

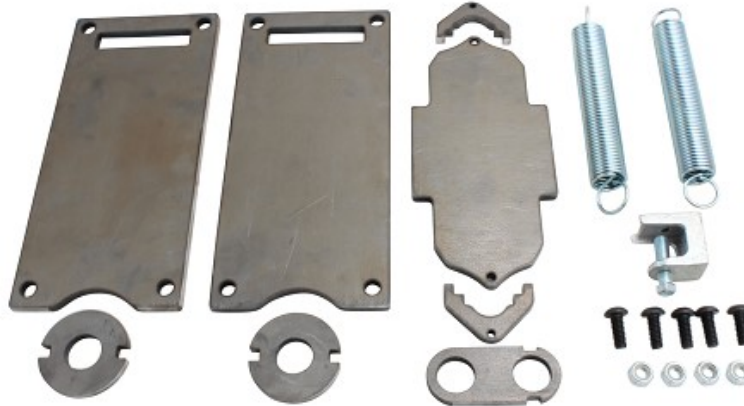
HARBOR FREIGHT TUBING ROLLER ELECTRIC DRIVE/BOTTLE JACK KIT

Tools needed for assembly:

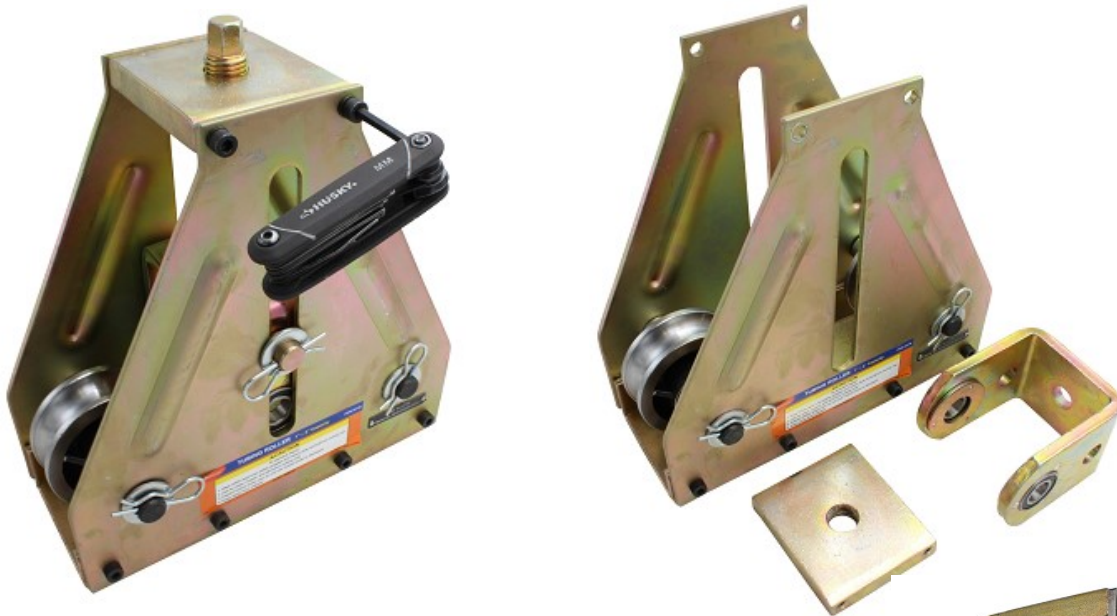
- ✓ Welder
- ✓ Basic Shop tools
- ✓ HF 4 Ton Bottle Jack, PN 66450 or PN 69472
- ✓ HF Electric Pipe Threader, PN 62203
- ✓ HF Tubing Roller, PN 99736



Step 1. Separate the laser cut tabs and grind down the rough edges where the parts were connected to each other.



Step 2. Remove the Harbor Freight threaded top plate as shown below.



Step 3. Install the (2) side plate extensions and spring retainer plate as shown below, using the provided (4) 5/16" bolts and lock nuts on the bottom, The (4) metric fasteners that were previously remove will be reinstalled on top threaded plate.

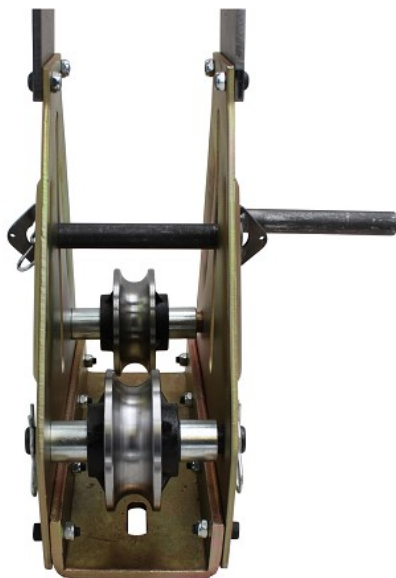


Step 4. The parts shown to the right are included with the Harbor Freight pipe threader. You will need to press the 20mm pin out of the clamping vise.

Step 5. Weld the (5) sheet metal parts as shown below. Do not weld on the inside of the 20mm through holes on these parts. Weld the anti rotation pin that was removed in step #4 above, and then tack weld this pin in a couple of spots, to verify it is kept vertical, then fully into position as shown below in the 4th picture..



Step 6. Install the 20MM pin that was previously removed in step #2 and slide it through the tube roller frame. On the back side of the frame, install the bottom spring retainer bracket and the cotter pin. You will then plug weld the front side of the 20mm pin into anti rotation bracket that was previously welded in step #5. Keep the cotter pin parallel to the ground and when welding the anti-rotation arm to the pin on keep it in either the 3 O'clock or 9 O'clock position.

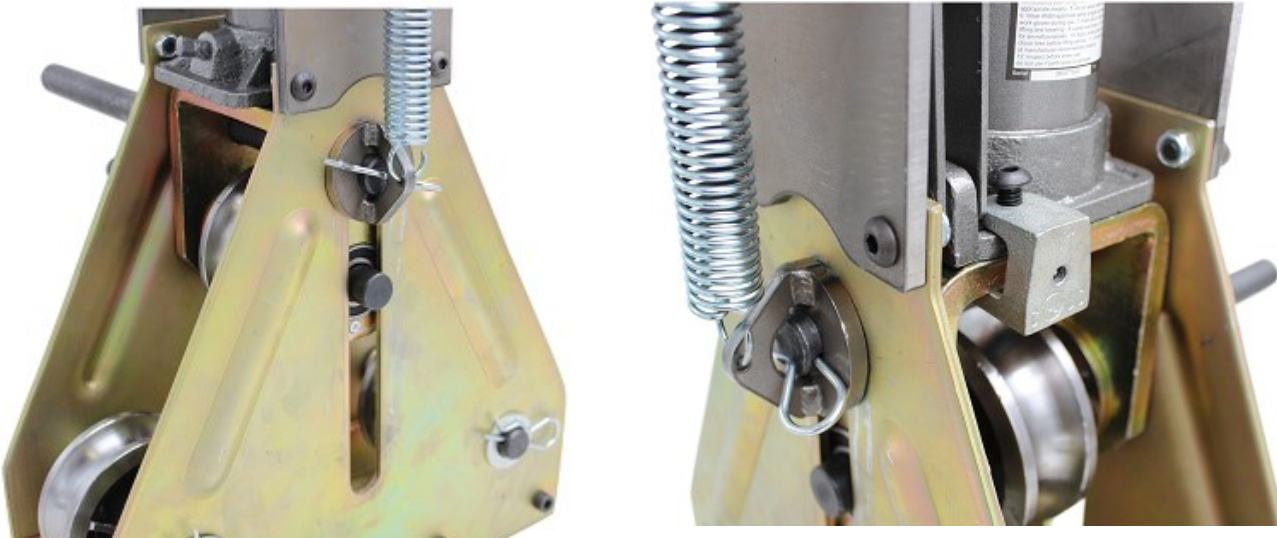


Step 7. If you are using the provided 1/2" pipe threading die that came with the Harbor Freight pipe threader proceed below, remove the 4 Phipps screws and the black cover cap as shown below. Using a screw driver evenly spread out the cutting teeth on the threading die so the 20mm drive axle can be slid into position ~4.25" down the axle as indicated below. Center up the threading die prior to welding, this will reduce the wobble of the pipe threader when installed on the tube roller.

If you are using the SWAG machined drive hub, weld the hub on the axle ~4.5" down the axle.



Step 8. Install the drive axle, 4 ton bottle jack, beam clamp, and springs as shown below. We recommend cutting a bit off the end of the springs to make installation a bit easier.





Step 9. Finished assembly. Note you will need to add grease between bottom spring mounts and the tubing roller frame to ensure the assembly slides freely up and down.



If you looking to help speed up the learning process on tips and trick to mastering the Harbor Freight tubing roller, in Google type in **“Harbor Freight Tubing Roller Review”** The first thing that will pop up is a review that we did of this roller when it first debuted ~10 years ago. It is filled with great user discussion and pictures of customer’s builds as well as problem solving solutions. Thanks for the order, happy rolling.

