

QWIKLINE™ THREAD CHASER - (Instructions for repairing Left-Hand Threads)

The following instructions are provided to ensure the proper use of the **QwikLine™ Thread Chaser (QTC)**. This Product is to be used only as a thread repair tool! Please review both the 'Warning' and 'Instructions for Use' sections carefully before using QTC. ([Video Instructions available at www.qwikline.com/product-instructions-for-use](http://www.qwikline.com/product-instructions-for-use))

WARNING!!

- 1) **Never use oil** with the QTC! It will cause the QTC to become ineffective and/or inoperable.
- 2) **Safety glasses should be worn at all times** while using the QTC.
- 3) **Each QTC is size-specific and can only be used to repair a single size bolt/threaded rod!** Using the QTC on the wrong size bolt or thread pitch will result in damage to the QTC and threaded surface and likely cause the QTC to get stuck on the bolt or rod.
- 4) The QTC should not be used to repair extremely damaged threads.
- 5) **Always use gloves** when using or cleaning the QTC. Use extreme caution when handling the cutting mechanism during cleaning as the teeth are very sharp!
- 6) The **QTC should never be used as a fastening device!**

Instructions for Use: The following instructions refer to the use of a QwikLine™ Thread Chaser designed to repair left-hand threads. If you are repairing conventional right-hand threads, please refer to the instructions for right-hand threads.

- 1) Start by verifying that the thread specification of the QTC and damaged bolt/rod are identical so that no damage occurs to the QTC or bolt/rod.
- 2) Prepare the QTC for use by inserting the key into the top of the QTC and rotating clockwise approximately 1/4 turn to move the QTC from the "closed" position into the "open/ready" position (see Figure 1). If unsure whether the QTC is in the open or closed position, rotate key back and forth 1/4 turn until QTC rests in the right-most position, which is the open position.
- 3) With QTC in open position, manually install by rotating QTC slightly counterclockwise while simultaneously sliding the QTC over and past the damaged threads (see Figure 2). Rotating the QTC counterclockwise makes installation easier and ensures that the QTC becomes aligned (ie, parallel) with the bolt/rod before beginning Step 4.
- 4) Once the QTC is past the damaged threads and aligned/parallel with the bolt/rod, manually rotate the QTC clockwise until the point at which firm resistance is met when the QTC engages with the damaged threads. In order to ensure proper engagement with minimally damaged threads, while rotating QTC clockwise simultaneously pull the QTC in the direction the QTC is rotating off the bolt/rod to ensure complete engagement with damaged thread area.
- 5) Install proper size socket or wrench to hex portion of the QTC.
- 6) Using a hand-operated or impact wrench, rotate QTC clockwise until removed from the damaged bolt/rod (see Figure 3). When rotating QTC off bolt/rod, **DO NOT** apply forward pressure (pressure in opposite direction to direction QTC is rotating off) to QTC as it may cause the QTC to remain in the "open" position and not properly repair the damaged threads.
- 7) Immediately after use of the QTC, it is advisable to tap the QTC 1-2 times on a hard surface to allow residual metal particles from repaired threads to be removed from QTC. This helps minimize the frequency in which the QTC must be cleaned (see Maintenance section for instructions on how to clean QTC). Leave QTC in "closed" position until next use.

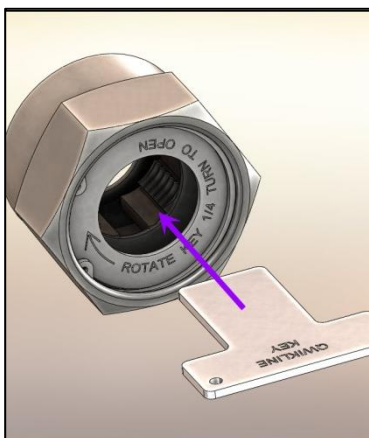


Figure 1 – Insert QwikLine™ Key and turn the key clockwise to rotate the QTC to the open/ ready position

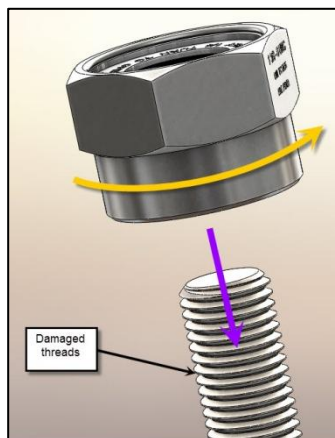


Figure 2 – Proper orientation of the QTC on damaged threads

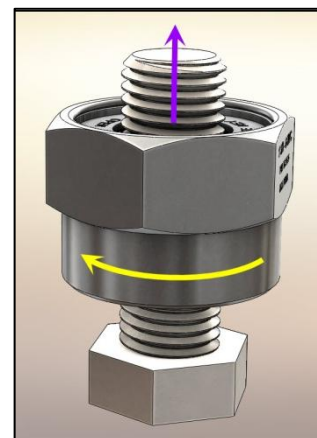


Figure 3 – Rotate QTC in direction shown to repair damaged threads



QWIKLINE™ THREAD CHASER - (Maintenance and Troubleshooting Tips)

Maintenance:

Following are some important tips to keep your QwikLine™ Thread Chaser (QTC) operating effectively:

- 1) After each use of the QTC, tap the bottom of the QTC 1-2 times on a hard surface to enable metal particles from repaired threads to be removed from the QTC. Alternatively, pressurized air may be blown into the bottom of the QTC to remove metal particles. This process is important to allow for continued smooth operation of the QTC while reducing cleaning cycles.
- 2) The QTC should generally be cleaned every 25-50 uses, depending on the severity of the damaged threads being repaired. Customer may return the QTC to QwikLine Industrial Products for a complimentary factory cleaning (shipping costs to/from factory are responsibility of customer), or perform the following steps to clean the QTC:
 - Step 1: Using Snap Ring Pliers, remove snap ring on top of QTC.
 - Step 2: Remove top washer, spring, bottom washer, and both halves of cutting mechanism. **NOTE: Requires protective gloves. Teeth on thread cutting mechanism are very sharp! Use extreme caution!**
 - Step 3: With all parts removed from QTC, wipe interior of QTC with a clean, soft cloth until no metal particles remain.
 - Step 4: Prior to reassembly, spray a light coat of dry graphite lubricant onto the bottom and tapered portions of the cutting mechanism. NEVER use oil lubricants or silicone spray as these products will cause metal shavings resulting from the thread repair process to adhere to the QTC, which impairs the performance of the QTC.
 - Step 5: Reassemble QTC by assembling in the opposite order of disassembly. First, place both halves of cutting mechanism into bottom of QTC. Ensure tapered bottom of thread cutting halves rest on interior bottom of QTC. Next, place bottom washer on top of cutting mechanism, which is then followed by spring, top washer, and lastly, the snap ring. When placing snap ring in QTC, it is important to press down slightly on spring to enable the snap ring to seat in the snap ring groove to ensure proper operation of QTC after cleaning.
- 3) Leave the QTC in the “closed” position after each use. Keeping the QTC in the closed position after use keeps debris out of the QTC. The QTC should only be moved to the open/ready position immediately prior to use (see Figure 1 in Instructions for Use).

Troubleshooting Tips:

- **If QTC is difficult or impossible to slide onto bolt or rod**
 - Verify that QTC is identical size to bolt/rod being repaired. Damage to QTC or bolt/rod, or both, may result if QTC is inserted onto mismatched size bolt/rod.
 - Make sure to rotate QTC slightly clockwise while sliding QTC down bolt/rod.
 - Ensure QTC is in open/ready position (see Figure 1 in Instructions for Use).
- **If QTC is not repairing threads**
 - QTC may be misaligned with bolt/rod. While installing QTC onto bolt/rod, continue to rotate clockwise until QTC is both beyond the area of damaged threads and the QTC is parallel to the bolt/rod. If QTC is not aligned (ie, is crooked) with bolt/rod prior to rotating QTC counter-clockwise off bolt/rod, QTC will not engage with damaged threads.
 - Visually inspect “teeth” on thread cutting mechanism for wear. After many uses, internal parts of QTC will wear to a point at which the QTC will no longer function properly and must be discarded.
 - Ensure that when rotating QTC counterclockwise off bolt/rod there is no “forward” pressure being applied to QTC (ie, pressure in the opposite direction the QTC is being rotated off). Forward pressure will result in the QTC not properly engaging with the damaged threads.
- **If QTC is difficult or impossible to get into the “open/ready” position when using QwikLine Key**
 - Metal particles may have accumulated inside the QTC. Clean QTC per Maintenance Item 2 above.
 - QTC may already be in open position. Check by turning key back and forth 1/4 turn until key stops in right-most position.