

Threading with D-1440 Ratchet

1. Make sure the geared threader is properly set up for stationary pipe operation.
2. Place the D-1440 Ratchet on square end of the drive shaft.
3. Assume a proper operating stance. Make sure that your footing is good and you are well balanced. For maximum leverage, you will want to use your body weight on the handle of the ratchet. Make sure the set up is stable.
4. Use the ratchet to turn the driveshaft. Rotation should be clockwise as viewed from the end of the pipe. Flood the dies with oil while threading to lower threading torque, improve thread quality and increase die life.



Figure 7 – D-1440 Ratchet Operation

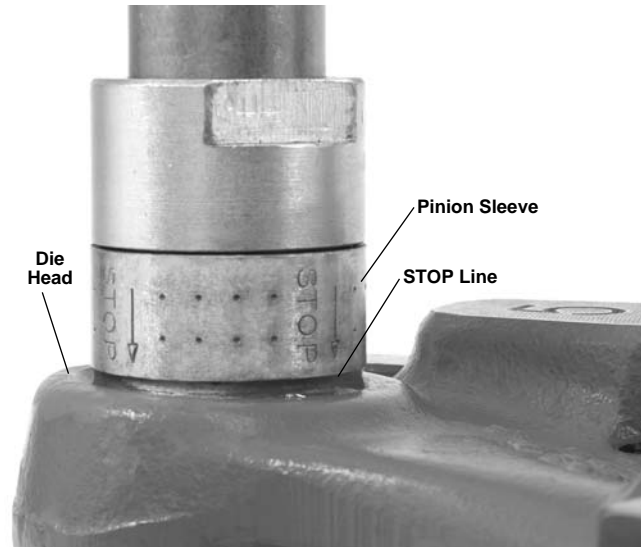


Figure 8 – Thread Complete – Top of Die Head Flush With STOP Line

5. Continue ratcheting until the top edge of the die head is flush with the red stop line on the pinion sleeve (see Figure 8).
6. Remove the ratchet and turn over. Rotate the drive shaft counterclockwise to back the die head up approximately one turn.
7. Pull out cam plate knobs and rotate cam plate towards the "CD" mark on top of the die head to retract the dies. This prevents the dies from dragging while returning the geared threader to the start position.
8. Rotate drive shaft counterclockwise to back the die head to the appropriate starting point for the next thread.
9. Carefully remove the geared threader from the pipe and inspect threads.