RIDGID® 65R-C and 65R-TC Threaders are designed to thread 1" to 2" pipe and conduit using a manually operated internal ratchet.

⚠ WARNING Read these instructions carefully before using this tool. Failure to follow all instructions may result in property damage and/or serious injury.

Thread Size Adjustment

1. Place threader with workholder up *(Figures 1 and 2)* and unscrew workholder by turning counter-clockwise until change plate is clear of posts.
2. Move post to desired pipe size. Screw workholder clockwise until change plate slides over post.
3. Adjust change plate to desired thread size.

Standard Size Thread: Set change plate between the two "Standard" marks.

Oversize Thread: For oversize (shallow) thread, set change plate slightly below the "Standard" marks.

Undersize Thread: For undersize (deep) thread, set change plate slightly above the "Standard" marks.

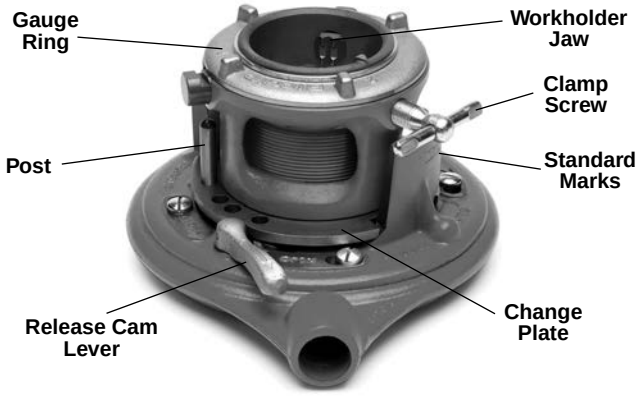


Figure 1 – 65R-C Threader

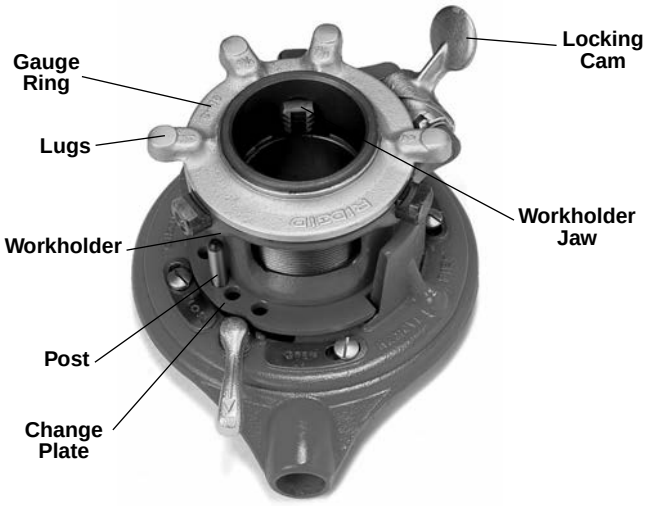


Figure 2 – 65R-TC Threader

Threading

1. Inspect the threader before use. Replace dies or any other part that shows damage or wear. To insure high thread quality, only use RIDGID replacement dies.

⚠ WARNING Worn dies can result in poor thread quality and high handle forces.

2. Mount the pipe firmly in a pipe vise. When threading an existing pipe, make sure it is secure and will not move. Cut the end of the pipe cleanly and squarely using a pipe cutter *(Figure 3)*.

⚠ WARNING To prevent tipping, long lengths of pipe should also be supported with a pipe stand. Vise and stands should be on level ground.

⚠ WARNING When working on a scaffold or lift, the operator should be properly secured to prevent injury in the event of a fall.

Figure 3 – Cutting End Of Pipe

3. Ream the end of the pipe to remove any burrs that may have been produced during the cutting of the pipe *(Figure 4)*.

Figure 4 – Reaming End Of Pipe

4. Adjust thread size for the size pipe to be threaded (refer to previous instructions for thread size adjustment).
5. Adjust workholder:

65R-C: Turn gauge ring until desired pipe size corresponds with mark on top of workholder *(Figure 1)*.

65R-TC: Turn gauge ring until desired pipe size is aligned with locking cam *(Figure 2)*.

6. Turn release cam lever to the “closed” position. Slide threader on the pipe with the workholder end first *(Figure 5)*. Center end of pipe in the throat of the dies.
7. Secure workholder on the pipe by tightening the clamp screw *(Figure 1)* or the locking cam *(Figure 2)*.

Figure 5 – Sliding Threader Onto Pipe

8. Move the handle in a pumping action to thread the pipe.

⚠ WARNING Make sure handle is clean and free from oil and grease. This allows better control of the tool.

9. When hand threading, your weight should be above the handle ensuring maximum leverage. If possible, do not do all the work with you arms; use your weight. Do not overreach. Keep proper footing and balance to maintain better control.

⚠ WARNING Do not slide a pipe or “cheater” over the handle to gain extra leverage. This practice can result in serious injury.

NOTE! When using the 65-R Threader with the 300 Power Drive, manually start the thread (approximately one turn) before starting power drive.

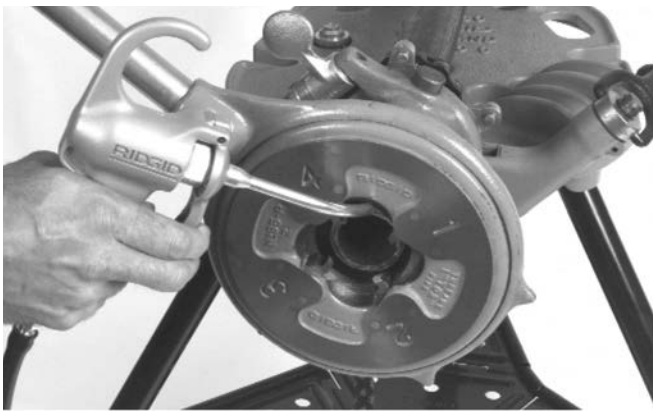


Figure 6 – Applying Thread Cutting Oil

10. Apply a generous quantity of RIDGID Thread Cutting Oil when threading *(Figure 6)*. Use of a lubricating oil or a poor thread cutting oil can result in a poor quality cut thread, leaky joints, short die life and high handle forces.
11. 65R Threaders are jam-proof and will automatically kick out and disengage the ratchet action when the thread is complete.
12. Remove threader from pipe by turning release cam lever to “OPEN” and spin threader back to the “STANDARD” position. Loosen clamp screw or locking cam and slide threader off the pipe.

    or

    Remove by turning the release lever to “OPEN” position, loosening clamp screw or locking cam, and pulling threader straight off pipe. Maintain close control of the threader so the threads are not damaged. Spinning the threader back to the “STANDARD” position is not required.

NOTE! Clean any oil spill or splatter that is on the ground. At the end of each job, always clean your threader and store in a clean dry area to protect against damage.

Changing Dies

1. Place threader in position as shown in *Figure 1* and unscrew workholder upwards until change plate is clear of post. Turn release cam lever to OPEN position.
2. Push post to the left past the 2" mark. Turn the threader over and remove dies. If the dies stick, tap the ratchet ring lightly behind the die.
3. Insert new dies making sure die numbers correspond to the slot numbers. Replace complete die set. Move post to engage dies.

⚠ CAUTION Failure to replace complete die set may result in poor thread quality and leaky joints.

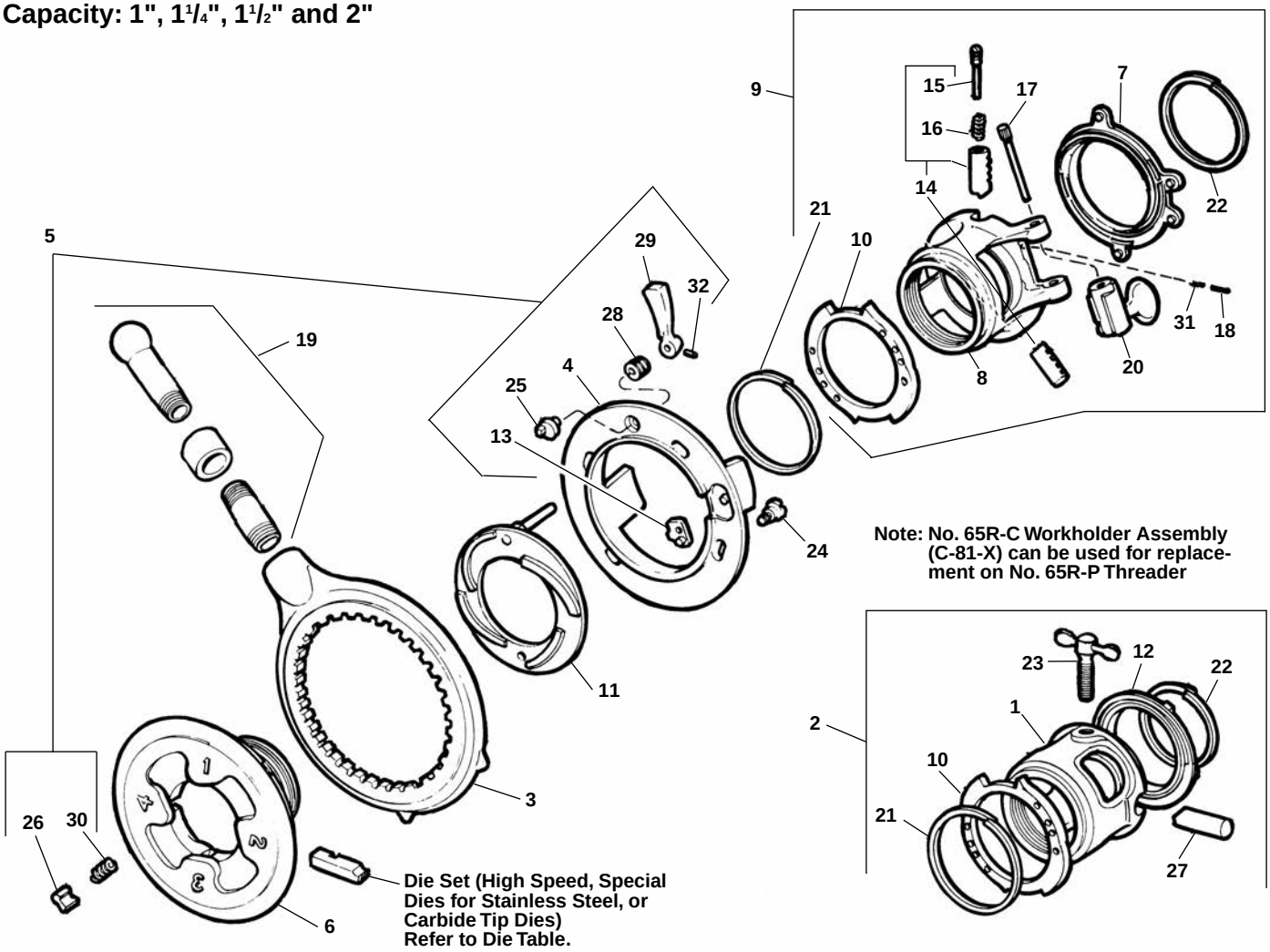
4. Turn threader over and set post to desired pipe size. Screw workholder down so change plate is between the “Standard” size marks and you are ready to resume threading.

Service and Repair

⚠ WARNING When servicing this tool, only identical replacement parts should be used. Failure to follow these steps may create a risk of serious injury.

Nos. 65R-C & 65R-TC

Capacity: 1", 1¼", 1½" and 2"



NOTE: Order parts by Catalog Number only. DO NOT order by Reference Number.

Ref. No.	Catalog No.	Description
1	39335	65R-C Workholder (Cam Type) N.P.T.
	68100	65R-C Workholder (Cam Type) B.S.P.T.
2	39340	65R-C Workholder Assy. (Cam Type) N.P.T.
	68110	65R-C Workholder Assy. (Cam Type) B.S.P.T.
3	39205	Ratchet Ring
4	39215	Drive Plate
5	39220	Jam Proof Drive Plate Assembly
6	39245	Head N.P.T.
	68060	Head B.S.P.T.
7	39290	Gauge Ring
8	39295	Tru-Center Workholder N.P.T.
	68070	Tru-Center Workholder B.S.P.T.
9	39300	65R Tru-Center Workholder Assy. N.P.T.
	68075	65R Tru-Center Workholder Assy. B.S.P.T.
10	39400	Change Plate N.P.T.
	68125	Change Plate B.S.P.T.
11	39450	Cam Plate
12	39370	Gauge Ring
13	39405	Throwout Plate
14	39425	Workholder Jaw (3 per set) (2 solid & 1 spring loaded)

Ref. No.	Catalog No.	Description
15	39485	Set Screw
16	39490	Compression Spring
17	39500	Locking Cam Pin
18	39505	Stop Pin
19	39545	Pipe Handle
20	39555	Locking Cam
21	39975	Change Plate Spring Ring
22	39980	Gauge Plate Spring Ring
23	39985	Clamp Screw
24	39990	Drive Plate Screw (4)
25	39995	Release Cam
26	39875	Pawl (2)
27	39880	Workholder Jaw (2)
28	39885	Release Cam Flat Spring (2)
29	39895	Release Cam Lever
30	39900	Pawl Spring (2)
31	39915	Coil Spring
32	39965	Cam Lever Pin