



WARNING



Study, understand and follow all instructions provided with this product. Read these instructions carefully before installing, operating, servicing or repairing this tool. Keep these instructions in a safe, accessible place.

INTENDED USE OF THE TOOL

This tap and die tool set is designed for cutting male and female threads of the thread pitches included in the kit using the drill bits provided in this set or other high quality appropriate size drill bits. This set is only suitable for experienced technicians. Tap only appropriately sized holes (see page 2); undersized holes will cause damage to the tool or work piece. Do not use this tool outside of the designed intent. Never modify the tool for any other purpose or use.



WARNING



Caution: To help prevent personal injury

- Use of this product can expose you to chemicals including ethylene glycol, gasoline vapors and engine exhaust, which are known to the State of California to cause cancer, birth defects, or reproductive harm. For more information, visit www.P65Warnings.ca.gov. Always wear ANSI approved safety equipment, safety glasses and clothing when using this product. Study, understand, and follow all instructions provided with this product. Failure to read and follow all warnings and operating instructions may result in damages and serious injury or death.
- Always wear ANSI approved goggles when using this product. (Users and Bystanders).
- Never use this tool for any application other than for which it was designed.
- Only use accessories designed for this tool.
- Never alter or modify this tool in any way.
- Improper operation and/or maintenance of the tool, modification of the tool, or use of the tool with accessories not designed for it could result in serious injury or death.
- Always select the correct accessories of the correct size and design for the job that you are attempting to perform.
- Always work in a clean, safe, well-lit, organized and adequately equipped area.
- Do not begin repairs without assurance that vehicle is in secure position, and will not move during repair.

BEFORE USE

When unpacking, check the parts diagram and part number listing on page 16-17 to make sure all parts are included. If any parts are missing or damaged, please call your distributor.



Made in Taiwan
to Matco specifications
PAT. No. US8616095 B2

(M) MIXED WARRANTY

(Lifetime and Consumable)

The manufacturer warrants this product to the original user against defective material or workmanship for either a period of lifetime, or consumable (drill bits 1/4" and below only). Ask your distributor for more details.

The manufacturer reserves the right to determine whether the part(s) failed because of defective material, workmanship or other causes. Failures caused by accident, alteration or misuse are not covered by this warranty.

Replacements under warranty also carry a Lifetime Warranty. The rights under this warranty are limited to the original user and may not be transferred to subsequent owners.

The warranty is in lieu of all other warranties, expressed or implied, including warranties of merchantability and fitness for a particular purpose.

Some states do not allow the exclusion or limitations of incidental or consequential damages, so the above limitations may not apply to you.

PRODUCT INFORMATION:

- Includes extractors and drill bits in the following sizes: Extractor #1, #2, #3, #4, #5.
Drill bit No. 3, 7, 9, 16, 19, 20, 21, 25, 29, 30, 36, 39, 43, Letter B, F, H, I, J, Q, O, R, S, T, U, Z and Fractional sizes 5/64", 7/64", 5/32", 1/4", 19/64", 5/16", 21/64", 3/8", 25/64", 13/32", 27/64", 7/16", and 29/64".
- Includes taps and dies in the following sizes: M3x0.5, M3x0.6, M4x0.7, M4x0.75, M5x0.8, M5x0.9, M6x1.0, M7x1.0, M8x1.0, M8x1.25, M9x1.0, M9x1.25, M10x1.0, M10x1.25, M10x1.5, M11x1.5, M12x1.25, M12x1.5, M12x1.75, 1/8BSP, 4-40, 6-32, 8-32, 10-24, 10-32, 12-24, 1/4-20, 1/4-28, 5/16-18, 5/16-24, 3/8-16, 3/8-24, 7/16-14, 7/16-20, 1/2-13, 1/2-20, 1/8NPT

DO NOT DISCARD – GIVE TO USER

DRILL GUIDE

Below you will find the included tap and extractor sizes as well as the drill bits that pair with them. Select the thread pitch you intend to tap, then match it with the drill bit size listed below. In rare cases if your material is exceptionally thin or thick, you may need to step up (thick) or down (thin) in drill size within the pouch provided, however the below drill bit pairings work with the majority of applications. The chart below also includes part numbers for each piece found in this kit.

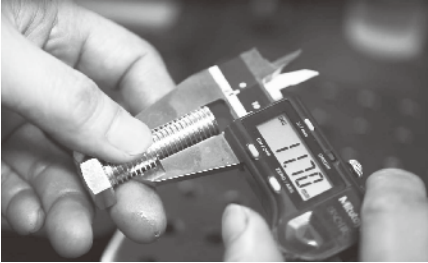
	Thread Size	Tap Part #	Die Part #	Drill Bit Size	Drill Bit Part #
Machine Screw	4-40 NC	MT440T	MT440D	No. 43	43A
	6-32 NC	MT632T	MT632D	No. 36	36A
	8-32 NC	MT832T	MT832D	No.29	29A
	10-24 NC	MT1024T	MT1024D	No. 25	25A
	10-32 NC	MT1032T	MT1032D	No. 21	21A
	12-24 NC	MT1224T	MT1224D	No. 16	16A
Fractional	1/4"-20 NC	MT1420T	MT1420D	No. 7	7A
	1/4"-28 NF	MT1428T	MT1428D	No. 3	3A
	5/16"-18 NC	MT51618T	MT51618D	Letter F	HDF
	5/16"-24 NF	MT51624T	MT51624D	Letter I	HDI
	3/8"-16 NC	MT3816T	MT3816D	5/16"	HD20A
	3/8"-24 NF	MT3824T	MT3824D	Letter Q	HDQ
	7/16"-14 NC	MT71614T	MT71614D	Letter U	HDU
	7/16"-20 NF	MT71620T	MT71620D	25/64"	HD2538A
	1/2"-13 NC	MT1213T	MT1213D	27/64"	HD2738A
	1/2"-20 NF	MT1220T	MT1220D	29/64"	HD2938A
Metric	M3x0.6	MT306T	MT306D	No. 39	39A
	M3x0.5	MT305T	MT305D	No. 39	39A
	M4x0.75	MT4075T	MT4075D	No. 30	30A
	M4x0.7	MT407T	MT407D	No. 30	30A
	M5x0.9	MT509T	MT509D	No. 20	20A
	M5x0.8	MT508T	MT508D	No. 19	19A
	M6x1.0	MT610T	MT610D	No. 9	9A
	M7x1.0	MT710T	MT710D	Letter B	HDB
	M8x1.25	MT8125T	MT8125D	Letter J	HDJ
	M8x1.0	MT810T	MT810D	Letter H	HDH
	M9x1.25	MT9125T	MT9125D	5/16"	HD20A
	M9x1.0	MT910T	MT910D	Letter O	HDO
	M10x1.5	MT1015T	MT1015D	Letter R	HDR
	M10x1.25	MT10125T	MT10125D	Letter S	HDSA
	M10x1.0	MT1010T	MT1010D	Letter T	HDT
	M11x1.5	MT1115T	MT1115D	3/8"	HD24A
	M12x1.75	MT12175T	MT12175D	13/32"	HD2638A
	M12x1.5	MT1215T	MT1215D	Letter Z	HDZRS
	M12x1.25	MT12125T	MT12125D	7/16" *	HD2838A
Pipe	1/8"-27 NPT	MT1827T	MT1827D	Letter Q	HDQ
	1/8"-28 BSP	MT1828T	MTBSP28	21/64"	HD21A
Extractor	Extractor Size		Extractor part #	Drill Bit Size	Drill Bit Part #
	Extractor #1		EO1A	5/64"	HD510A
	Extractor #2		EO2A	7/64"	HD710A
	Extractor #3		EO3A	5/32"	HD1010A
	Extractor #4		EO4A	1/4"	HD1610A
	Extractor #5		EO5A	19/64"	HD19A

* F/ material < 1/2" use 27/64"

USAGE INFORMATION

a.) Cutting Female Threads (Taps)

- (1) Measure the external diameter of the bolt you wish to use.



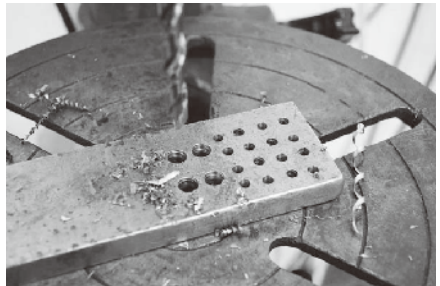
- (2) Determine the thread pitch using the thread gauge included with the product. The prongs on the thread pitch must fit exactly into the screw thread.



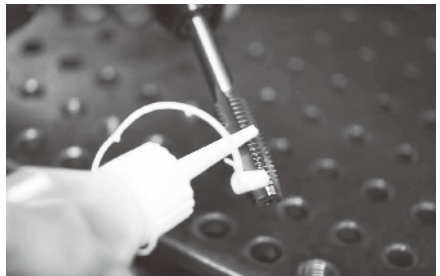
- (3) Choose the correct tap. The corresponding size information can be found on the thread gauge and the tap. Insert the tap into one of the two tap holders. Fix the tap in place so that it cannot fall out of the holder. Please note that one tap holder is designed for small taps and the other tap holder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



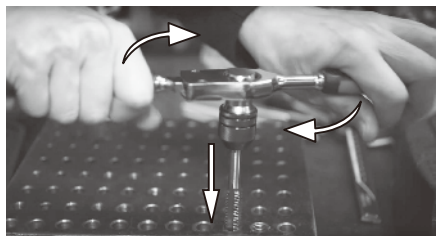
- (4) Locate or drill your own appropriately sized hole for the tap being used with the drill bits provided in the drill pouch in this kit (see page 2).



- (5) Apply a small amount of cutting oil to the tap.

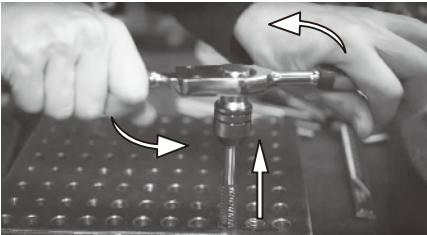


- (6) Start to cut the thread. The first 4 cutting edges of the tap are chamfered to allow for alignment with the hole. Turn the handle in a clockwise direction, maintaining a 90° perpendicular relationship with tap and hole.



(7) 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 and 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.

(8) 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.

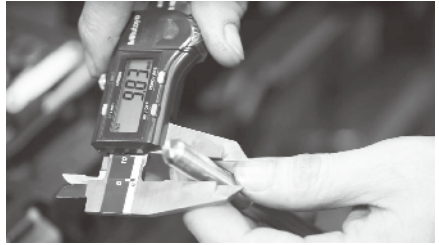


(9) Blow out all remaining chips from the work area and install fastener.



b.) Cutting Male Threads (Dies)

(1) 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.



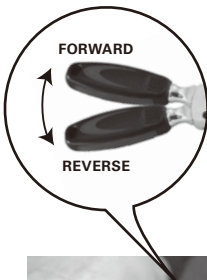
(2) Choose the correct bolt die. Insert the bolt die into the die holder. Secure the bolt die using the screw on the die holder.



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

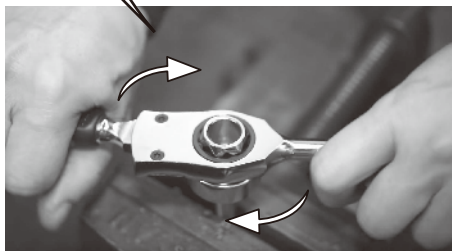


- (4) Set the direction of rotation for the handle to the forward position.

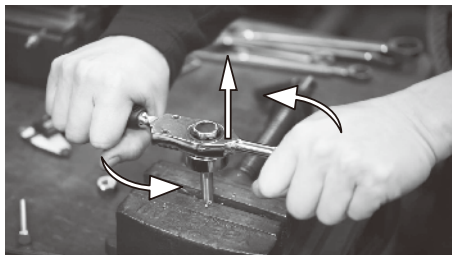


- (5) Apply a small amount of cutting oil to the work piece. Ratchet the tool in a clockwise direction. Make sure the ratchet is aligned with the work piece.

- (6) 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.



- (7) 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.



- (8) 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.



c.) Storage

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



ADVERTENCIA



Estudie, entienda y siga todas las instrucciones que se proveen con este producto. Lea las instrucciones detenidamente antes de instalar, operar, dar servicio o reparar esta herramienta. Guarde estas instrucciones en un lugar seguro y accesible.

EL USO DE LA HERRAMIENTA

This tap and die tool set is designed for cutting male and female threads of the thread pitches included in the kit using the drill bits provided in this set our other high quality appropriate size drill bits. This set is only suitable for experienced technicians. Tap only appropriately sized holes (see page 2); undersized holes will cause damage to the tool or work piece. Do not use this tool outside of the designed intent. Never modify the tool for any other purpose or use.



ADVERTENCIA



Precaución: Para ayudar a evitar lesiones a las personas

- El uso de este producto puede exponerlo a productos químicos que incluyen etilenglicol, vapores de gasolina y gases de escape del motor, que en el estado de California son causantes de cáncer, defectos de nacimiento o daños reproductivos. Para obtener más información, visite www.P65Warnings.ca.gov. Siempre use equipo de seguridad aprobado por ANSI, gafas de seguridad y ropa cuando use este producto. Estudie, comprenda y siga todas las instrucciones proporcionadas con este producto. Si no lee y sigue todas las advertencias e instrucciones de funcionamiento puede ocasionar daños y lesiones graves o la muerte.
- Siempre use guantes del tipo aprobado por la ANSI para trabajar con esta herramienta (tanto usuarios como espectadores).
- Nunca utilice esta herramienta para cualquier otra cosa que no sean las aplicaciones para lo que fue diseñada.
- Sólo utilice los accesorios diseñados para esta herramienta.
- No modifique o altere esta herramienta de ninguna manera.
- El funcionamiento y/o mantenimiento inadecuado de la herramienta, la modificación, o la utilización de la herramienta con accesorios inadecuados podrían causar lesiones graves o la muerte.
- Siempre usar los correctos accesorios para el trabajo que Ud. está realizando.
- Trabaje siempre en un área limpia, segura, bien iluminada, organizada y equipada adecuadamente.
- Nunca empiece reparaciones sin estar seguro de que el vehículo esté en posición segura y que no se mueva durante la reparación.

DESEMPACADO

Cuando desempaque el producto, revise el diagrama y la lista de piezas en página 16-17 para verificar que se hayan enviado todas las piezas. De perder piezas o tener piezas dañadas, favor llamar a su distribuidor inmediatamente.



HECHO en Taiwán
Para Matco especificaciones
PAT. No. US8616095 B2

(M) MIXED WARRANTY (Lifetime and Consumable)

The manufacturer warrants this product to the original user against defective material or workmanship for either a period of lifetime, or consumable (drill bits 1/4" and below only). Ask your distributor for more details.

El fabricante se reserva el derecho de determinar si la pieza, o partes fallaron debido al material y/o mano de obra defectuosos u otras causas. Las fallas causadas por accidentes, alteraciones o mal uso no están cubiertas por esta garantía.

Los reemplazos bajo garantía también llevan una garantía de por vida. Los derechos bajo esta garantía están limitados al usuario original y no pueden ser transferidos a los propietarios posteriores.

Esta garantía es en lugar de todas las demás garantías, expresas o implícitas, incluyendo garantías de comerciabilidad y adecuación para un propósito particular.

Algunos Estados no permiten la exclusión o limitaciones de daños incidentales o consecuentes, por lo que las limitaciones anteriores pueden no aplicarse a usted

INFORMACIÓN DEL PRODUCTO:

- Includes extractors and drill bits in the following sizes:
Extractor #1, #2, #3, #4, #5.
Drill bit No. 3, 7, 9, 16, 19, 20, 21, 25, 29, 30, 36, 39, 43, Letter B, F, H, I, J, Q, O, R, S, T, U, Z and Fractional sizes 5/64", 7/64", 5/32", 1/4", 19/64", 5/16", 21/64", 3/8", 25/64", 13/32", 27/64", 7/16", and 29/64".
- Includes taps and dies in the following sizes:
M3x0.5, M3x0.6, M4x0.7, M4x0.75, M5x0.8, M5x0.9, M6x1.0, M7x1.0, M8x1.0, M8x1.25, M9x1.0, M9x1.25, M10x1.0, M10x1.25, M10x1.5, M11x1.5, M12x1.25, M12x1.5, M12x1.75, 1/8BSP, 4-40, 6-32, 8-32, 10-24, 10-32, 12-24, 1/4-20, 1/4-28, 5/16-18, 5/16-24, 3/8-16, 3/8-24, 7/16-14, 7/16-20, 1/2-13, 1/2-20, 1/8NPT

NO LO DESCARTE O DESECHE, ENTREGUELO AL USUARIO

DRILL GUIDE

Below you will find the included tap and extractor sizes as well as the drill bits that pair with them. Select the thread pitch you intend to tap, then match it with the drill bit size listed below. In rare cases if your material is exceptionally thin or thick, you may need to step up (thick) or down (thin) in drill size within the pouch provided, however the below drill bit pairings work with the majority of applications. The chart below also includes part numbers for each piece found in this kit.

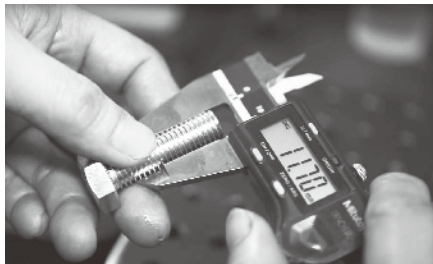
	Thread Size	Tap Part #	Die Part #	Drill Bit Size	Drill Bit Part #
Machine Screw	4-40 NC	MT440T	MT440D	No. 43	43A
	6-32 NC	MT632T	MT632D	No. 36	36A
	8-32 NC	MT832T	MT832D	No.29	29A
	10-24 NC	MT1024T	MT1024D	No. 25	25A
	10-32 NC	MT1032T	MT1032D	No. 21	21A
	12-24 NC	MT1224T	MT1224D	No. 16	16A
Fractional	1/4"-20 NC	MT1420T	MT1420D	No. 7	7A
	1/4"-28 NF	MT1428T	MT1428D	No. 3	3A
	5/16"-18 NC	MT51618T	MT51618D	Letter F	HDF
	5/16"-24 NF	MT51624T	MT51624D	Letter I	HDI
	3/8"-16 NC	MT3816T	MT3816D	5/16"	HD20A
	3/8"-24 NF	MT3824T	MT3824D	Letter Q	HDQ
	7/16"-14 NC	MT71614T	MT71614D	Letter U	HDU
	7/16"-20 NF	MT71620T	MT71620D	25/64"	HD2538A
	1/2"-13 NC	MT1213T	MT1213D	27/64"	HD2738A
	1/2"-20 NF	MT1220T	MT1220D	29/64"	HD2938A
Metric	M3x0.6	MT306T	MT306D	No. 39	39A
	M3x0.5	MT305T	MT305D	No. 39	39A
	M4x0.75	MT4075T	MT4075D	No. 30	30A
	M4x0.7	MT407T	MT407D	No. 30	30A
	M5x0.9	MT509T	MT509D	No. 20	20A
	M5x0.8	MT508T	MT508D	No. 19	19A
	M6x1.0	MT610T	MT610D	No. 9	9A
	M7x1.0	MT710T	MT710D	Letter B	HDB
	M8x1.25	MT8125T	MT8125D	Letter J	HDJ
	M8x1.0	MT810T	MT810D	Letter H	HDH
	M9x1.25	MT9125T	MT9125D	5/16"	HD20A
	M9x1.0	MT910T	MT910D	Letter O	HDO
	M10x1.5	MT1015T	MT1015D	Letter R	HDR
	M10x1.25	MT10125T	MT10125D	Letter S	HDSA
	M10x1.0	MT1010T	MT1010D	Letter T	HDT
	M11x1.5	MT1115T	MT1115D	3/8"	HD24A
	M12x1.75	MT12175T	MT12175D	13/32"	HD2638A
	M12x1.5	MT1215T	MT1215D	Letter Z	HDZRS
	M12x1.25	MT12125T	MT12125D	7/16" *	HD2838A
Pipe	1/8"-27 NPT	MT1827T	MT1827D	Letter Q	HDQ
	1/8"-28 BSP	MT1828T	MTBSP28	21/64"	HD21A
Extractor	Extractor Size		Extractor part #	Drill Bit Size	Drill Bit Part #
	Extractor #1		EO1A	5/64"	HD510A
	Extractor #2		EO2A	7/64"	HD710A
	Extractor #3		EO3A	5/32"	HD1010A
	Extractor #4		EO4A	1/4"	HD1610A
	Extractor #5		EO5A	19/64"	HD19A

* F/ material < 1/2" use 27/64"

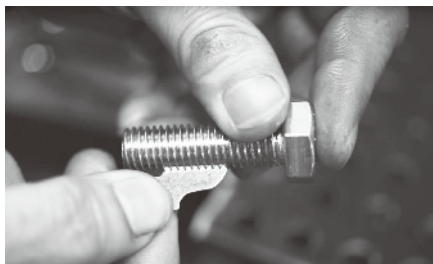
INFORMACION PARA SU USO

a.) Para cortar roscas hembra (Taps)

- (1) Medir el diámetro exterior del perno que desee utilizar.



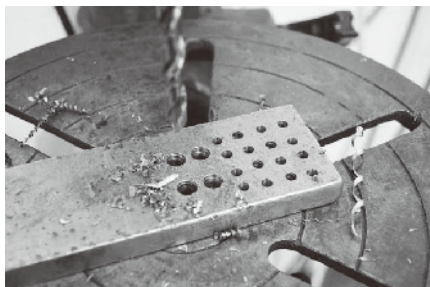
- (2) Determinar el grado de rosca que utilizara con el calibrador que se incluye con el producto. Las puntas de la rosca deben encajar exactamente en el enroscado.



- (3) Seleccione la terraja correcta. La información correspondiente se puede encontrar con el calibrador de brocas y terrajas. Inserte la llave en uno de los dos titulares de la tuerca o terraja. Fijar la terraja en su lugar para que no se caiga fuera del soporte. Tenga en cuenta que uno de los titulares de la terraja está diseñado para pequeños golpeitos y la otra para grandes. Inserte uno de los extremos de la terraja en el trinquete o llave.



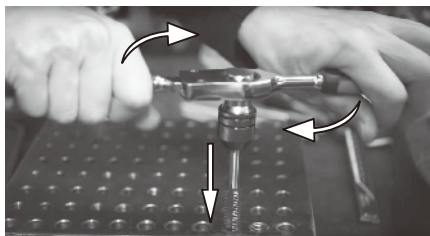
- (4) Locate or drill your own appropriately sized hole for the tap being used with the drill bits provided in the drill pouch in this kit (see page 2).



- (5) Aplicar una pequeña cantidad de aceite antes del corte.

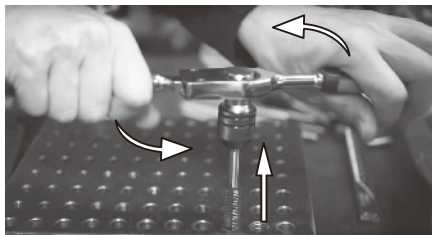


- (6) Comience a cortar el enroscado. Los primeros 4 filos del corte están biselados para permitir la alineación con el agujero. Girar el mango en dirección a las manecillas del reloj, mantener una alineación perpendicular de 90 grados con el agujero.



(7) Dependiendo de la dureza del material tachado, usted será capaz de sacar la terraja del agujero de 1/4 - 1/2 rotando de 2-3 vueltas completas, con el fin de soltar las lascas y para realizar golpes seguros y consistentes. El funcionamiento rápido de la llave o trinquete permite alternar entre el avance y el retroceso más rápidamente a fin de realizar este procedimiento tan fácilmente como sea posible.

(8) Cuando termine de perforar, limpie las lascas o rebabas con aire presurizado haciéndolo de atrás para delante. Mueva el brazo del trinquete para seleccionar la reversa y lentamente sacar la terraja del agujero siendo muy cauteloso en las últimas vueltas de no tocar o dañar el enroscado.

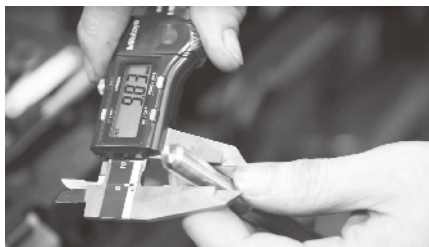


(9) Elimine el resto de las virutas del área de trabajo e instale el sujetador.



b.) Cortar roscas macho (Dies)

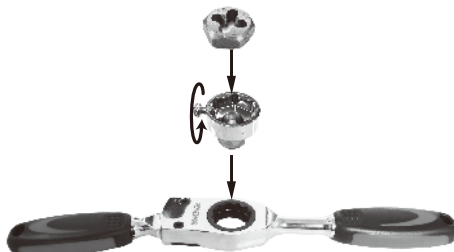
(1) Medir el diámetro exterior del perno en blanco o ya enroscado. Si está siguiendo el enroscado en un perno, también mida las líneas del enroscado con el calibrador.



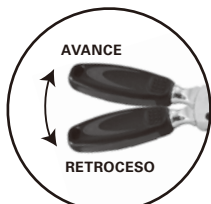
(2) Seleccione el troquel correcto. Insertar el perno en el soporte y fíjelo o asegúrelo firmemente utilizando el tornillo del soporte.



(3) Inserte el sostenedor del troquel o dado en la llave del trinquete.

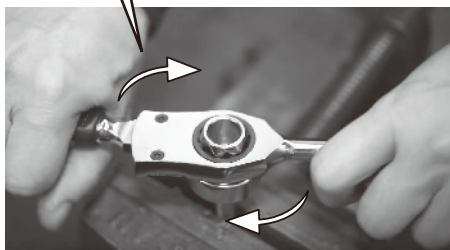


- (4) Establecer la dirección de rotación mediante la palanca de la llave a la posición de avance.

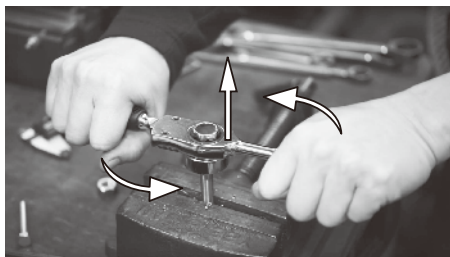


- (5) Aplicar una pequeña cantidad de aceite a la pieza de trabajo. Mueva el trinquete en sentido de las manecillas del reloj. Asegúrese de que el trinquete este en posición perpendicular de 90 grados.

- (6) A lo largo del corte, utilice el sistema rápido del trinquete que puede cambiar rápidamente de adelante hacia atrás para eliminar las virutas y hacer un trabajo más limpio.



- (7) Ajuste el mango a la posición de reversa o marcha atrás. Utilice aire comprimido para soplar las virutas de la pieza de trabajo. Utilice el perno del trinquete en sentido contrario a las manecillas del reloj para soltar el perno de la pieza de trabajo.



- (8) Limpiar el resto de las virutas de las roscas y comprobar la efectividad de su trabajo enroscando una tuerca antes de instalar el perno definitivo. Puede ser necesario aplicar una pequeña cantidad de aceite o para suavizar los bordes del enroscado con una lima fina antes de su instalación.



c.) Almacenamiento

Aplice una pequeña cantidad de aceite al producto antes de su almacenamiento y guardarlo en un lugar fresco y seco, para garantizar que no se produce condensación.

⚠ AVERTISSEMENT ⚠

Etudier, comprendre et suivre toutes les instructions fournies avec ce produit. Lire ces instructions attentivement avant d'installer, d'utiliser, d'entretenir et de réparer cet outil. Conserver ces instructions dans un endroit sécuritaire et accessible.

UTILISATION PRÉVUE DE L'OUTIL

This tap and die tool set is designed for cutting male and female threads of the thread pitches included in the kit using the drill bits provided in this set our other high quality appropriate size drill bits. This set is only suitable for experienced technicians. Tap only appropriately sized holes (see page 2); undersized holes will cause damage to the tool or work piece. Do not use this tool outside of the designed intent. Never modify the tool for any other purpose or use.



Fabriqué à Taïwan
les spécifications de Matco
PAT. No. US8616095 B2

(M) MIXED WARRANTY (Lifetime and Consumable)

The manufacturer warrants this product to the original user against defective material or workmanship for either a period of lifetime, or consumable (drill bits 1/4" and below only). Ask your distributor for more details.

Le fabricant se réserve le droit de déterminer si la pièce ou les pièces ont échoué en raison d'un défaut de matériau, de fabrication ou d'autres causes. Les défauts causés par un accident, une altération ou un mauvais usage ne sont pas couverts par cette garantie.

Les remplacements sous garantie comportent également une garantie à vie. Les droits sous cette garantie sont limités à l'utilisateur original et ne peuvent être transférés aux propriétaires suivants.

La garantie remplace toutes les autres garanties, explicites ou implicites, y compris les garanties de qualité marchande et d'adéquation à un usage particulier.

Certains états ne permettent pas l'exclusion ou les limitations des dommages accessoires ou consécutifs, de sorte que les limitations ci-dessus peuvent ne pas s'appliquer à vous.

INFORMATIONS PRODUIT:

- Includes extractors and drill bits in the following sizes: Extractor #1, #2, #3, #4, #5. Drill bit No. 3, 7, 9, 16, 19, 20, 21, 25, 29, 30, 36, 39, 43, Letter B, F, H, I, J, Q, O, R, S, T, U, Z and Fractional sizes 5/64", 7/64", 5/32", 1/4", 19/64", 5/16", 21/64", 3/8", 25/64", 13/32", 27/64", 7/16", and 29/64".
- Includes taps and dies in the following sizes: M3x0.5, M3x0.6, M4x0.7, M4x0.75, M5x0.8, M5x0.9, M6x1.0, M7x1.0, M8x1.0, M8x1.25, M9x1.0, M9x1.25, M10x1.0, M10x1.25, M10x1.5, M11x1.5, M12x1.25, M12x1.5, M12x1.75, 1/8BSP, 4-40, 6-32, 8-32, 10-24, 10-32, 12-24, 1/4-20, 1/4-28, 5/16-18, 5/16-24, 3/8-16, 3/8-24, 7/16-14, 7/16-20, 1/2-13, 1/2-20, 1/8NPT

⚠ AVERTISSEMENT ⚠

Mise en garde: Pour aider à prévenir les blessures

- L'utilisation de ce produit peut vous exposer à des produits chimiques, notamment l'éthylène glycol, les vapeurs d'essence et les gaz d'échappement des moteurs, qui sont reconnus par l'État de Californie pour causer le cancer, des anomalies congénitales ou des problèmes de reproduction. Pour plus d'informations, visitez www.P65Warnings.ca.gov. Toujours porter un équipement de sécurité, des lunettes de sécurité et des vêtements homologués ANSI lors de l'utilisation de ce produit. Étudier, comprendre et suivre toutes les instructions fournies avec ce produit. Ne pas lire et suivre tous les avertissements et instructions d'utilisation peut entraîner des dommages et des blessures graves ou la mort.
- Toujours porter des lunettes à coques approuvées par l'ANSI lorsque vous utilisez ce produit. (Utilisateurs et Spectateurs).
- Ne jamais utiliser cet outil pour aucune application qui n'est pas conçue.
- Seulement utiliser les accessoires conçus pour cet outil.
- Ne jamais modifier cet outil.
- Le fonctionnement et/ou l'entretien incorrect de cet outil, la modification de cet outil, ou l'utilisation de cet outil avec les accessoires non conçus pour lui devrait causer des blessures graves ou la mort.
- Toujours utiliser les accessoires adéquats pour le travail que vous effectuez.
- Toujours travailler dans un environnement propre, sécuritaire, bien éclairé, organisé et suffisamment équipé.
- Ne pas commencer les réparations sans assurance que le véhicule est en position de sécurité, et ne se déplace pas lors de la réparation.

DÉBALLAGE

Lors du déballage, vérifier que les pièces contenues dans le schéma et la liste des numéros de pièces de la page 16-17 sont toutes incluses. Si une pièce est manquante ou abîmée, veuillez appeler immédiatement votre distributeur.

NE PAS JETER-DONNER À L'UTILISATEUR

DRILL GUIDE

Below you will find the included tap and extractor sizes as well as the drill bits that pair with them. Select the thread pitch you intend to tap, then match it with the drill bit size listed below. In rare cases if your material is exceptionally thin or thick, you may need to step up (thick) or down (thin) in drill size within the pouch provided, however the below drill bit pairings work with the majority of applications. The chart below also includes part numbers for each piece found in this kit.

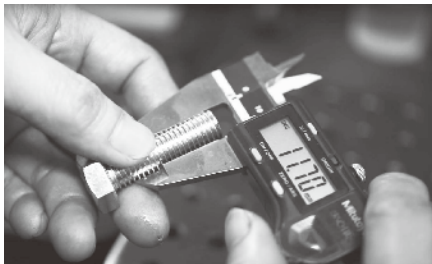
	Thread Size	Tap Part #	Die Part #	Drill Bit Size	Drill Bit Part #
Machine Screw	4-40 NC	MT440T	MT440D	No. 43	43A
	6-32 NC	MT632T	MT632D	No. 36	36A
	8-32 NC	MT832T	MT832D	No.29	29A
	10-24 NC	MT1024T	MT1024D	No. 25	25A
	10-32 NC	MT1032T	MT1032D	No. 21	21A
	12-24 NC	MT1224T	MT1224D	No. 16	16A
Fractional	1/4"-20 NC	MT1420T	MT1420D	No. 7	7A
	1/4"-28 NF	MT1428T	MT1428D	No. 3	3A
	5/16"-18 NC	MT51618T	MT51618D	Letter F	HDF
	5/16"-24 NF	MT51624T	MT51624D	Letter I	HDI
	3/8"-16 NC	MT3816T	MT3816D	5/16"	HD20A
	3/8"-24 NF	MT3824T	MT3824D	Letter Q	HDQ
	7/16"-14 NC	MT71614T	MT71614D	Letter U	HDU
	7/16"-20 NF	MT71620T	MT71620D	25/64"	HD2538A
	1/2"-13 NC	MT1213T	MT1213D	27/64"	HD2738A
	1/2"-20 NF	MT1220T	MT1220D	29/64"	HD2938A
Metric	M3x0.6	MT306T	MT306D	No. 39	39A
	M3x0.5	MT305T	MT305D	No. 39	39A
	M4x0.75	MT4075T	MT4075D	No. 30	30A
	M4x0.7	MT407T	MT407D	No. 30	30A
	M5x0.9	MT509T	MT509D	No. 20	20A
	M5x0.8	MT508T	MT508D	No. 19	19A
	M6x1.0	MT610T	MT610D	No. 9	9A
	M7x1.0	MT710T	MT710D	Letter B	HDB
	M8x1.25	MT8125T	MT8125D	Letter J	HDJ
	M8x1.0	MT810T	MT810D	Letter H	HDH
	M9x1.25	MT9125T	MT9125D	5/16"	HD20A
	M9x1.0	MT910T	MT910D	Letter O	HDO
	M10x1.5	MT1015T	MT1015D	Letter R	HDR
	M10x1.25	MT10125T	MT10125D	Letter S	HDSA
	M10x1.0	MT1010T	MT1010D	Letter T	HDT
	M11x1.5	MT1115T	MT1115D	3/8"	HD24A
	M12x1.75	MT12175T	MT12175D	13/32"	HD2638A
	M12x1.5	MT1215T	MT1215D	Letter Z	HDZRS
	M12x1.25	MT12125T	MT12125D	7/16" *	HD2838A
Pipe	1/8"-27 NPT	MT1827T	MT1827D	Letter Q	HDQ
	1/8"-28 BSP	MT1828T	MTBSP28	21/64"	HD21A
Extractor	Extractor Size		Extractor part #	Drill Bit Size	Drill Bit Part #
	Extractor #1		EO1A	5/64"	HD510A
	Extractor #2		EO2A	7/64"	HD710A
	Extractor #3		EO3A	5/32"	HD1010A
	Extractor #4		EO4A	1/4"	HD1610A
	Extractor #5		EO5A	19/64"	HD19A

* F/ material < 1/2" use 27/64"

INFORMATION UTILISATION

a.) Couper les filets femelles (Robinets)

- (1) Mesurer le diamètre extérieur du boulon que vous souhaitez utiliser.



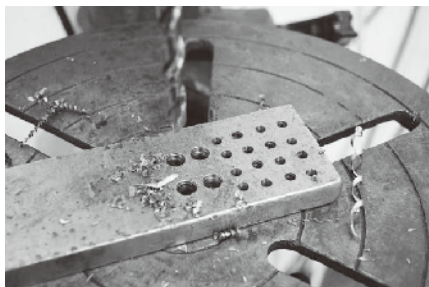
- (2) Déterminer le pas de filetage en utilisant la jauge de fil fourni avec le produit. Les dents sur le pas de filetage doit correspondre exactement dans le filetage.



- (3) Choisissez la bonne prise. Les informations de taille correspondante peut être trouvée sur la jauge de fil et le robinet. Insérer le robinet dans l'une des deux porte-tarands. Fixer le robinet en place afin qu'il ne puisse pas tomber hors du support. S'il vous plaît noter que un support du robinet est conçu pour les petits robinets et l'autre titulaire du robinet est conçu pour les grands robinets. Insérez le support du robinet dans le robinet clé (clicquet).



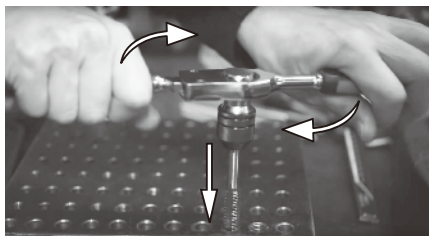
- (4) Locate or drill your own appropriately sized hole for the tap being used with the drill bits provided in the drill pouch in this kit (see page 2).



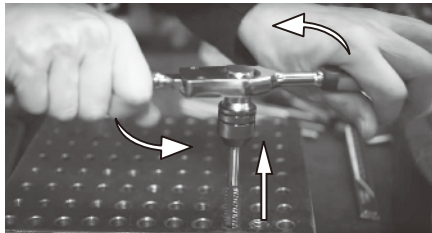
- (5) Appliquez une petite quantité de l'huile de coupe à l'eau du robinet.



- (6) Commencer à couper le fil. Les 4 premières arêtes de coupe du robinet sont chanfreinées pour permettre un alignement avec le trou. Tournez la poignée dans le sens horaire le maintien d'une relation perpendiculaire de 90 degrés avec le trou.



- (7) En fonction de la dureté du matériau taraudé, vous pourrez renvoyer le robinet hors du trou 1/4 - 1/2 tours toutes les 2-3 tours pleines, afin de briser les copeaux et pour une coupe sûre et constante. Le Rapide Select rochet vous permet de basculer entre la marche avant et marche arrière rapidement afin d'effectuer cette procédure aussi facilement que possible.
- (8) La coupe des filets des vis dans les trous est terminée, utilisez de l'air pour souffler des puces métalliques avant de retirer l'outil. Déplacez le bras sur le cliquet pour sélectionner inverse et revenir lentement le robinet du trou en faisant attention sur les quelques derniers tours ne pas attraper et endommager les fils en enlevant le robinet.

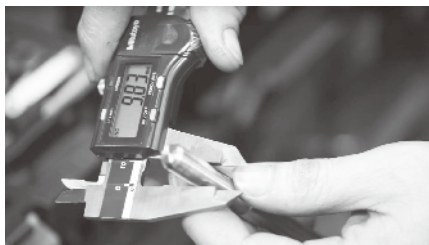


- (9) Souffler tous les jetsons restants de la zone de travail et installer attache.



b.) Couper les filets mâles (Dies)

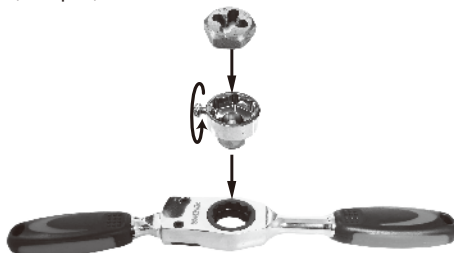
- (1) Mesurer le diamètre extérieur du boulon vierge ou fileté. Si le traçage les discussions sur un boulon, mesurent également le pas de vis avec la jauge de fil.



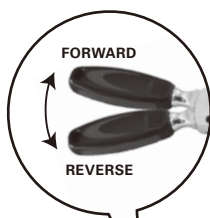
- (2) Choisissez la matrice de boulon correct. Insérez la matrice de boulon dans le support de la filière. Garantir le boulon meurent en utilisant la vis sur le support de matrice.



- (3) Insérez le support de filière dans la clé du robinet (à cliquet).

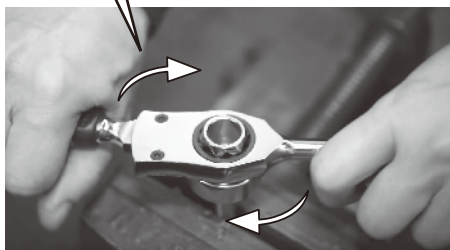


- (4) Régler le sens de rotation de la poignée à la position avancée.

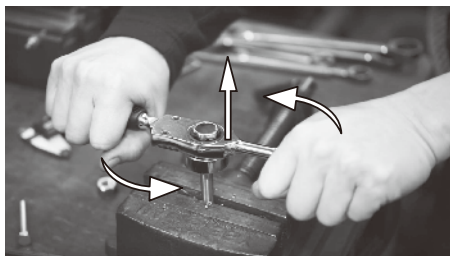


- (5) Appliquez une petite quantité de l'huile de coupe à la pièce de travail. Cliquez l'outil dans un le sens horaire. Assurez-vous que le cliquet est de 90 degrés perpendiculaires la pièce de travail.

- (6) Tout au long de la coupe, utilisez le Select Rapide Rochet pour changer rapidement et vient entre avant et arrière pour briser les copeaux et faire un coupe plus nette.



- (7) Réglez la poignée à la position inverse. Utilisez de l'air sous pression pour souffler la copeaux de la pièce de travail. Cliquez le boulon dié le sens antihoraire pour retirer la matrice de la pièce.



- (8) Nettoyer le reste des puces à partir des fils et vérifier votre travail avec un écrou fileté avant d'installer le boulon. Il peut être nécessaire d'appliquer une petite quantité d'huile ou pour faciliter les bords des filets avec une lime fine avant installation.

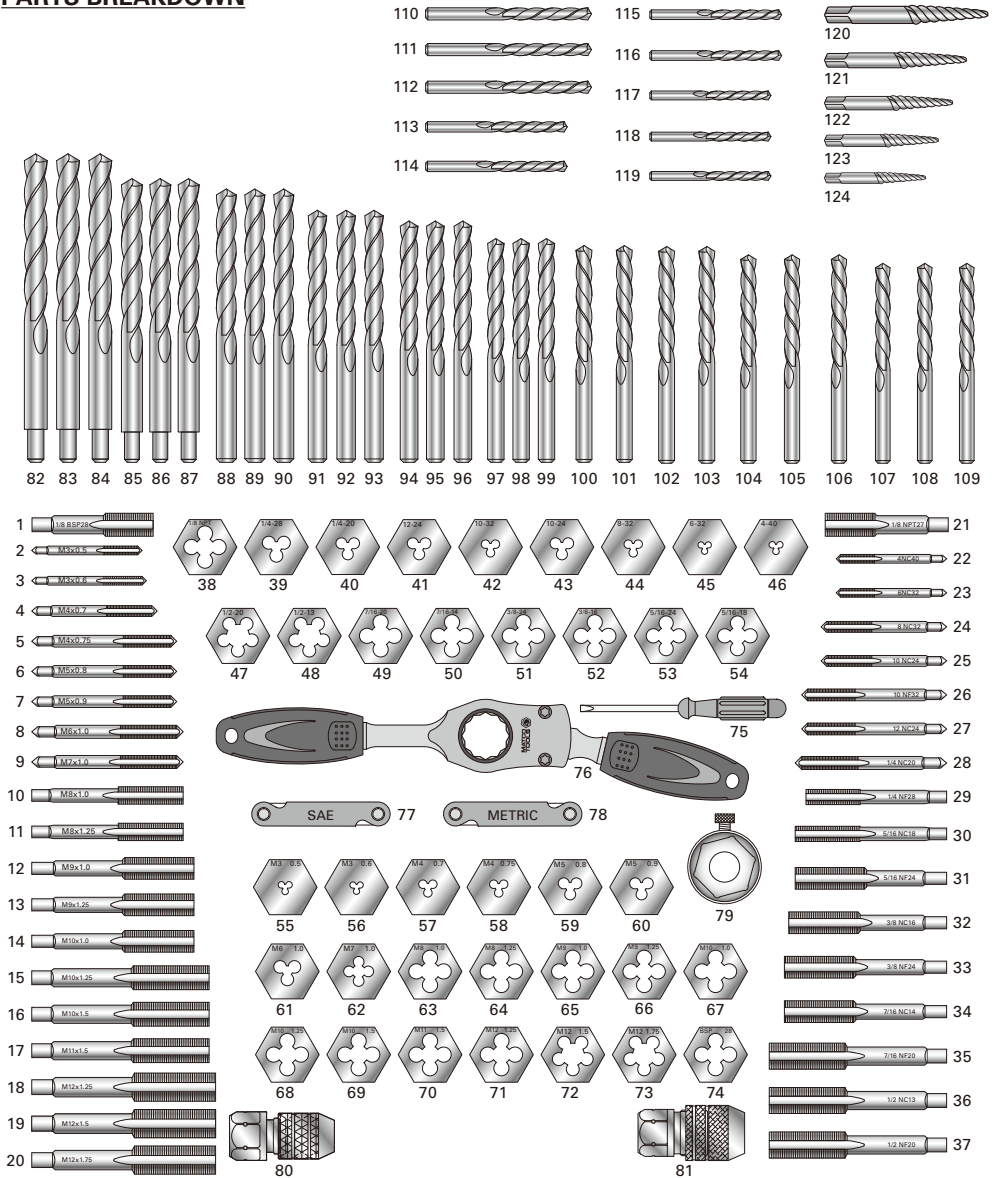


c.) Stockage

Appliquez une petite quantité d'huile à la matrice et appuyez sur pour le stockage. Conserver le produit dans un endroit frais et sec. Veiller à ce que ne se forme pas de condensation.



PARTS BREAKDOWN



PARTS BREAKDOWN

Index	Part No.	Description
1	MT1828T	1/8BSP28 Tap
2	MT305T	M3x0.5 Tap
3	MT306T	M3x0.6 Tap
4	MT407T	M4x0.7 Tap
5	MT4075T	M4x0.75 Tap
6	MT508T	M5x0.8 Tap
7	MT509T	M5x0.9 Tap
8	MT610T	M6x1.0 Tap
9	MT710T	M7x1.0 Tap
10	MT810T	M8x1.0 Tap
11	MT8125T	M8x1.25 Tap
12	MT910T	M9x1.0 Tap
13	MT9125T	M9x1.25 Tap
14	MT1010T	M10x1.0 Tap
15	MT10125T	M10x1.25 Tap
16	MT1015T	M10x1.5 Tap
17	MT1115T	M11x1.5 Tap
18	MT12125T	M12x1.25 Tap
19	MT1215T	M12x1.5 Tap
20	MT12175T	M12x1.75 Tap
21	MT1827T	1/8" NPT27 Tap
22	MT440T	4 NC40 Tap
23	MT632T	6 NC32 Tap
24	MT832T	8 NC32 Tap
25	MT1024T	10 NC24 Tap
26	MT1032T	10 NF32 Tap
27	MT1224T	12 NC24 Tap
28	MT1420T	1/4" NC20 Tap
29	MT1428T	1/4" NF28 Tap
30	MT51618T	5/16" NC18 Tap
31	MT51624T	5/16" NF24 Tap
32	MT3816T	3/8" NC16 Tap
33	MT3824T	3/8" NF24 Tap
34	MT71614T	7/16" NC14 Tap
35	MT71620T	7/16" NF20 Tap
36	MT1213T	1/2" NC13 Tap
37	MT1220T	1/2" NF20 Tap
38	MT1827D	1/8" NPT27 Die
39	MT1428D	1/4-28" Die
40	MT1420D	1/4-20" Die
41	MT1224D	1/2-24" Die
42	MT1032D	10-32 Die

Index	Part No.	Description
43	MT1024D	10-24 Die
44	MT832D	8-32 Die
45	MT632D	6-32 Die
46	MT440D	4-40 Die
47	MT1220D	1/2-20" Die
48	MT1213D	1/2-13" Die
49	MT71620D	7/16-20" Die
50	MT71614D	7/16-14" Die
51	MT3824D	3/8-24" Die
52	MT3816D	3/8-16" Die
53	MT51624D	5/16-24" Die
54	MT51618D	5/16-18" Die
55	MT305D	M3x0.5 Die
56	MT306D	M3x0.6 Die
57	MT407D	M4x0.7 Die
58	MT4075D	M4x0.75 Die
59	MT508D	M5x0.8 Die
60	MT509D	M5x0.9 Die
61	MT610D	M6x1.0 Die
62	MT710D	M7x1.0 Die
63	MT810D	M8x1.0 Die
64	MT8125D	M8x1.25 Die
65	MT910D	M9x1.0 Die
66	MT9125D	M9x1.25 Die
67	MT1010D	M10x1.0 Die
68	MT10125D	M10x1.25 Die
69	MT1015D	M10x1.5 Die
70	MT1115D	M11x1.5 Die
71	MT12125D	M12x1.25 Die
72	MT1215D	M12x1.5 Die
73	MT12175D	M12x1.75 Die
74	MTBSP28	1/8BSP28 Die
75	MT35SD	Screw Driver
76	MT40R	Rapid Select Ratchet
77	MT36STG	SAE Pitch Gauge
78	MT36MTG	Metric Pitch Gauge
79	MT37DH	Die Holder
80	MT38TH	M3-M6 Tap Holder
81	MT39TH	M6-M12 Tap Holder
82	HD2938A	29/64" Drill Bit
83	HD2838A	7/16" Drill Bit
84	HD2738A	27/64" Drill Bit

Index	Part No.	Description
85	HDZRS	LTR Z
86	HD2638A	13/32" Drill Bit
87	HD2538A	25/64" Drill Bit
88	HD24A	3/8" Drill Bit
89	H DU	LTR U
90	HDT	LTR T
91	HDSA	LTR S
92	HDR	LTR R
93	HDQ	LTR Q
94	HD21A	21/64" Drill Bit
95	HDO	LTR O
96	HD20A	5/16" Drill Bit
97	HD19A	19/64" Drill Bit
98	HDJ	LTR J
99	HDI	LTR I
100	HDH	LTR H
101	HDF	LTR F
102	HD1610A	1/4" Drill Bit
103	HDB	LTR B
104	3A	#3
105	7A	#7
106	9A	#9
107	16A	#16
108	19A	#19
109	20A	#20
110	21A	#21
111	HD1010A	5/32" Drill Bit
112	25A	#25
113	29A	#29
114	30A	#30
115	HD710A	7/64" Drill Bit
116	36A	#36
117	39A	#39
118	43A	#43
119	HD510A	5/64" Drill Bit
120	EO5A	Extractor #5
121	EO4A	Extractor #4
122	EO3A	Extractor #3
123	EO2A	Extractor #2
124	EO1A	Extractor #1