

## CONDUIT DIE SET



- Stocks & Dies made from high quality steel for longer life
- A conduit die set is a tool used in electrical and construction work to thread or ream the ends of conduit pipes

**GARVIN**<sup>®</sup>  
T O O L S

Cat No.	Set Contents
GTS-4388	Round Die M20 & M25 + 2 Guides + 1 Die Handle
GTS-4388A	Round Dies M20, M25 & M32 + 3 Guides + 1 Die Handle

## How to Use

### Materials you'll need:

1. Conduit pipe
2. Conduit die set (including the appropriate die for your conduit)
3. Pipe cutter (if you need to cut the conduit to the desired length)
4. Luicant (conduit threading oil or wax)
5. A vise (optional, for securing the conduit during the threading process)

### Procedure:

#### 1. Prepare the Conduit:

- If your conduit pipe is not already cut to the desired length, use a pipe cutter to cut it to the appropriate size. Make sure the cut is straight.

#### 2. Secure the Conduit (Optional):

- If available, secure the conduit in a vise to keep it steady during the threading process. This is especially helpful for larger conduit pipes.

#### 3. Select the Right Die:

- Choose the die that matches the size of the conduit pipe and the type of threading you need (NPT threads are standard for electrical conduits).

#### 4. Apply Luicant:

- Apply a liberal amount of conduit threading oil or wax to the area of the conduit that will be threaded. This luication reduces friction and heat generated during the threading process and prolongs the life of the die.

#### 5. Position the Die:

- Place the selected die onto the end of the conduit pipe. The die should fit snugly but not be overly tight.

#### 6. Thread the Conduit:

- With the die in place, begin turning it clockwise (righty-tighty) while applying steady pressure. This action will cause the die to cut threads onto the conduit pipe. Make sure to keep the die perpendicular to the pipe to create even, straight threads.

#### 7. Maintain Luication:

- Periodically reapply luicant to the conduit and the die as needed to ensure smooth cutting and reduce friction.

#### 8. Inspect the Threads:

- Periodically stop to inspect the threads for quality. They should be clean, even, and well-defined. If you encounter any irregularities, you may need to adjust the die or the cutting process.

#### 9. Complete the Threading:

- Continue turning the die until you have threaded the desired length of the conduit. Typically, you'll thread the conduit to match the length of your conduit fittings and connectors.

#### 10. Remove the Die:

- Once you've achieved the desired threading, carefully remove the die from the conduit pipe. [www.garvintools.com](http://www.garvintools.com)

#### 11. Clean and Assemble:

- Remove any excess lubricant and debris from the threaded conduit. You can use a wire brush or a rag to clean the threads. After cleaning, you can assemble your conduit fittings, connectors, and wires as needed.

Remember that safety is crucial when working with conduit die sets. Use appropriate personal protective equipment (PPE) such as safety glasses or goggles to protect your eyes, and be cautious to avoid any sharp edges on the freshly threaded conduit. Properly threaded conduit ensures secure and reliable cable installations, making it an essential skill for electricians and construction professionals.

