

819 and 1219 Nipple Chuck Instructions

WARNING



Read these instructions and the warnings and instructions for all equipment being used before operating this tool to reduce the risk of serious personal injury.

- **Do not wear gloves or loose clothing when operating.** Keep sleeves and jackets buttoned. Clothing can be caught by the pipe or tool resulting in entanglement.
- **Keep hands away from rotating pipe and parts.** Allow the machine to come to a complete stop before touching the pipe or tool. This reduces the risk of entanglement, crushing or striking injuries.
- **Remove wrench from Nipple Chuck before turning on the Threading Machine.** This reduces the risk of striking or crushing injuries.



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Description

RIDGID® 819 and 1219 Nipple Chucks are designed to hold short or close NPT nipples for threading.

The Model 819 Nipple Chuck is used with 2" capacity and larger threading machines, such as the 300 Power Drive, 300 Compact, 535, 1233 and 1224 Threading Machines. With the 839 Adapter kit, the 819 can be used with 535A and 1822 Threading Machines. The Model 1219 is used with 1215 Threading Machine.

The 819 is available in a BSPT configuration.

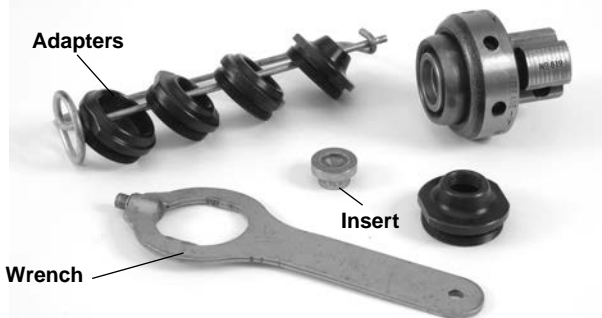


Figure 1 – 819 Nipple Chuck and Accessories

Inspection/Maintenance

Inspect the Nipple Chuck before each use for proper assembly, wear, damage or other issues that could affect safe use. Clean the chuck to aid inspection and improve control.

Lubricate the chuck as needed with a light general purpose lubricating oil. Clean excess oil from exposed surfaces.

Set Up and Operation

1. Make sure all equipment is inspected and set up per its instructions.
2. Following the instructions for the threading machine, ream and thread one end of the pipe and cut to the desired length.
3. Remove foot from the foot switch and move the threading machine switch to the OFF position. Do not use machine if the foot switch is broken or missing.

4. Fully open the threading machine chuck and remove pipe.
5. Insert the nipple chuck into the machine chuck. Align the grooves/flats in nipple chuck body with the machine chuck inserts. Securely close the machine chuck onto the nipple chuck.

If using 819 Nipple Chuck with the 535A or 1822 threading machines, assemble the 839 Adapter kit as per the instructions.

6. If needed, remove the thread adapter with the wrench. Do not operate the machine with the wrench installed, this increases the risk of striking or crushing injuries.

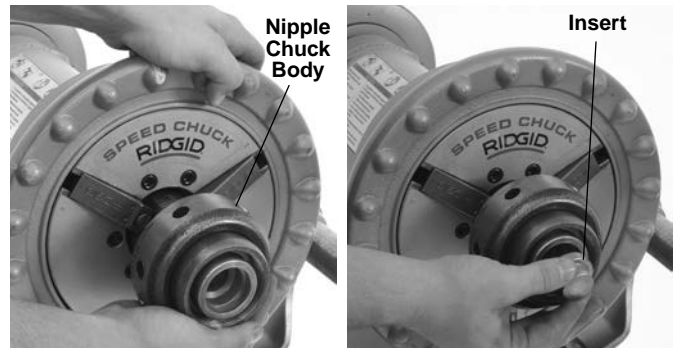


Figure 2 – Installing Nipple Chuck and Insert

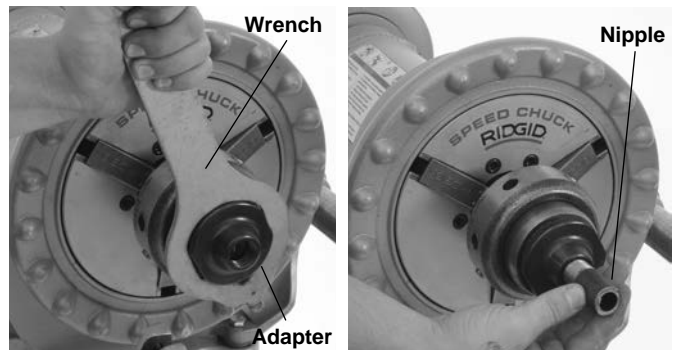
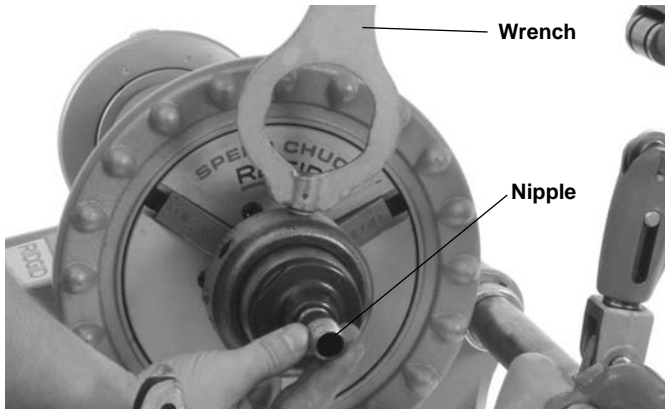


Figure 3 – Installing Nipple Chuck Adapter and Nipple

7. If needed, install the insert (Figure 2):
 - For 1¼" or larger pipe, the insert is not used.
 - For 1" pipe, install the insert into the nipple chuck with the large end out.
 - For ¾" or smaller pipe, install the insert with the small end out.
8. Install the proper size pipe adapter and tighten with the wrench (Figure 3). Remove wrench.
9. Screw the threaded end of the nipple into the pipe adapter by hand until the pipe end stops against the insert. If this does not happen, the thread is oversized and may jam in the adapter.
10. Following the instructions for the threading machine used, ream and thread the nipple. Watch closely for any interference between parts – if needed, stop the machine by removing foot from the foot switch.
11. Remove foot from the foot switch and move the threading machine switch to OFF position.
12. Insert the wrench pin into one of the holes on body of the nipple chuck. Turn the wrench to release the finished nipple and unscrew from the adapter. See Figure 4. Remove wrench.


Figure 4 – Removing Nipple
Accessories

Catalog No.	Model No.	Description
35867	839	Adapter Kit for 535A/1822 Machine
51020	D-380-X	Nipple Chuck Wrench
51035		Insert

Pipe Adapters

Size (Inch)	NPT Standard		BSPT Standard	
	Catalog No.	Model No.	Catalog No.	Model No.
1/8	51040	E-729	–	–
1/4	51045	E-730	68195	E-730-B
3/8	51050	E-731	68200	E-731-B
1/2	51055	E-732	68165	E-732-B
3/4	51060	E-733	68170	E-733-B
1	51065	E-734	68175	E-734-B
1 1/4	51070	E-735	68180	E-735-B
1 1/2	51075	E-736	68185	E-736-B



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