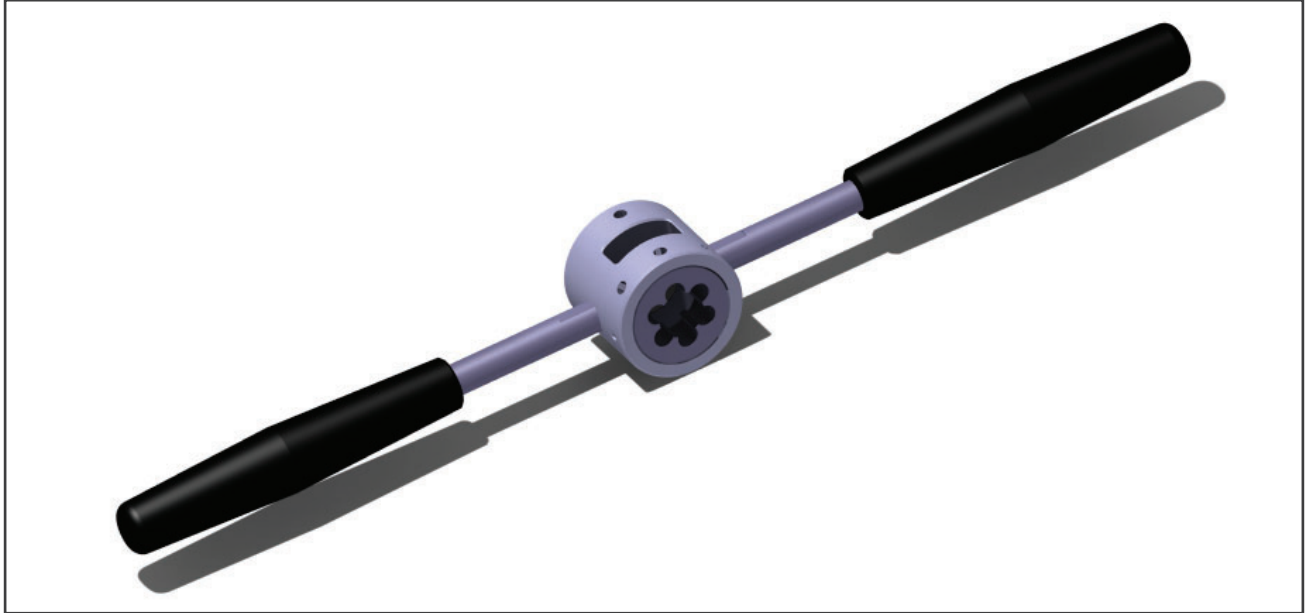


Manual Dies Threading



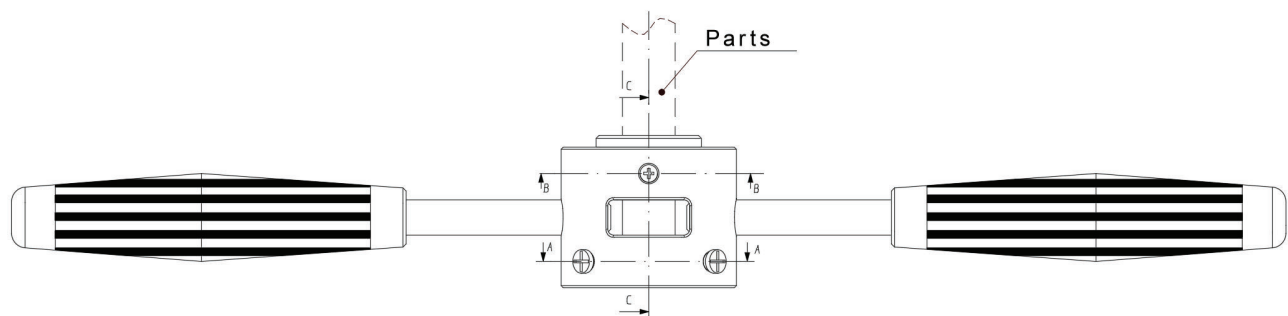
Thread of tubing ends with AUTABA guiding threading

1. Using the Coning Tool Body to hold the tubing for threading, clamp in vise, and slide the threading tool over the tube through the guide bushing.

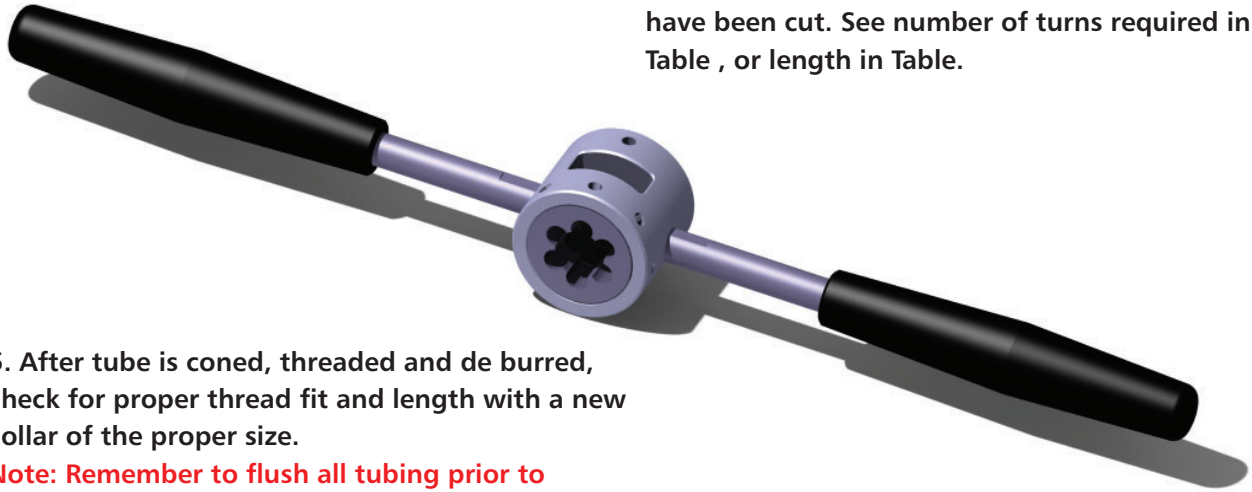
2. Apply a medium weight, high sulphur cutting oil to threading area.

3. Apply pressure to the top of the threading tool to start the cutting action. The threads are left handed, so turn the threader counterclockwise to thread the tube. The threading tool may need to be periodically rotated clockwise to break and discharge metal chips. Apply lubricant freely during the threading process.

Note: The lead in chamfer (larger chamfer) on the dies flutes toward guide bushing.

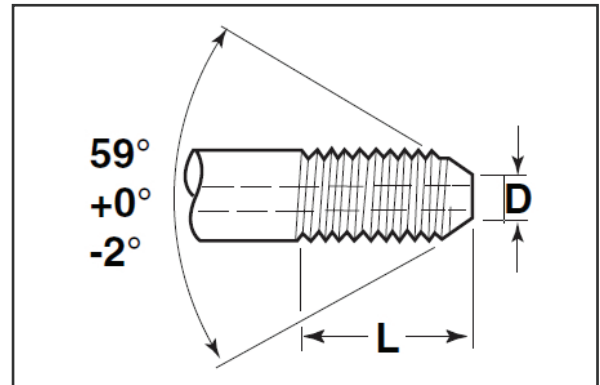


4. Continue to rotate die holder counterclockwise while applying cutting oil generously throughout the process until threads of the following lengths have been cut. See number of turns required in Table , or length in Table.



5. After tube is coned, threaded and de burred, check for proper thread fit and length with a new collar of the proper size.

Note: Remember to flush all tubing prior to installation with a fluid that is compatible with the process fluid being used.



Tool Kits Package

