



## **INSTRUCTIONS:**

KnechtionRepair tools are designed to chase damaged internal and external threads of compression type tube connections.

All applicable lock out and tag procedures must be in compliance. System isolation and safety is the responsibility of the **TECHNICIAN / USER!**

To repair a cross-threaded or damaged thread of a nut:

Clean tube and nut (internal and external) from foreign debris. Tube and ferrules must be in a serviceable condition. Install the tap into the holder - hex end of tap goes in first. Insert nut and tubing into the holder. If outside hex of nut is damaged and out of shape, it must be filed back to its original shape to fit into the holder. Once the nut and tube is inserted into the holder, install clip, this will hold the nut in the holder during the thread chasing process.

Move the tap into the nut. Turn the tap using the drive pin or applicable wrench to chase the internal threads. Complete the thread chasing. Reverse turn the tap completely out from nut and tubing.

Remove the clip, nut and tube from holder. Store the holder, tap, drive pin and clip in the original container.

**Note:** It is the responsibility of the user to determine the need for cutting fluids. Use appropriate thread tapping fluid for the type of alloy fitting and process as required. Fluid and chips must be cleaned from the nut and tubing.

To repair external threads of compression tube fittings:

Clean the fitting (internal and external) from foreign debris.

**Note:** If the fitting is so damaged and out shape that the die pilot will not insert into the fitting - the fitting is not repairable by using KnechtionRepair tools.

Insert the pilot into the fitting then install the piloted die over the pilot. Turn the die using applicable wrenches. Complete the thread chasing. Remove the die and pilot from the fitting.

**Note:** It is the responsibility of the user to determine the need for cutting fluids. Use appropriate thread tapping fluid for the type of alloy fitting and process as required. Fluid and chips must be cleaned from the fitting.

**\*\*\*PLEASE READ\*\*\***

**THE INTEGRITY OF THE FITTING FOR "RETURN TO SERVICE" IS THE RESPONSIBILITY OF THE USER!  
KNECHTIONREPAIR IS NOT RESPONSIBLE FOR REPAIRED OR DAMAGED FITTINGS.**

