RIDGID

Threading Machine Manual

1215 Threading Machine

1½″ Capacity

⚠ WARNING!

Read this Operator's Manual carefully before using this tool. Failure to understand and follow the contents of this manual may result in electrical shock, fire and/or serious personal injury.

General Safety Information

WARNING! Read and understand all instructions. Failure to follow all instructions listed below may result in electric shock, fire, and/or serious personal injury.

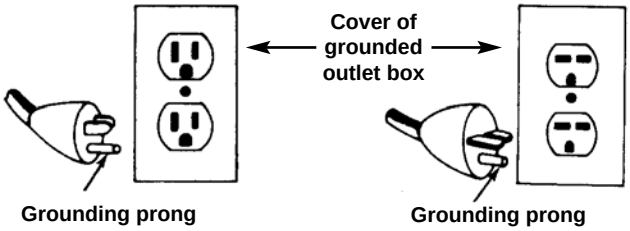
SAVE THESE INSTRUCTIONS!

Work Area Safety

- **Keep your work area clean and well lit.** Cluttered benches and dark areas invite accidents.
- **Do not operate tools in explosive atmospheres, such as in the presence of flammable liquids, gases or dust.** Tools create sparks which may ignite the dust or fumes.
- **Keep bystanders, children, and visitors away while operating a tool.** Distractions can cause you to lose control.
- **Keep floors dry and free of slippery materials such as oil.** Slippery floors invite accidents.
- **Guard or barricade the area when work piece extends beyond machine.** A guard or barricade that provides a minimum of three (3) feet clearance around the work piece will reduce the risk of entanglement.

Electrical Safety

- **Grounded tools must be plugged into an outlet, properly installed and grounded in accordance with all codes and ordinances. Never remove the grounding prong or modify the plug in any way. Do not use any adapter plugs. Check with a qualified electrician if you are in doubt as to whether the outlet is properly grounded.** If the tool should electrically malfunction or break down, grounding provides a low resistance path to carry electricity away from the user.



- **Avoid body contact with grounded surfaces.** There is an increased risk of electrical shock if your body is grounded.
- **Do not expose electrical tools to rain or wet conditions.** Water entering a tool will increase the risk of electrical shock.
- **Do not abuse cord. Never use the cord to pull the plug from an outlet. Keep cord away from heat, oil, sharp edges or moving parts. Replace damaged cords immediately.** Damaged cords increase the risk of electrical shock.
- **When operating a tool outside, use an outdoor extension cord marked "W-A" or "W".** These cords are rated for outdoor use and reduce the risk of electrical shock.
- **Use only three-wire extension cords which have three-prong grounding plugs and three-pole receptacles which accept the tool's plug.** Use of other extension cords will not ground the tool and increase the risk of electrical shock.
- **Use proper extension cords.** *(See chart.)* Insufficient conductor size will cause excessive voltage drop, loss of power and overheating.

Minimum Wire Gauge for Cord Set			
Nameplate Amps	**Total Length (in feet)**		
	0 – 25	**26 – 50**	**51 – 100**
0 – 6	18 AWG	16 AWG	16 AWG
6 – 10	18 AWG	16 AWG	14 AWG
10 – 12	16 AWG	16 AWG	14 AWG
12 – 16	14 AWG	12 AWG	NOT RECOMMENDED

- **Keep all electric connections dry and off the ground. Do not touch plugs or tool with wet hands.** Reduces the risk of electrical shock.

Personal Safety

- **Stay alert, watch what you are doing and use common sense when operating a power tool. Do not use tool while tired or under the influence of drugs, alcohol, or medications.** A moment of inattention while operating power tools may result in serious personal injury.
- **Dress properly. Do not wear loose clothing or jewelry. Contain long hair. Keep your hair, clothing, and gloves away from moving parts.** Loose clothes, jewelry, or long hair can be caught in moving parts.
- **Avoid accidental starting. Be sure switch is OFF before plugging in.** Plugging in tools in that have the switch ON invites accidents.
- **Remove adjusting keys before turning the tool ON.** A wrench or a key that is left attached to a rotating part of the tool may result in personal injury.
- **Do not over-reach. Keep proper footing and balance at all times.** Proper footing and balance enables better control of the tool in unexpected situations.

- **Use safety equipment. Always wear eye protection.** Dust mask, non-skid safety shoes, hard hat, or hearing protection must be used for appropriate conditions.

Tool Use and Care

- **Do not use if switch does not turn it ON or OFF.** Any tool that cannot be controlled with the switch is dangerous and must be repaired.
- **Disconnect plug from the power source before making any adjustments, changing accessories, or storing the tool.** Such preventive safety measures reduce risk of starting tool accidentally.
- **Store idle tools out of the reach of children and other untrained persons.** Tools are dangerous in the hands of untrained users.
- **Check for misalignment or binding of moving parts, breakage of parts, and any other condition that may affect the tools operation. If damaged, have the tool serviced before using.** Many accidents are caused by poorly maintained tools.
- **Use only accessories that are recommended for your tool.** Accessories that may be suitable for one tool may become hazardous when used on another tool.
- **Keep handles dry and clean; free from oil and grease.** Allows for better control of the tool.

Service

- **Tool service must be performed only by qualified repair personnel.** Service or maintenance performed by unqualified repair personnel could result in injury.
- **When servicing a tool, use only identical replacement parts. Follow instructions in the Maintenance Section of this manual.** Use of unauthorized parts or failure to follow maintenance instructions may create a risk of electrical shock or injury.

Specific Safety Information

⚠ WARNING

Read this operator's manual carefully before using the 1215 Threading Machine. Failure to understand and follow the contents of this manual may result in electrical shock, fire and/or serious personal injury.

Call the Ridge Tool Company, Technical Service Department at (800) 519-3456 if you have any questions.

⚠ WARNING Foot Switch Safety

Using a threading machine without a foot switch increases the risk of serious injury. A foot switch provides better control by letting you shut off the motor by removing your foot. If clothing should become caught in the machine, it will continue to wind up, pulling you into the machine. Because the machine has high torque, the clothing itself can bind around your arm or other body parts with enough force to crush or break bones.

Machine Safety

- **Threading Machine is made to thread and cut pipe or bolt. Follow instructions on proper use of this machine. Do not use for other purposes such as drilling holes or turning winches.** Other uses or modifying this power drive for other applications may increase the risk of serious injury.
- **Secure machine to bench or stand. Support long heavy pipe with pipe supports.** This practice will prevent tipping.
- **Do not wear gloves or loose clothing when operating machine. Keep sleeves and jackets buttoned. Do not reach across the machine or pipe.** Clothing can be caught by the pipe or machine resulting in entanglement and serious injury.
- **Operate machine from side with REV/OFF/FOR switch.** Eliminates need to reach over the machine.
- **Do not use this machine if the foot switch is broken or missing.** Foot switch is a safety device to prevent serious injury.
- **Keep hands away from rotating pipe and fittings. Stop the machine before wiping pipe threads or screwing on fittings. Allow the machine to come to a complete stop before touching the pipe or machine chucks.** This practice will prevent entanglement and serious injury.
- **Do not use this machine to make or break fittings.** This practice is not an intended use of the machine and can result in serious injury.
- **Tighten chuck handwheel and engage rear centering devise on the pipe before turning on the machine.** Prevents oscillation of the pipe.
- **Keep covers in place. Do not operate the machine with covers removed.** Exposure to moving parts may result in entanglement and serious injury.
- **Lock foot switch when machine is not in use *(Figure 1).*** Avoids accidental starting.

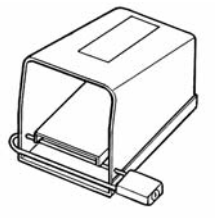


Figure 1 – Locked Foot Switch

Description, Specifications and Standard Equipment

Description

The RIDGID Model 1215 Threading Machine is an electric motor-driven machine that centers and chucks the pipe and rotates it while cutting, reaming and threading operations are performed. Threading dies are mounted in self-opening, quick-opening or semi-automatic die heads. An integral oiling system is provided to flood the work with thread cutting oil during the threading operations.

Specifications

Threading Capacity .....Pipe 1/4″ through 1 1/2″
Bolt 5/16″ through 1″

Chuck .....Speed Grip Chuck with Replaceable Jaw Inserts

Rear Centering Device .....Scroll Operated, Rotates with Chuck

Operating Speed .....44 RPM (No-Load)

Motor:
- Type .....Universal
- Horsepower.....1/2 HP
- Volts .....115V Single Phase AC 50-60 HZ (230V On Request)
- Amps.....14 Amps

Controls .....Rocker Type ON/OFF Switch and ON/OFF Foot Switch

Pump .....Gerotor-Type

Material Capacity.....Black, Galvanized, Stainless Steel, Cast Iron, IMC, PVC, Heavy Wall Conduit. Rod Up to 30 Rockwell C and Plastic Coated Pipe.

Weight .....69 lbs.

Standard Equipment

- 811A Quick Opening Die Head 1/4″–1 1/2″ NPT
- 1/2″–3/4″ Alloy Universal NPT Dies
- 1″–1 1/2″ Alloy Universal NPT Dies
- 344 Five Fluted Reamer 1/4″–1 1/2″
- 732 Cutter (Roll Type Cut-Off, Self-Centering)
- 1 Gallon NuClear Oil

Model No.	Cat. No.	Description
1215	61142	1/2″ - 1 1/2″ NPT, 115V, 60Hz
1215	56087	1/4″ - 1 1/2″ 230V, 25-60Hz NPT Export Only
1215	56092	1/4″ - 1 1/2″ BSPT 230V, 25-60Hz
1215	56097	1/4″ - 1 1/2″ 115V, 25-60Hz No Die Head, Export Only
1215	56102	1/4″ - 1 1/2″ 230V, 25-60Hz BSPT Export Only

Machine Accessories

Model No.	Cat. No.	Description
1230	61187	Tripod Stand
1219	62457	Nipple Chuck, NPT
1219	62462	Nipple Chuck, BSPT
531	97045	Bolt Die Head 1/4″ - 1″
816	84537	1/4″ - 3/4″ Semi-Automatic Die Head
817	84532	1″ - 1 1/2″ Semi-Automatic Die Head

NOTE! NPT Dies are for NPT Die heads only. BSPT Dies are for BSPT Die Heads only. Please use Catalog Item Nos. when ordering.

Machine Mounting

⚠ WARNING

To prevent serious injury, proper mounting of the Threading Machine is required. The following procedures should be followed:

Mounting Machine To No. 1203 Leg Stand

1. Assemble the 1203 stand by placing the legs into the sockets on the bottom of the base.
2. Secure the legs by inserting the bolts through holes in the base and tighten with the nuts provided.
3. Mount the machine to the stand using the three (3) bolts provided. Make sure the stand and base are stable.

⚠ WARNING Machine should not be operated without being securely fastened to the stand.

Figure 2 – Mounting Machine to Stand

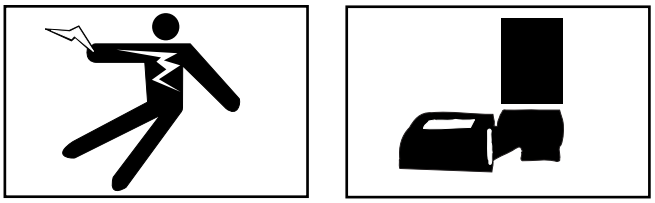
Mounting Machine To Bench

1. If a stand is not used, the machine should be mounted to a stable bench. To mount the unit on a bench, use three (3) bolts in holes provided in the machine base.

⚠ WARNING Failure to mount the threading machine to a stable stand or bench may result in tipping and serious injury.

Machine Inspection

⚠ WARNING



To prevent serious injury, inspect your Threading Machine. The following inspection procedures should be performed on a daily basis:

1. Make sure Threading Machine is unplugged and the ON/OFF switch is set to the OFF position *(Figure 3)*.

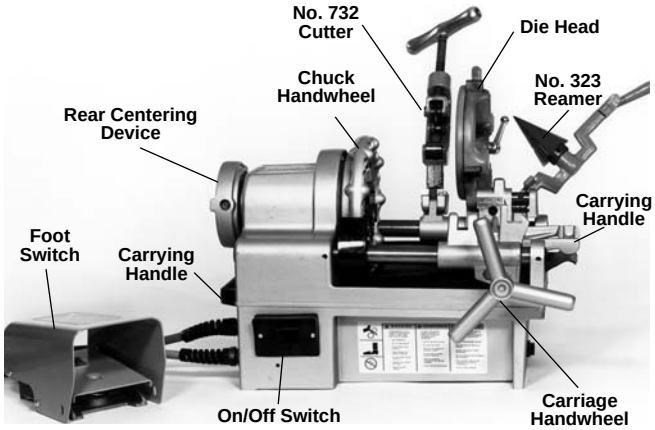


Figure 3 – No. 1215 Threading Machine

2. Clean the speed chuck jaws with a wire brush.
3. Inspect the jaw inserts for excessive wear. Refer to the Maintenance Instructions if they need to be replaced.

NOTE! For plastic and coated work pieces, special jaw inserts (No. 58302) should be used to prevent damaging the workpiece.

4. Make sure the foot switch is present and attached to the Threading Machine.

⚠ WARNING Do not operate the Threading Machine without a foot switch.

5. Inspect the power cord and plug for damage. If the plug has been modified, is missing the grounding pin, or if the cord is damaged, do not use the Threading Machine until the cord has been replaced.
6. Inspect the Threading Machine for any broken, missing, misaligned or binding parts as well as any other conditions which may affect the safe and normal operation of the machine. If any of these conditions are present, do not use the Threading Machine until any problem has been repaired.
7. Lubricate the Threading Machine if necessary according to the Maintenance Instructions.
8. Use tools and accessories that are designed for your Threading Machine and meet the needs of your application. The correct tools and accessories allow you to do the job successfully and safely. Accessories designed for use with other equipment may be hazardous when used with this Threading Machine.
9. Clean any oil, grease or dirt from all handles and controls. This reduces the risk of injury due to a tool or control slipping from your grip.

Inspect the cutting edges of your tools and dies. If necessary, have them replaced prior to using the Threading Machine. Dull or damaged cutting tools and dies can lead to binding , tool breakage and poor quality threads

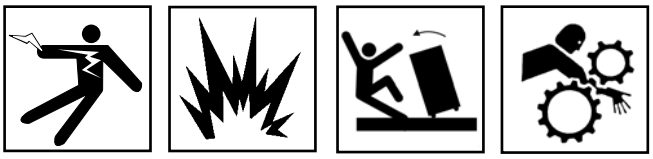
Clean metal shavings and other debris from the chip tray of the Threading Machine. Check the level and quality of the thread cutting oil. Replace or add oil if necessary. Reservoir in the base will hold approximately one (1) quart of thread cutting oil.

NOTE! Thread cutting oil lubricates and cools the threads during the threading operation. A dirty or poor grade cutting oil can result in poor thread quality and reduce die life.

NOTE! To drain dirty oil and properly maintain the oil system, refer to the “Maintenance Instructions”.

Machine and Work Area Set-Up

⚠ WARNING



To prevent serious injury, proper set-up of the machine and work area is required. The following procedures should be following to set-up the machine.

1. Locate a work area that has the following:
   - Adequate lighting.
   - No flammable liquids, vapors or dust that may ignite.
   - Grounded electrical outlet.
   - Clear path to the electrical outlet that does not contain any sources of heat or oil, sharp edges or moving parts that may damage electrical cord.
   - Dry place for machine and operator. Do not use the machine while standing in water.
   - Level ground.
2. Clean up the work area prior to setting up any equipment. Always wipe up any oil that may have splashed or dripped from the machine to prevent slips and falls.
3. If the workpiece extends more than four (4) feet beyond the Threading Machine, use one or more pipe stands to prevent tipping and the oscillation of the pipe.
4. If the workpiece extends beyond the Threading Machine, set-up guards or barricades to create a minimum of three (3) feet of clearance around the Threading Machine and workpiece. This “safety zone” prevents others from accidentally contacting the machine or workpiece and either causing the equipment to tip or becoming entangled in the rotating parts.
5. If necessary, fill the reservoir with RIDGID Thread Cutting Oil.
6. Make sure ON/OFF switch is in the OFF position.
7. Position the foot switch so that the operator can safely control the machine, tools and workpiece. It should allow the operator to do the following:
   - Stand facing the ON/OFF switch.
   - Use the foot switch with his left foot.
   - Have convenient access to the ON/OFF switch, tools and chucks without reaching across the machine.

Machine is designed for one person operation.

8. Plug the Threading Machine into the electrical outlet making sure to position the power cord along the clear path selected earlier. If the power cord does not reach the outlet, use an extension cord in good condition.

⚠ WARNING To avoid electrical shock and electrical fires, never use an extension cord that is damaged or does not meet the following requirements:

- The cord has a three-prong plug similar to shown in Electrical Safety section.
- The cord is rated as “W” or “W-A” if being used outdoors.
- The cord has sufficient wire thickness (14 AWG below 25′/12 AWG 25′-50′). If the wire thickness is too small, the cord may overheat, melting the cord’s insulation or causing nearby objects to ignite.

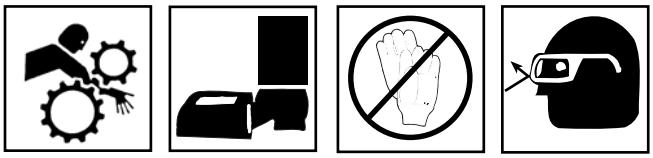
⚠ WARNING To reduce risk of electrical shock, keep all electrical connections dry and off the ground. Do not touch plug with wet hands.

9. Check the Threading Machine to insure it is operating properly.
   - Flip the switch to ON. Press and release the foot switch. Check that the Threading Machine rotates in a counterclockwise direction as you are facing the front chuck. Have the Threading Machine serviced if it rotates in the wrong direction or if the foot switch does not control its stopping or starting.

- Depress and hold the foot switch. Inspect the moving parts for misalignment, binding, odd noises or any other unusual conditions that may affect the safe and normal operation of the machine. If such conditions are present, have the machine serviced.
- Release the foot switch and flip the switch to OFF.

Operation Using Machine-Mounted Tools

⚠ WARNING



Do not wear gloves or loose clothing when operating Threading Machine. Keep sleeves and jackets buttoned. Do not reach across the machine or pipe.

Do not use this Threading Machine if the foot switch is broken or missing. Always wear eye protection to protect eyes from dirt and other foreign objects.

Keep hands away from rotating pipe and fittings. Stop the machine before wiping pipe threads or screwing on fittings. Allow the machine to come to a complete stop before touching the pipe or machine chucks.

Do not use this machine to "make-on" or "break off" fittings. This practice is not an intended use of this Threading Machine.

Installing Pipe In Threading Machine

1. Check to insure the cutter, reamer and die head are swung to UP position.
2. Mark the pipe at the desired length if it is being cut to length.
3. Insert the pipe into the Threading Machine so that the end to be worked or the cutting mark is located about 12 inches to the front of the speed chuck jaws.
4. Insert workpieces less than 2 feet long from the front of the machine. Insert longer pipes through either end so that the longer section extends out beyond the rear of the Threading Machine.

⚠ WARNING To avoid equipment tip-overs, position the pipe supports under the workpiece.

5. Tighten the rear centering device around the pipe by using a counterclockwise rotation of the handwheel at the rear of the Threading Machine. This prevents movement of the pipe that can result in poor thread quality.
6. Secure the pipe by using repeated and forceful counterclockwise spins of the speed chuck handwheel at the front of the Threading Machine. This action "hammers" the jaws tightly around the pipe.

Cutting Pipe With No. 732 Cutter

1. Swing reamer and die head to UP position.
2. Move pipe cutter DOWN onto pipe and move carriage with handwheel to line up cutter wheel with mark on pipe.
3. Tighten cutter feed screw handle on pipe keeping wheel aligned with the pipe.
4. Assume the correct operating posture *(Figure 4)*.

⚠ WARNING This will allow you to maintain proper balance and to safely keep control of the machine and tools.

- Be sure you can quickly remove your foot from the foot switch.
- Stand facing the ON/OFF switch.
- Be sure you have convenient access to the ON/OFF switch, tools and chucks.
- Do not reach across the machine or workpiece.

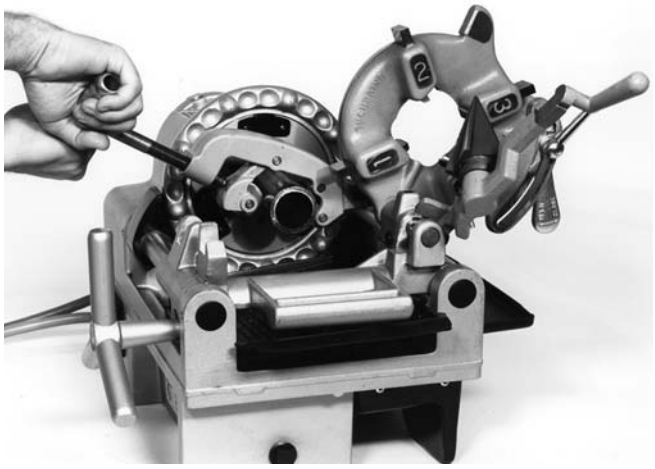


Figure 4 – Cutting Pipe With No. 732 Cutter

5. Flip the switch to ON.
6. Grasp the pipe cutter's feedscrew handle with both hands *(Figure 5)*.
7. Depress and hold down the foot switch with the left foot.
8. Tighten the feedscrew handle slowly and continuously until the pipe is cut. Do not force the cutter into the workpiece.
9. Release the foot switch and remove your foot from the housing.

10. Swing pipe cutter back to the UP position.

Pipe Reaming with No. 344 Reamer

1. Move reamer arm into DOWN position.
2. Depress and hold the foot switch down with left foot.
3. Position reamer into pipe and complete reaming by exerting pressure on handwheel *(Figure 5)*.

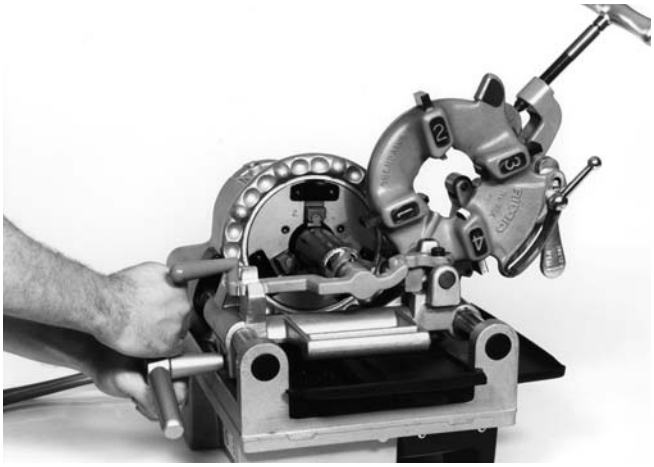


Figure 5 – Reaming Pipe with No. 344 Reamer

4. Retract reamer and return reamer to UP position.
5. Release foot switch and remove your foot from the housing.

Threading Pipe Or Rod With Quick-Opening, Self-Opening or Semi-Automatic Die Head

1. Install die set. Refer to die installation procedure.
2. Swing cutter and reamer to UP position.
3. Swing die head to DOWN position with throwout lever set to CLOSE position.
4. Depress and hold the foot switch down with left foot.

NOTE! 1215 Machines have an automatic oiling system that brings oil to the work through the die head. Oil flow can be adjusted with oil flow control valve located on back side of carriage *(Figure 6)*.

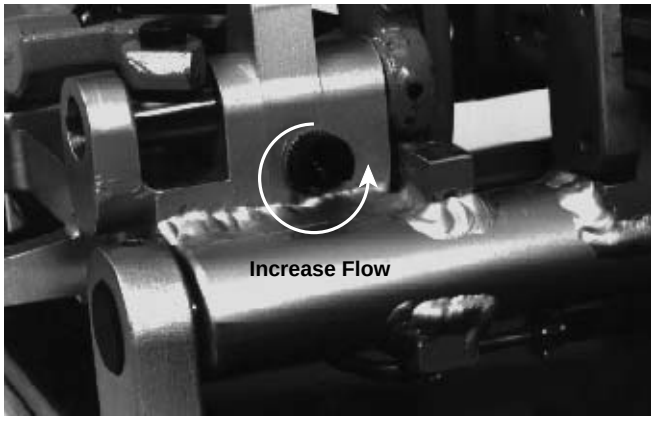


Figure 6 – Oil Flow Control

5. Turn carriage handwheel to bring dies against end of pipe. Slight pressure on handwheel will start dies *(Figure 7)*.

Figure 7 – Threading Pipe With No. 811-A Die Head

6. Quick-Opening 811A Die Head *(Figure 8)* – When thread is completed, raise throwout lever to open position, retracting dies.

   Self-Opening 815A Die Head *(Figure 9)* – When die head trigger contacts end of pipe, throwout lever is automatically opened.

NOTE! For $^{1}/_{2}$″ - $1^{1}/_{2}$″ pipe, die heads will open automatically when proper length of thread has been cut. For $^{1}/_{4}$″ - $^{3}/_{8}$″ pipe, die heads must be opened manually. With die head trigger placed up and out of the way, thread length can be controlled by manually releasing throw-out lever. This is necessary for making long BSPP and NPSM threads.

Semi-automatic die head *(Figure 10)* – When the end of the pipe being threaded is flush with the end of the number 1 die, hit the handle for the dies to release the pipe.

7. Turn carriage handwheel to back die head off pipe.
8. Swing die head back to UP position.
9. Release foot switch and push control switch to OFF position.

Removing Pipe From The Threading Machine

1. Use repeated and forceful clockwise spins of the speed chuck handwheel at the front of the Threading Machine to release the workpiece from the speed chuck jaws.
2. If necessary, loosen the rear centering device using a clockwise rotation of the handwheel at the rear of the Threading Machine.
3. Slide the workpiece out of the Threading Machine, keeping a firm grip on the workpiece as it clears the Threading Machine.

⚠ WARNING To avoid injury from falling parts or equipment tip-overs when handling long workpieces, make sure that the end farthest from the Threading Machine is supported prior to removal.

Installing Dies In Quick-Opening Die Head (Right Hand)

The 811-A Universal Die Head *(Figure 8)* for right-hand threads requires four sets of dies to thread pipe ranging from 1/8″ through 1 1/2″. One set of dies is required for each of the following pipe size ranges: (1/8″), (1/4″ and 3/8″), (1/2″ and 3/4″), and (1″ through 1 1/2″). Bolt threading requires a separate set of dies for each bolt size.

1. Lay die head on bench with numbers up.
2. Flip throwout lever to OPEN position.
3. Loosen clamp lever approximately three turns.
4. Lift tongue of clamp lever washer up out of slot under size bar. Slide throwout lever all the way to end of slot in the over direction indicated on size bar.
5. Remove dies from die head.
6. Die numbers 1 through 4 must agree with those on die head.
7. Insert dies to mark on side of dies.
8. Slide throwout lever back so that tongue of clamp lever washer will drop in slot under size bar.
9. Adjust die head size bar until index line on link is aligned with proper size mark on size bar.
10. Tighten clamp lever. For bolt threads, align index line with bolt line on size bar.
11. If oversize or undersize threads are required, set the index line in direction of OVER or UNDER size mark on size bar.

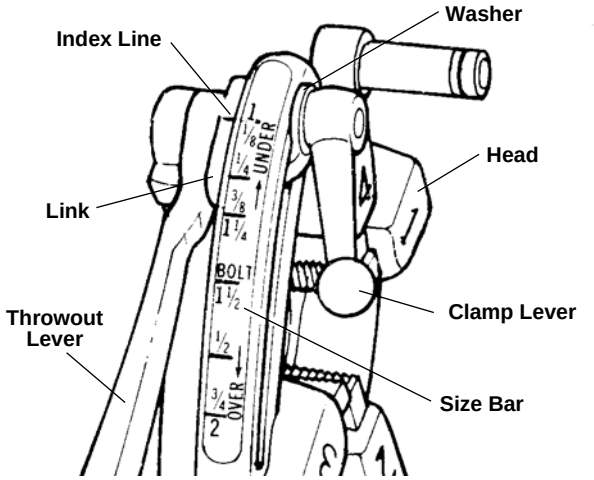


Figure 8 – 811-A Quick-Opening Die Head

Installing Dies In Self-Opening Die Head (Right Hand)

The No. 815-A Self-Opening Die Head *(Figure 9)* for right-hand threads requires four sets of dies to thread pipe ranging from 1/8″ through 1 1/2″. One set of dies is required for each of the following pipe size ranges: (1/8″), (1/4″ and 3/8″), (1/2″ and 3/4″), and (1″ through 1 1/2″). Bolt threading requires a separate set of dies for each bolt size.

1. Place self-opening die head on bench in vertical position.
2. Make sure trigger assembly is released.
3. Loosen clamp lever approximately six full turns.
4. Pull lock screw out of slot under size bar so that roll pin in lock screw will by-pass slot. Position size bar so that index line on lock screw is all the way to the end of REMOVE DIES position.
5. Lay head down with numbers up.
6. Remove dies from die head.
7. Die numbers 1 through 4 on the dies must agree with those on die head.
8. Insert new dies to mark on sides of dies.
9. Move lever back to lock in dies.

10. With head in vertical position, rotate cam plate until roll pin on lock screw can be positioned in slot under size bar. In this position dies will lock in die head. Make sure roll pin points toward end of size bar marked REMOVE DIES.
11. Adjust die head size bar until index line on lock screw of link is aligned with proper size marks on size bar.
12. Tighten clamp lever. For bolt threads, align index line with bolt line on size bar.
13. If oversize or undersize threads are required, set the index line in direction of OVER or UNDER size mark on size bar.

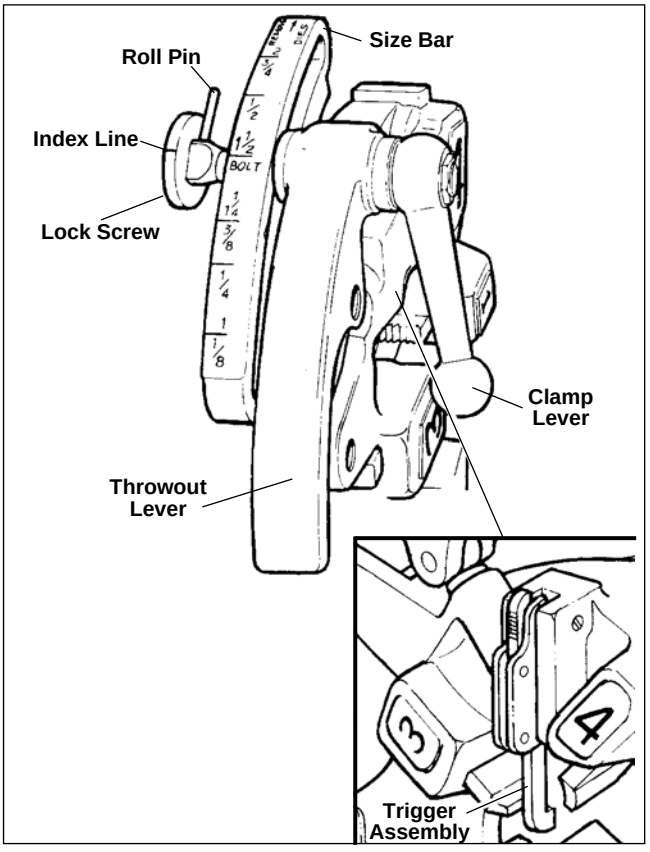


Figure 9 – 815-A Self-Opening Die Head

Installing Dies In Model 816/817 Semi-Automatic Die Heads

The 816/817 Semi-Automatic Die Head *(Figure 10)* for right hand threads requires four sets of dies to thread pipe ranging from 1/8″ through 1 1/2″. One set of dies is required for each of the following pipe size ranges: (1/8″), (1/4″ and 3/8″), (1/2″ and 3/4″) and (1″ through 1 1/2″). Bolt threading requires a separate set of dies for each bolt size.

1. Depress handle so that cam plate rests *(Figure 10 – Model 816/817 Semi-Automatic Die Head)* against the stop (as shown).
2. Lay the die head down flat on a table or bench with the numbers facing up.
3. Pull up on the plunger knob and push the handle all the way to the left.
4. Select the correct dies for the size desired. (Size marked on the back or face of the dies.)
5. Numbers on the dies must correspond with those on the die head slots. Insert dies to the line marked on the dies – numbered edge up.
6. Rotate the handle back to the right so that the plunger knob pops back down flush against the die head.
7. To set or adjust for desired size, loosen the screw for the desired position block size, move the block to the right to make it undersize and to the left to make it oversized. When setting blocks for new dies start with the position block on the middle mark and adjust from there.

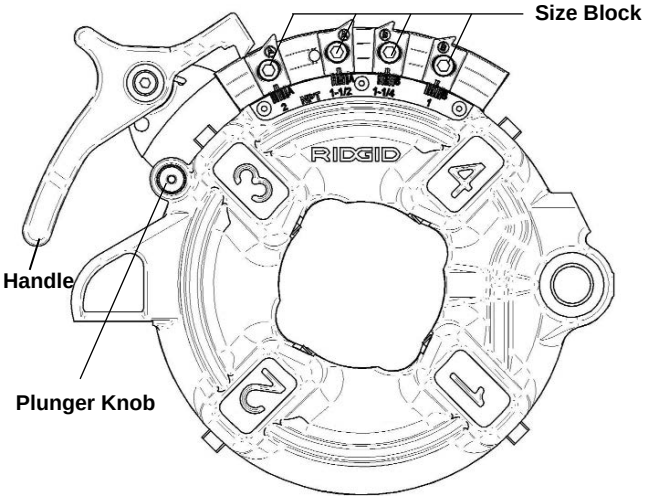


Figure 10 – 816/817 Semi-Automatic Die Head

Checking Thread Length

1. Thread is cut to proper length when end of pipe is flush with edge of dies *(Figure 11)*.
2. Die Head is adjustable to obtain proper thread diameter. If possible, threads should be checked with a thread ring gage *(Figure 11)*. A proper thread is cut when end of pipe is plus or minus one turn of being flush with face of ring gage.

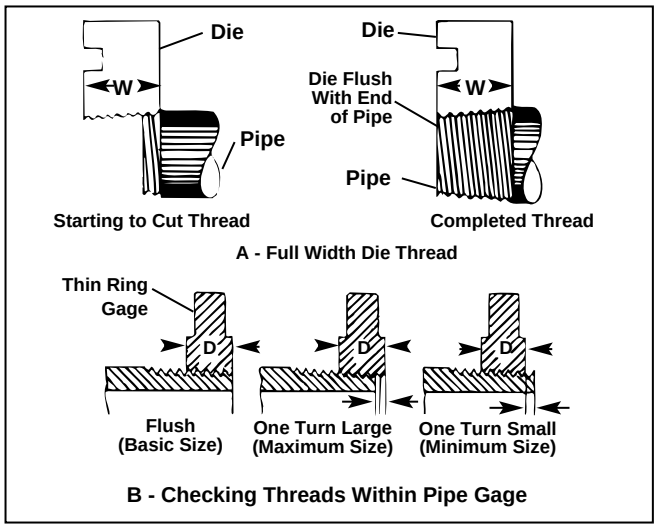


Figure 11 – Checking Thread Length

NOTE! If a ring gauge is not available, a fitting can be used. This fitting should be representative of those being used on the job. The pipe thread should be cut to obtain 2 to 3 turns hand tight engagement with fitting. If pipe thread is not proper diameter the index line should be moved in the direction of the OVER or UNDER size mark on size bar. (Refer to "Installing Dies In Die Heads").

Accessories

⚠ WARNING Only the following RIDGID products have been designed to function with the 1215 Threading Machine. Other accessories designed for use with other tools may become hazardous when used on this Threading Machine. To prevent serious injury, use only the accessories listed below.

Accessories For Threading Machine

Die Heads and Dies

Model	Pipe Capacity	Bolt Capacity	Dies	Opening	Operation
811A NPT	1/8″ - 2″	1/4″ - 2″	Universal	Quick	R.H.
815A NPT	1/8″ - 2″	1/4″ - 2″	Universal	Self	R.H.
816 NPT	1/8″ - 3/4″	1/4″ - 2″	Universal	TAP	R.H.
817 NPT	1″ - 2″	1/4″ - 2″	Universal	TAP	R.H.
811A BSPT	1/8″ - 2″	1/4″ - 2″	Universal	Quick	R.H.
815A BSPT	1/8″ - 2″	1/4″ - 2″	Universal	Self	R.H.
531 Bolt	—	1/4″ - 1″	500B	Quick	R.H.
532 Bolt	—	1 1/8″ - 2″	500B	Quick	R.H.

Stands:

No. 1203 Leg Stand

Pipe Supports:

VJ-99, VJ-98, RJ-99

No. 1219 Nipple Chuck (Right Hand Only):

Pipe Adapters.....1/8″ through 1 1/2″

Stud Adapters.....1/4″ through 1″ UNC
1/4″ through 1″ UNF

Jaw Inserts For Coated Pipe

NOTE! See Ridge Tool Catalog for complete list of pipe supports, thread cutting oil and dies.

Maintenance Instructions

⚠ WARNING

Make sure machine is unplugged from power source before performing maintenance or making any adjustment.

Oil Flow Control Valve

The flow of oil out of the die head can be increased or decreased by adjusting oil control valve. *(See Figure 7.)*

Lubrication

Proper lubrication is essential to trouble-free operation and long life of threading machine. Two oil inlets are provided on top of machine housing to allow for oiling of the front and rear bearings. *(See Figure 12.)*

NOTE! Bearings should be oiled periodically, depending on usage of machine.

1. Fill bearing cavity with oil.
2. Depress ball bearing to allow oil to reach bearing.

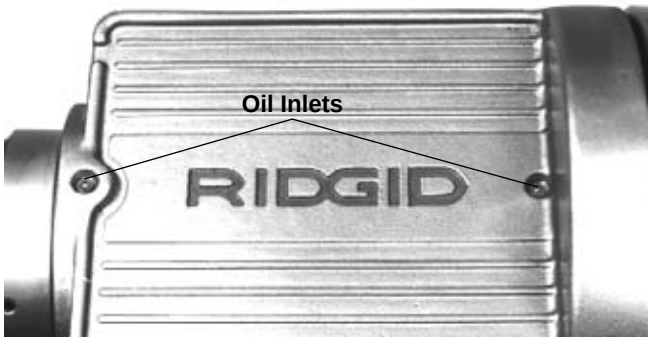


Figure 12 – Lubricate Bearings

Oil System Maintenance

To help assure proper operation of threading machine, keep oil system clean, as follows:

1. Replace thread cutting oil when it becomes dirty or contaminated. To drain oil, position a container under the drain plug and remove plug.

2. Keep oil filter screen clean to assure proper flow of clean oil to work. Oil filter screen is located in the bottom of oil reservoir. Do not operate machine with oil filter screen removed.

NOTE! Do not disassemble oil pump. Pump should be disassembled only by a RIDGID Authorized Service Center.

Cleaning Oil System

1. Place container under oil reservoir drain plug.
2. Remove drain plug and drain oil.
3. Slide out chip tray.
4. Lift up and remove oil tray.
5. Use putty knife to remove pipe scale, metal shavings and dirt from bottom of oil reservoir.

Jaw Insert Replacement

NOTE! Never remove insert if jaw is out of machine. A spring loaded locating pin behind insert can cause injury.

1. **To remove insert** — place punch into spring détente slot of jaw and push down. *(Figure 13)*
2. Continue to push down on spring détente and slowly slide insert out of chuck jaw holder.
3. **Install new insert** — place into chuck jaw holder and with finger, depress spring and plunger. Slowly move insert past spring and plunger until insert fully sits in chuck jaw holder.

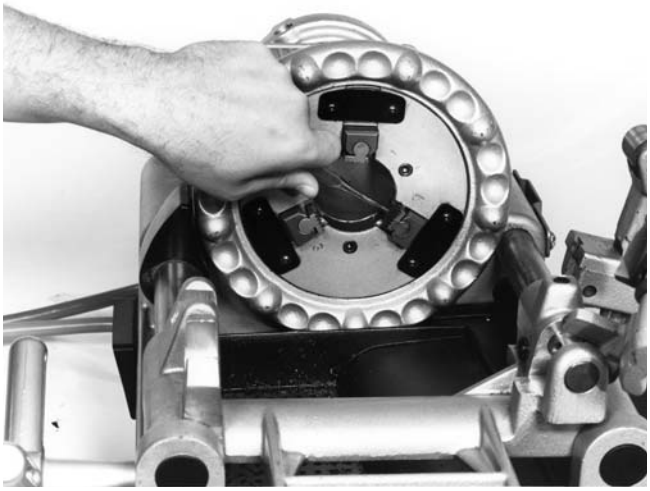


Figure 13 – Replacing Jaw Inserts

Replacing Brushes In Motor

NOTE! Check motor brushes every 6 months and replace when worn to less than $^{1}/_{2}$″.

1. Unplug machine from power source.
2. Fully loosen three screws that hold motor housing cover in place and remove motor housing cover. *(Figure 14)*
3. Fully loosen two motor cover screws and remove motor cover.
4. Carefully remove carbon brushes.
5. Install new carbon brushes.
6. Re-install motor cover and housing.

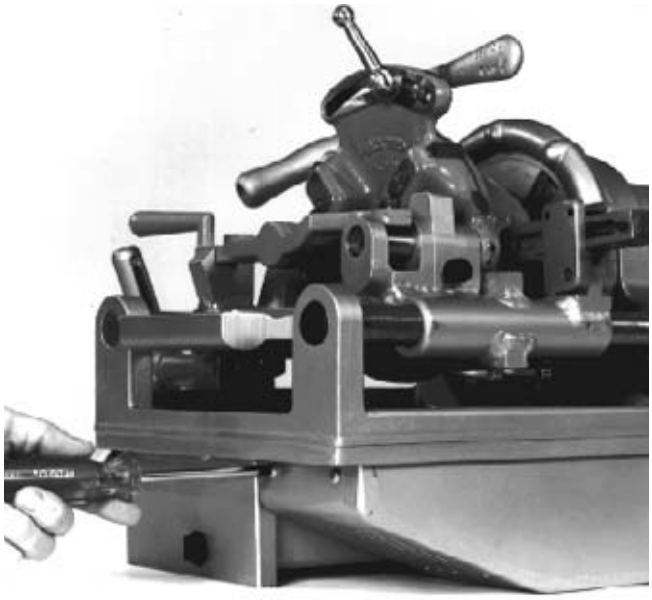


Figure 14 – Loosen and Remove Motor Cover Screws

Machine Storage

⚠ WARNING Motor-driven equipment must be kept indoors or well covered in rainy weather. Store the machine in a locked area that is out of reach of children and people unfamiliar with threading machines. This machine can cause serious injury in the hands of untrained users.

Service and Repair

⚠ WARNING

Service and repair work on this Threading Machine must be performed by qualified repair personnel.

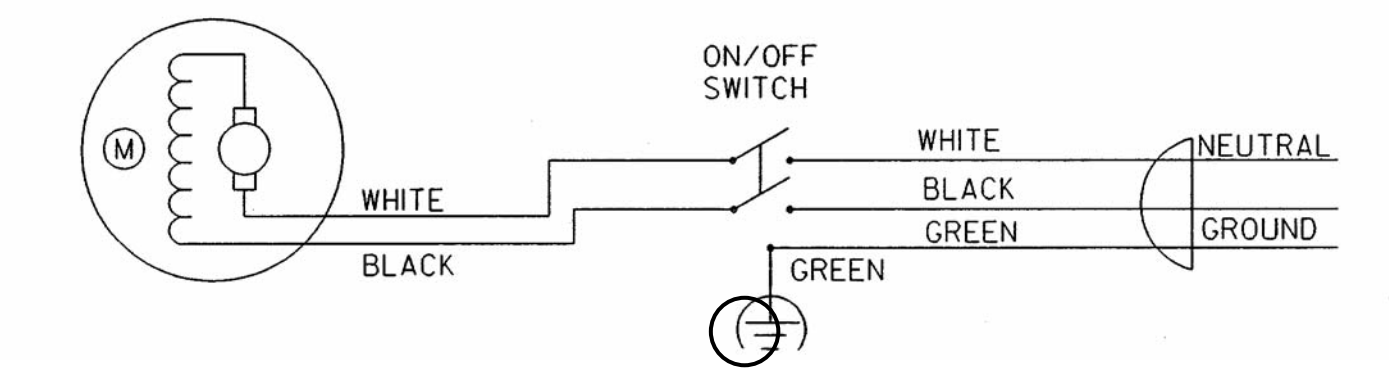
Machine should be taken to a RIDGID Independent Authorized Service Center or returned to the factory. All repairs made by Ridge service facilities are warranted against defects in material and workmanship.

When servicing this machine, only identical replacement parts should be used. Failure to follow these instructions may create a risk of electrical shock or other serious injury.

Wiring Diagrams

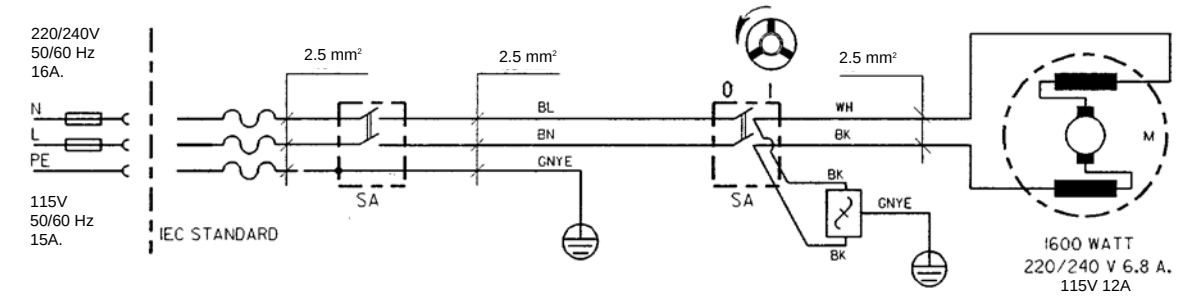
Far East Version

115V 50-60 Hz Without Foot Switch
100V 50-60 Hz Without Foot Switch



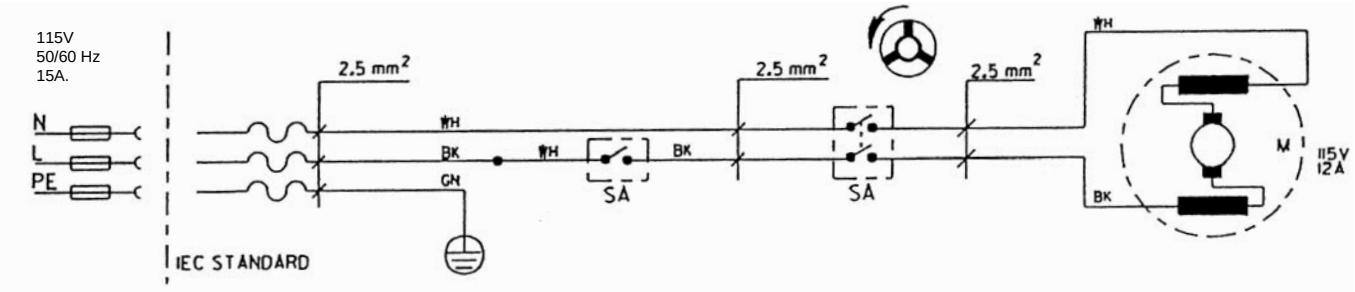
European Version

230V 50-60 Hz With Foot Switch
115V 50-60 Hz With Foot Switch



Domestic Version

115V 50-60 Hz With Foot Switch



We Build Reputations™

RIDGID

EMERSON™
Commercial & Residential Solutions

EMERSON. CONSIDER IT SOLVED.™

Printed in U.S.A. 2/14
EC39890

999-997-051.10
REV. A