

# User's Manual

## Pipe Tap Cutter Set 62983



Illustration similar, may vary depending on model

Read and follow the operating instructions and safety information before using for the first time.

Technical changes reserved!

Illustrations, functional steps, and technical data may deviate insignificantly due to continuous further developments.

Updating the documentation

If you have suggestions for improvement or have found any irregularities, please contact us.



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## Introduction

Thank you for choosing to purchase this quality product. To minimise the risk of injury, we ask you to always take some basic safety precautions when using this product. Please read this operating manual carefully and make sure that you understand it.

Keep these operation instructions in a safe place.

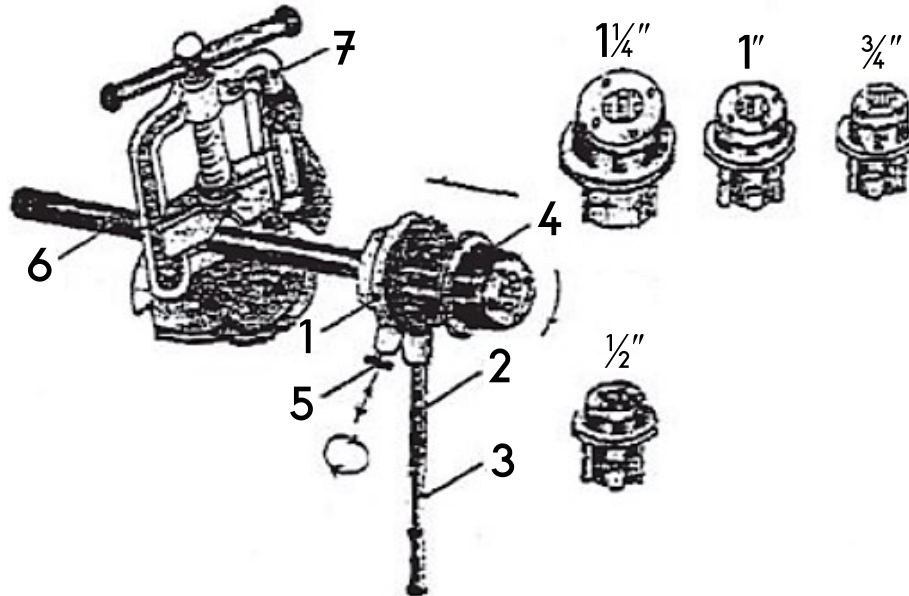
## Safety instructions

- Keep your working area clean and well illuminated. A cluttered and poorly lit workplace increases the risk of accidents and injuries.
- Keep children and bystanders away from your work area.
- Always wear an appropriate protective equipment (e.g., protective glasses, safety gloves, sturdy shoes, etc.).
- During operation, wear suitable clothes. Avoid wearing wide clothes and jewellery and securely tie long hair together.
- Do not stoop down too far. Always keep your balance and always make sure to have a safe stand.
- Always fully concentrate on what you are doing and work with care. Do not use the device when being under the influence of alcohol, drugs, or medicine.
- Do not overcharge the device. Do not use it in an incorrect manner and only in the range of capacity specified.
- Only allow persons trained and familiarised with both the device and the safety instructions to use the device.
- Children and people who, due to their physical, sensory, or mental abilities, to their lack of experience, or to their ignorance, are not able to operate the pipe tap cutter safely, must not use it without supervision or instruction from a responsible person.
- Carefully maintain the device and its accessories on a regular basis. Regularly check the device and its components to know if they are fully operational or if there are damages. Using a damaged pipe tap cutter can provoke damages and injuries.
- Keep the handles proper, dry, and free from oil and lubricating agents.
- Never modify the device itself or its accessories.
- Always operate the device with a safety ring; otherwise, the cutting head might be pressed out of its seat.
- Never hit onto the ratchet lever with a hammer.

## Scope of delivery

- 1× pipe tap cutter with right/left conversion
- 1× cutting head  $\varnothing$  20.96 mm (R 1/2") BSPT
- 1× cutting head  $\varnothing$  26.44 mm (R 3/4") BSPT
- 1× cutting head  $\varnothing$  33.25 mm (R 1") BSPT
- 1× cutting head  $\varnothing$  41.91 mm (R 1 1/4") BSPT
- 2× steel handle piece (ratchet extension screwable with each other)

## Main components and their name



Nº	Name	Nº	Name
1	Thread frame with right/left conversion	5	Ratchet lever
2	Turning rod	6	Workpiece (pipe)
3	Connection rod	7	Vice to pipe (not included in the scope of delivery)
4	Cutting head		

## Use

1. Connect the turning rod (2) with the connection rod (3) and thread frame (1).
2. Set the cutting head (4) into the thread frame (1) with the help of the safety ring. Then turn the tap cutter clockwise or extract the ratchet lever (5) and turn it by 180°.
3. Check if the diameter of the pipe at the position to be threaded answers to the technical requirements.
4. Oil the end of the pipe to be cut to ensure the correct temperature at the position to be threaded and the precision of the thread.
5. Fix the pipe (6) into the pipe vice (7) and set the cutting head (4) onto the pipe. Hold the turning rod (2) with one hand and use the other hand to set the tap cutter onto the pipe; then turn it.
6. Continue until the edge of the pipe has reached the rear wall of the pipe tap cutter. **Warning!** Cutting the thread beyond this point might provoke the cutting edge breaking off.
7. After the thread has been made, extract the ratchet lever (5) and turn it by 180°. Then take the thread frame (1) and cutting head (4) off the pipe.
8. To produce a thread of another size, you can exchange the cutting head (4) of the thread frame.
9. Turn the tap cutter in the direction of the arrow found on the ratchet lever (5).
10. Use an appropriate oil to ensure a flawless operation.

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