



## Threading Kit Rental

(updated 07-05-08)

### Contents (make sure I get them back)

Die Holder with 3 screws  
Thread Alignment Tool (**TAT**)  
Threading Die  
Bottle Cutting Fluid (with red cap)

I've revamped the threading kit rental process which should be better for all parties. Too many abuses and damaged/lost equipment. A deposit is now required, as is sending the equipment directly back to me. Your deposit will be refunded pending the timely return of the undamaged threading kit. Please replace the cap and double bag the cutting fluid to prevent leakage and return in the original box.

Please complete your threading **within one week** from receiving it so the next person in line can get their turn. Inside of one week should be more than sufficient. The quicker I get it back, the quicker you get your deposit back. Threading should take no longer than 30-60 minutes.

When finished, clean the tools from chips and excess oil. Air compressor works great.

### Threading Prep

I will ship the threading kit with the Thread Alignment Tool and Die already installed in the die holder. You are ready to rock out of the box.

For reference, this is how I do it:

- #1 - Insert die in die holder, lettered (front) side up. Sometimes you need the die upside down due to the location of the external die divots.
- #2 - Align the pointed "**spreader**" screw with the die split.
- #3 - Align the other 2 "**tightening**" screws with the divots in the o.d. of the die. They will either be 90 degrees apart if 180 degrees apart.
- #4 - Screw in the TAT about 4-5 threads from the back side of the die with the pilot going the rest of the way through the die.
- #5 - Loosen the **spreader** screw and tighten the **tightening** screws. The **TAT** should now be tight.
- #6 - If you have a flash hider or brake, it is a good idea to screw it on the back of the TAT to help lock it in the die.

## Threading - starting

Hold the barrel firmly for threading. A vise with padded jaws works best.

Apply a good cutting fluid/oil to the die teeth and pilot and start cutting. It will take a little bit to get it started. Apply even pressure towards the receiver and take your time. Threading goes much smoother with a little linear force.

I recommend advancing the die 1/5<sup>th</sup> to 1/6<sup>th</sup> of a turn, then back it off until you hear a "click" to break the chips. You want to keep it from loading up and chipping the teeth.

After you have 4-6 threads cut, **Remove the TAT**. Loosen the 2 tightening screws on the die holder. Tighten the pointed spreader screw. Unscrew the TAT. Hand tighten the 2 tightening screws. Do not allow the TAT to bottom out on the barrel face and rip the teeth out, ruining TAT and possibly the threads on the barrel. It's been happening a lot.

## Threading - first pass

Resume threading as above, breaking the chips very frequently. Remember to apply cutting fluid to the die and pilot. Thread to the desired depth, wipe off threads and check tightness of fit with whatever brake/hider you plan on using. You want the threads firm and not too loose.

## Threading - final pass

If the threads are too tight, loosen the "spreader" screw in the die holder and tighten the "tightening" screws. Then hand tighten the "spreader screw. Apply more cutting fluid and run over the threads again. Wipe off threads and check fitment again. You should be finished. Clean the die, holder & TAT.

## Saiga x39 or .223

You will need to remove the shroud and thread the barrel. A dremel cutting disc works best for this, just be careful to not cut too deep into the barrel.

## Indexing Muzzle Devices

If you need to index a certain type brake or hider, like a '74 brake or hider, you can index with teflon tape or I can supply a crush washer or muzzle nut.

## Rental Fees

Fees are based on **one firearm** for **one week maximum**. If you need to do more than one barrel of the same caliber, Cost is \$10 for each additional.

From when I send it out it needs to be back within 2 weeks+/- or I will start docking \$10 a week from your deposit. Basically when you get it, use it and return it within one week.

## Deposits

I regret having to do this, but as an alternative to scrapping the entire operation, I now must charge a deposit for the rentals. As of late there has been a rash of stolen equipment, shredded dies, stripped TATs and keeping the equipment for extended times. Chasing down the offenders has been a pain.

I am also no longer having users pass the kits on to the next renter. They will be shipped directly to you and you will ship it directly back to me **within** the allotted time. Upon timely return of the **clean and undamaged** equipment, I will inspect and refund your deposit.

If you read the instructions, you should have no trouble. I've been getting broken dies back that weren't installed in the die holder properly. Follow the instructions! I send them ready to rock out of the box, so setup shouldn't be an issue. Please know that I try not to rule this with an iron fist and am a reasonable guy. But I am also trying to run a business. I can't be replacing dies after a single use. I keep strict track of the dies mileage and retire them to the shop to ensure everyone has sharp equipment.

## Damaged / Missing Equipment

Users are responsible for any and all damage and missing parts by paying **full** replacement costs. This means any chips or damage whatsoever. I have seen it all. Whoever let their dog crew up the cutting fluid bottle, I hope he is O.K..

Costs are as follows: **\$25 for the rifle TAT's; \$30 for the shotgun TAT's; \$25 for the rifle dies; \$125 for the shotgun dies; \$10 for the die holder; \$5 for the die holder screws** and **\$5 for the cutting fluid bottle**. (please send back with cap on, double bagged)

## Returning the Kit

Return as soon as possible to:

Brian Smithwick  
4098 E. Farrand Rd.  
Clio, MI 48420  
[dinzzag@yahoo.com](mailto:dinzzag@yahoo.com)

Please be sure to clean it up and package securely to avoid loss or damage in transit. Do not return ship in an envelope, it will rip open. Wrap the parts and place them in a box and remember to tape it closed.

It is also your responsibility to cover your butt when you send it back. Remember the USPS, FedEx and UPS all offer insurance. You are responsible for replacing the equipment until it is delivered and in my hands.

Thanks!  
Brian