

Operating Instructions

Threading with Drop Head Die Heads

Warning: Operator should be thoroughly familiar with Safety Precautions before attempting to operate this equipment.

1. Push Die Heads or Adapters, spline end first, squarely into Power Drive Face Gear until spring-loaded Adapter Pawls catch securely (Fig. 3).

Note: Installation can be made into either side of Face Gear.

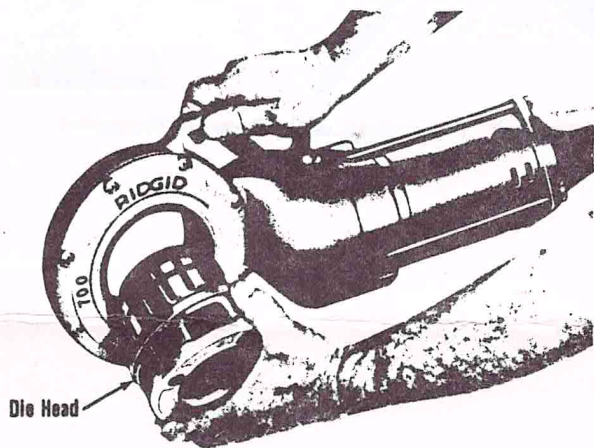


Figure 3. Installing No. 12-R Drop Head Die Head.

2. Secure pipe in Portable Tristand Vise or bench vise, if available.

Warning: When threading pipe 1 inch or larger, the No. 775 Support Arm should be used and securely locked on pipe because of torque developed during threading (Figs. 4 and 5).

3. Position No. 775 Support Arm on pipe so end of tang is in line with end of pipe (Figs. 4 and 5).

Note: When threading pipe less than 1 inch in size, without No. 775 Support Arm, hold onto Power Drive handle firmly with one hand to exert pressure against torque developed by threading.

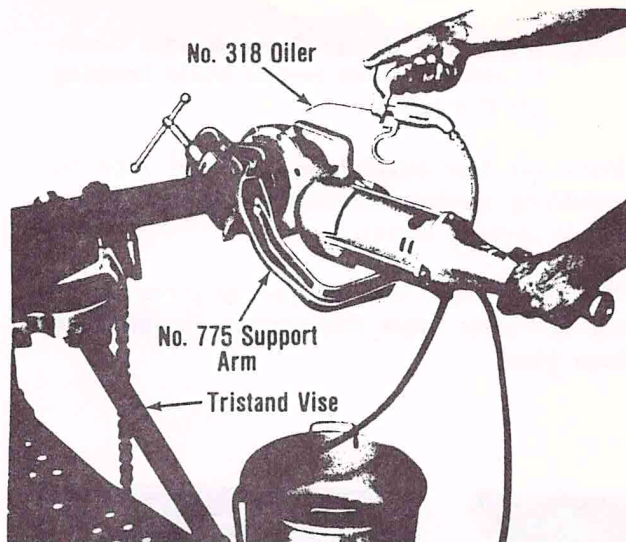


Figure 4. Threading 2" Pipe with Vise.

4. Place Die Head over end of pipe. Make sure Power Drive is correctly positioned on Support Arm. For Right Hand threads, Die Head should rotate clockwise (looking at face of Die Head).

Note: During threading, apply plenty of RIDGID Thread Cutting Oil to dies.

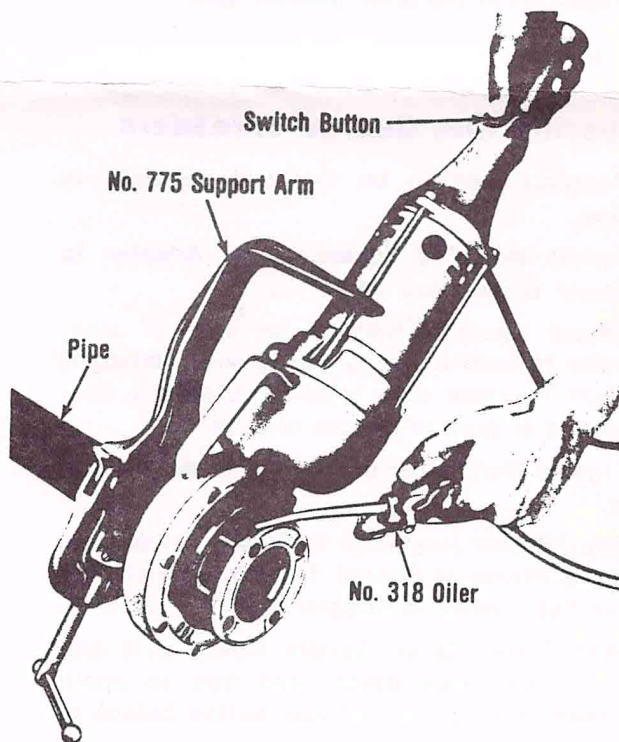


Figure 5. Threading 2" Pipe without Vise.

5. Simultaneously actuate switch button and exert pressure against Die Head with palm of free hand to make sure thread is started.
6. Keep switch button depressed until end of pipe is even with edge of chaser and release switch button.

Warning: Hold onto Power Drive handle firmly to resist initial torque while backing off Die Head.

7. Back off Die Head from threaded pipe by actuating switch button with thumb or finger in reverse direction.
8. When dies clear end of pipe, grip handle on top of Power Drive and remove Power Drive from pipe.

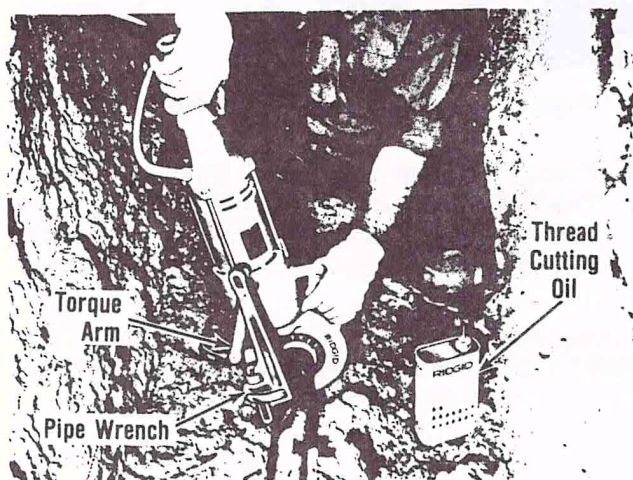


Figure 6. Ideal for Construction Use.

8. Back off Die Head by actuating switch button in reverse direction.
9. Loosen Set Screws in Adapter and remove Power Drive from Drive Pinion.
10. Loosen Workholder and remove Geared Threader.

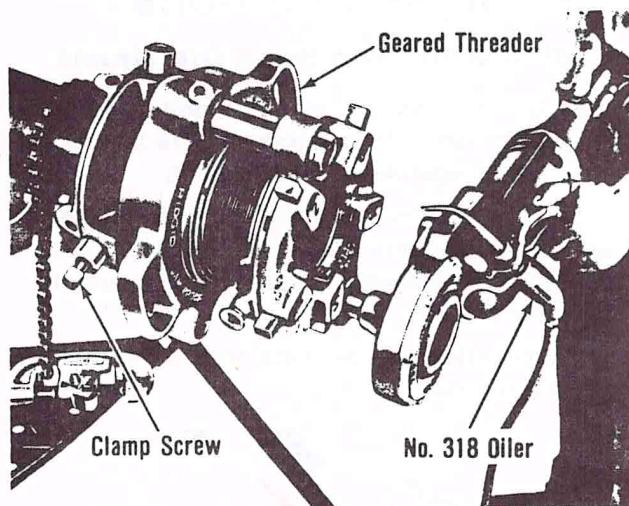


Figure 7. Threading with Geared Threader.

Threading with Geared Threaders

1. Position pipe to be threaded securely in vise.
2. Install No. 774 Square Drive Adapter in Power Drive Face Gear.
3. Adjust Geared Threader for size of pipe, (refer to instructions supplied with Threader) slide Threader onto pipe and carefully center end of pipe in throats of Dies.
4. Tighten Workholder and Clamp Screw securely.
5. Slip Adapter (installed in Power Drive) onto Drive Pinion of Geared Threader and tighten two Set Screws in Adapter.
6. Hold Power Drive handle firmly with one hand and leave other hand free to apply thread cutting oil. Actuate switch button in direction required for threading.
7. When Die Head begins to press on Ring at base of Pinion Sleeve threading is completed. Release switch button to stop Power Drive.

Note: Keep switch button actuated until Dies are free from end of pipe.