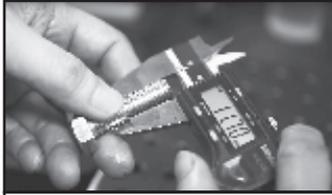


4 Pcs Tap & Die Set

Art. Nr: PT5943



1. Cutting Female Threads (taps)



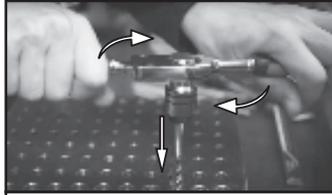
A. Measure the external diameter of the bolt you wish to use.



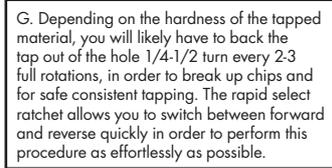
B. Determine the thread pitch using the thread gauge included with the product. The prongs on the thread pitch must fit exactly into the screw thread.



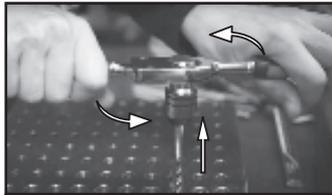
C. Choose the correct tap. The corresponding size information can be found on the thread gauge and the tap. Insert the tap into one of the two tap holders. Fix the tap in place so that it cannot fall out of the holder. Please note that one tap holder is designated for small taps and the other tap holder is designed for large taps. Insert the tap holder into the tap wrench.



F. Start to cut the thread. The first 4 cutting edges of the tap are chamfered to allow for alignment with the hole. Turn the handle in a clockwise direction, maintaining a 90° perpendicular relationship with tap and hole.



G. Depending on the hardness of the tapped material, you will likely have to back the tap out of the hole 1/4-1/2 turn every 2-3 full rotations, in order to break up chips and for safe consistent tapping. The rapid select ratchet allows you to switch between forward and reverse quickly in order to perform this procedure as effortlessly as possible.



H. When tapping of the hole is finished, from behind the tap, blow chips out with pressurized air. Move the arm on the ratchet to select reverse and slowly back the tap out of the hole, being careful on the last few turns not to catch and damage the threads when removing the tap.



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2. Cutting Male Threads (dies)



D. Locate or drill your own appropriately sized hole for the tap being used (see chart on page).



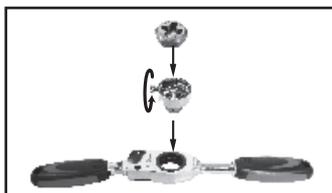
E. Apply a small amount of cutting oil to the tap.



A. Measure the outside diameter of the blank or threaded bolt. If tracing the threads on a bolt, also measure the thread pitch with the thread gauge.



B. Choose the correct bolt die. Insert the bolt die into the die holder. Secure the bolt die using the screw on the die holder.



C. Insert the die holder into the tap wrench (ratchet).

D. Set the direction of rotation for the handle to the forward position.

E. Apply a small amount of cutting oil to the work piece. Ratchet the tool in a clockwise direction. Make sure the ratchet is aligned with the work piece.



F. Throughout the cut, use the Rapid select ratchet to quickly switch back and forth between forward and reverse to break up the chips for a cleaner cut.



G. Set the handle to the reverse position. Use pressurized air to blow the chips from the work piece. Ratchet the bolt die counter-clockwise to remove the die from the workpiece.



H. Clean the rest of the chips from the threads and check your work with a threaded nut before installing bolt. It may be necessary to apply a small amount of oil or using a fine file to ease the edges of the threads before installation.

3. Storage

Apply a small amount of oil to the die and tap for storage. Store the product in a cold and dry place. Ensure that no condensation forms.

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