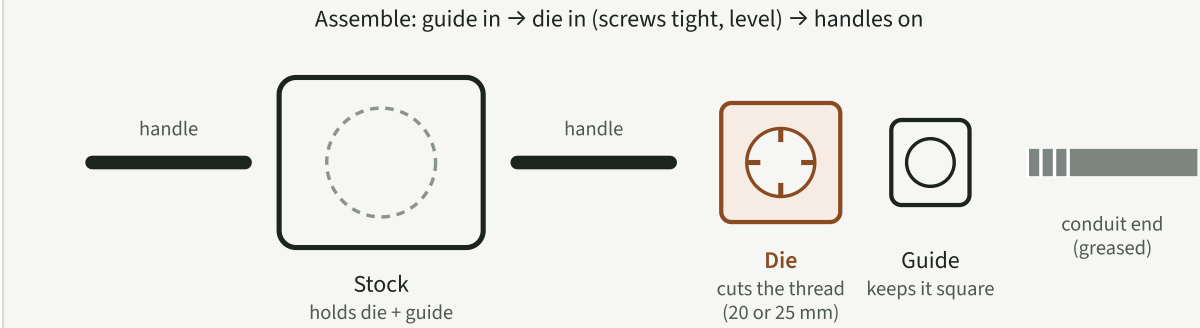
THREADING CONDUIT WITH STOCKS AND DIES

HOW DO YOU KNOW WHEN TO STOP THREADING?

The factory puts a thread on each end of a length. When you **cut** conduit you need to put your **own thread** on the cut end so it matches the factory thread and fits couplers and boxes. You use the bender's **vice** to hold it and a **stocks and dies** threading set.

The kit

- **Stock**: the main body that holds everything.
- **Guide**: fits in first and keeps the die square on the conduit. (It's easy to forget.)
- **Die**: the cutter with the threads in it. Each die suits one size. Our kit did **20 mm and 25 mm**. Grub screws hold it in tightly and level.
- **Handles**: screw into the stock and give you the grip and leverage.
- **Cutting grease** (from general wholesalers, bought by the tin, in black, green or yellowish colours) and a **brush** or anything you don't mind getting greasy. It's messy.



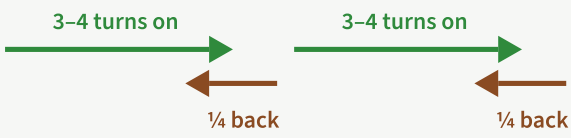
A stocks and dies set, pulled apart. Don't forget the **guide**. Without it the die won't start square.

Step by step

THREADING A CUT END (STEP BY STEP)

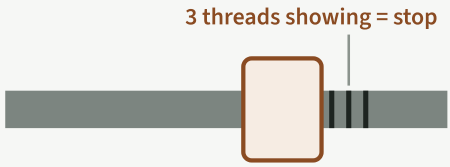
1. Clamp the conduit in the vice. Check the vice and bender are tight.
2. FILE the inside of the cut end to remove the burr.
3. Put a sheet of cardboard (or other floor protection) down.
   Greasy swarf drops on the floor, and a shifting bender
   can scratch a tiled floor.
4. Brush a small dab of cutting grease onto the end.
5. Slide the stocks and dies on. Push forward with EVEN
   pressure on both handles to start the thread.
   Keep your feet on the bender so it doesn't move.
6. Turn 3–4 turns forward, then ¼ turn BACK. Repeat.
   Backing off lets the cut metal fall out.
7. Stop when about 3 THREADS show past the die.
8. Remove the die, tap it off, wipe the grease away with
   tissue or a cloth.
9. Run the file through the end again for a smooth entry.

The rhythm



Backing off clears the swarf. Otherwise loose bits can embed in the thread you've already cut and spoil it.

When to stop



conduit held in the vice

Three or four turns forward, a quarter turn back. A handy gauge: once you can count **three individual threads** past the die, you've gone about the right distance.

> **Why file twice?**
> A cut or freshly threaded end can leave a sharp burr inside the conduit, and that can **damage the cable insulation** as you draw the cables in. File before threading, then again afterwards in case you damaged the end.

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