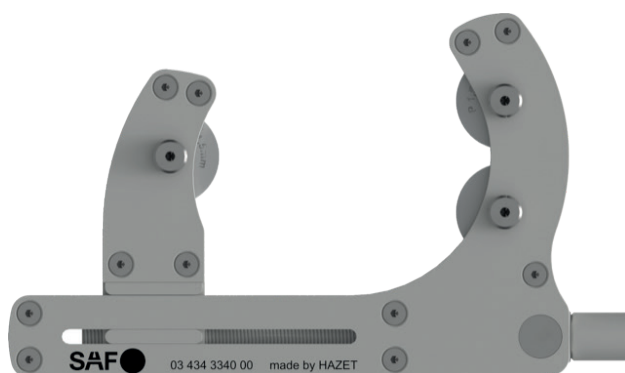
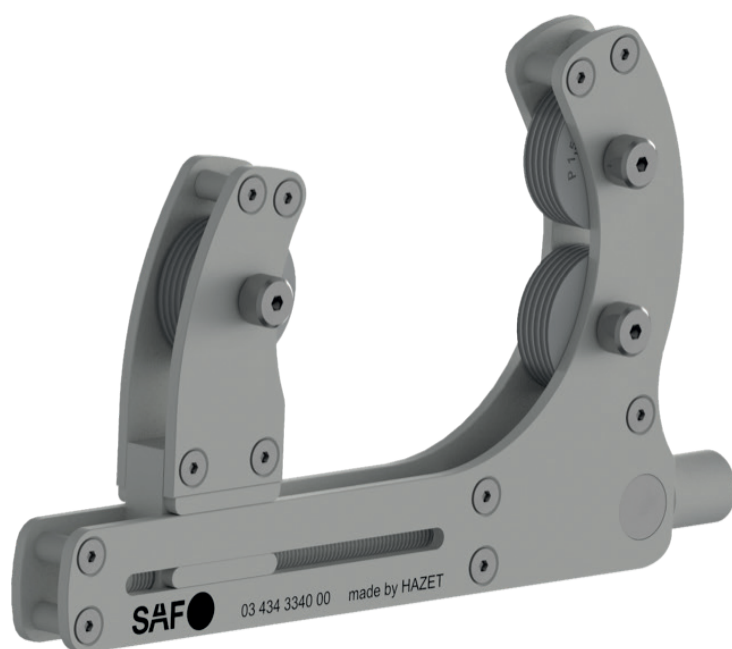




Scan Me

Operating manual

Thread rolling die





1. For your information

1.1 General information

- Please make sure that the users of this tool have carefully read and understood this operating manual before putting it into operation for the first time.
- This operating manual contains important instructions required for the smooth and safe operation of your HAZET / SAF-Holland Group thread rolling die.
- The proper use of the HAZET / SAF-Holland thread rolling die includes observing all safety instructions and information contained in this operating manual in full.
- Therefore, always keep this operating manual with your HAZET / SAF-Holland Group thread rolling die.
- This tool was developed for specific applications. HAZET would like to emphasize emphatically that this tool may not be modified and/or used in any manner that does not correspond to its intended purpose.
- HAZET does not assume any liability or provide warranty for injuries or damages caused as a result of improper and unauthorized use or violations of the safety regulations.
- In addition, all accident prevention regulations and general safety provisions must be observed for the device's range of application.

1.2 Explanation of symbols

CAUTION: Pay close attention to these symbols!



READ OPERATING MANUAL!

The operator is obliged to observe the contents of the operating manual and to train all users of your HAZET / SAF-Holland Group thread rolling die in accordance with said operating manual.



NOTE!

This symbol indicates advice that can make it easier to handle the device.



WARNING!

This symbol indicates important descriptions, dangerous conditions, safety hazards, and safety instructions.



CAUTION!

Failing to follow the notices indicated by this symbol can result in damages, malfunctions and/or the failure of the device.



SPECIALISTS!

This tool can cause serious damage and should therefore only be used by specialists.

2. For your safety



2.1 The operator's responsibility

- At the time of its development and production, the device was built according to the latest applicable safety standards and can be regarded as operationally reliable. However, the device can be dangerous if it is not used properly or for its intended purpose by professionally trained personnel. Therefore, each person tasked with working on or with the device must have read and understood the operating manual before starting to work.
- Always keep the operating manual in close proximity to the device.
- Modifications of any type as well as add-ons or alterations to the device are prohibited.
- All safety instructions, warnings and operating instructions on the device must always be kept in legible condition. Damaged signs or stickers must be replaced immediately.
- All specified settings or configurations must be observed without fail.
- This manual only provides instructions. Always make sure that you are in possession of the appropriate maintenance instructions from the vehicle manufacturer or a relevant manual containing accurate information in order to carry out the work properly.



2.2 Proper use

Operational safety can only be ensured if the device is used properly in accordance with the instructions in the operating manual. In addition to the instructions related to occupational safety contained in this operating manual, observing and complying with the general safety, accident protection, and environmental protection regulations for this area of application is required.

Tools must always be used and serviced in accordance with the local laws or federal regulations in the respective country.

- Only operate the device in technically sound and operationally reliable condition.
- Your HAZET / SAF-Holland Group thread rolling die is intended to repair and re-roll damaged threads
 \varnothing measuring 50-110 mm with a pitch of 1.5 mm (optional: pitch of 2 mm).
- Using the device for anything other than its intended purpose is prohibited and is considered improper use.
- Any claims filed against the manufacturer and/or its authorized representatives due to damages caused as a result of using the device incorrectly are excluded.
- The operator alone is liable for all damages caused as a result of improper use.



2.3 Dangers posed by the device

Before each use, make sure that your HAZET / SAF-Holland Group thread rolling die is fully functional. If this inspection reveals that the device is not fully functional or that it is damaged, you must not use your HAZET / SAF-Holland Group thread rolling die. If the HAZET / SAF-Holland Group thread rolling die is not fully functional and the device is used nevertheless, there is a danger of serious physical or health-related injuries and material damage.

- The device is considered fully functional if:
 - It runs smoothly
 - It is not damaged
- The individual parts must only be used in their intended arrangement.
- Safety goggles and close-fitting protective workwear must be worn when working with the HAZET / SAF-Holland Group thread rolling die.
- All maintenance or repair work must always be performed by specialized personnel. In order to ensure continued operational safety, only original spare parts may be used.
- For safety reasons, modifying your HAZET / SAF-Holland Group thread rolling die is strictly prohibited. By making modifications to your HAZET / SAF-Holland Group thread rolling die, you immediately forfeit any guarantee of liability.



Wear work gloves and safety goggles.

Tools with a pneumatic drive can whirl up chips, dust and other debris at a high speed, which can cause serious eye injuries. Compressed air is dangerous. The stream of air can damage sensitive body parts, such as the eyes, ears, etc. Objects and dust whirled up by the stream of air can cause injuries.



Wear hearing protection. Prolonged exposure to the noise produced by a pneumatic tool can lead to a permanent loss of hearing.



Wear a face mask or respirator. Some materials, such as adhesives and tar, contain chemicals whose vapors can cause serious damage when inhaled over an extended period of time.



Wear close-fitting protective workwear.

Tools with moving parts can get caught in hair, clothing, jewelry or other loose objects, which can in turn cause serious injuries. Never wear clothing that is too loose and/or clothing with straps and loops that can get caught in the moving tool parts. When working, take off all jewelry, watches, ID cards, bracelets, necklaces, etc. that could get caught on the tool. Never pick up tool components while they are moving. Long hair should be tied together or covered.

3. Application

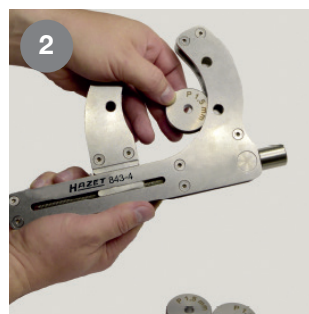
This manual only provides instructions. Always make sure that you are in possession of the appropriate maintenance instructions from the vehicle manufacturer or a relevant manual containing accurate information in order to carry out the work properly. The thread rollers and tools must not be tilted before or during operation in order to prevent the vehicle parts from being damaged.

Using the thread rolling die (Part no.: 03434334000):

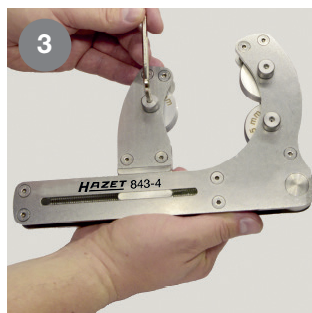
In order to ensure that the thread is re-rolled correctly, follow steps 1-7.



1 Check the damaged thread using the boundary sample (Chapter 2. Boundary sample, Page 4).



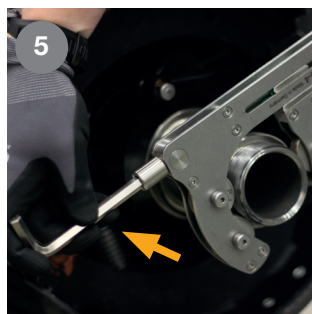
2 If necessary, insert the appropriate rollers into the thread rolling die.
CAUTION:
Pay attention to right-hand and left-hand threads!



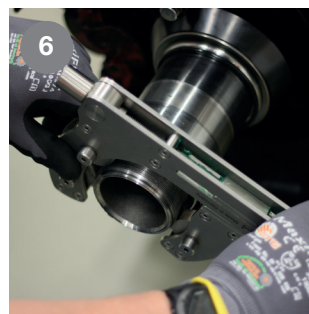
3 Fasten the rollers onto the thread rolling device.



4 Wipe any dust or residue off of the damaged thread and moisten it with a suitable cleaner.



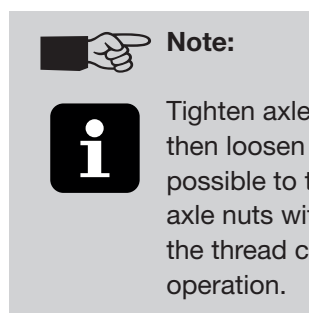
5 Place the thread rolling die on top of the thread being repaired and tighten it using the clamp screw. The rollers have to fit correctly into the still intact thread flanks!



6 Using rotating movements, roll the damaged thread over the entire thread area in several passes. Note: Re-tighten the clamp screw if necessary!



7 Check whether the axle nut can be screwed onto the thread by hand. It may be necessary to repeat the re-rolling process.

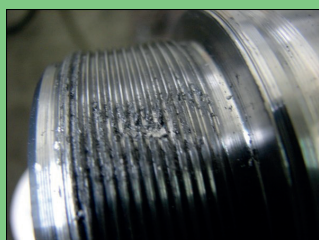


Note:

i Tighten axle nuts to 900 Nm and then loosen them again. If it is possible to tighten and loosen the axle nuts without any problems, the thread can be put back into operation.

4. Boundary sample:

In order to ensure that the thread is re-rolled correctly, observe the following figures and compare them with the present damage profile.



Damage profiles that can be repaired using the thread rolling die



Damage profiles that CANNOT be repaired using the thread rolling die

[illegible]



Contact information

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