start the machine and keep holding the die firmly against the piece being threaded until threads are well started. Make sure the die is covered with Reed Threadguard cutting oil.
8. If cutting by hand, use Threadguard cutting oil liberally. The dies will cut a better thread and last longer.



NOTE:

1. You can thread plastic-coated pipe without removing the plastic.
2. You can thread up to a coupling.
3. By removing the die holding screw and turning over the die, you can thread up to 1/2" of a wall.

Set Available Cat. No.	Pipe Capacity	Die	Size
SD81	1/8" - 1"	0S	2x2"
SD82	1/8" - 1 1/4"	1S	2 1/2"x 2 1/2"
SD84	1/2" - 2"	2S	4x4"

REED MANUFACTURING COMPANY

1425 West 8th Street, Erie, PA 16502 USA

Phone: 800-666-3691 or 814-452-3691

Fax: 800-456-1697 or 814-455-1697

www.reedmfco.com

0119 - 50187