Self-Opening Die Head Instructions

⚠ WARNING

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

- **Do not wear gloves, loose clothing, or jewelry when operating machine.** 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.

If you have any question concerning this RIDGID® product:

– Contact your local RIDGID distributor.
– Visit www.RIDGID.com or www.RIDGID.eu to find your local RIDGID contact point.
– Contact Ridge Tool Technical Service Department at rtctechservices@emerson.com, or in the U.S. and Canada call (800) 519-3456.

Description

RIDGID® Self-Opening Die Heads can be automatically opened for 1/2" through 2" pipe size, and include the following models.

Model	RH/LH	Dies	Capacity		Machines Used
			Pipe	Bolt	
815A NPT	RH	Univ.	1/8" – 2"	1/4" – 2"	*
815A BSPT	RH	Univ.	1/8" – 2"	1/4" – 2"	*
711 NPT	RH	Univ.	1/4" – 2"	–	1224
911 BSPT	RH	Univ.	1/4" – 2"	–	1224

* 1215, 1233, 535, 535A, 300 Compact Machines and 300 Power Drive

A trigger is used to open the diehead when the NPT or BSPT thread is complete. For 1/8" to 3/8" sizes or if cutting bolt or straight threads, the die head is manually opened when the thread is complete.

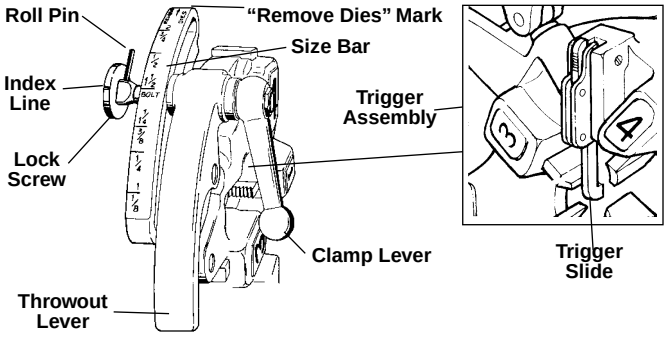

Figure 1 – Self-Opening Die Head

Inspection/Maintenance

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

Inspect the cutting edges of the dies. Dull or damaged cutting tools increase required force, produce poor quality threads and increase the risk of injury. If any problems are found, do not use until corrected.

Set-Up/Operation

Make sure all equipment is inspected and set up per its instructions.

Always cut a test thread to confirm proper thread size after changing/adjusting the dies.

Inserting/Changing the Dies

Die Heads require one set of dies for each of the following pipe size ranges: (1/8"), (1/4" and 3/8"), (1/2" and 3/4") and (1" through 2"). NPT/NPSM dies must be used in NPT die heads and BSPT/BSPP dies must be used in BSPT die heads – The size bar is marked for each.

Bolt threading requires specific dies for each bolt size.

See the RIDGID catalog for Dies available for your die head.

1. Place the die head with numbers facing up.
2. Make sure the trigger assembly is released and die head OPEN by pulling the trigger slide away from the die head. Stay clear of the spring loaded Throwout Lever while releasing trigger assembly.

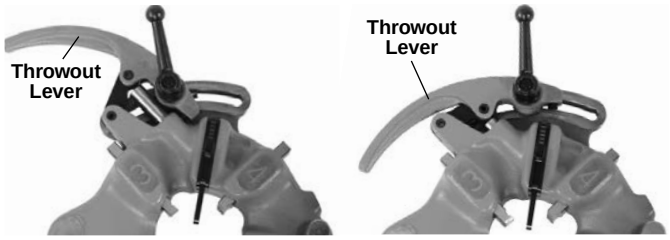

Figure 2 – Open/Closed Position

3. Loosen clamp lever approximately six full turns.
4. Pull lock screw out of size bar slot so roll pin will bypass slot. Position size bar so that the index line on lock screw is aligned with the REMOVE DIES mark.
5. Remove dies from the die head.
6. Insert appropriate dies into the die head, numbered edge up until the indicator line is flush with the edge of the diehead *(see Figure 3)*. Numbers on the dies must correspond with those on the die head slots. Always change dies as sets – do not mix dies from different sets.

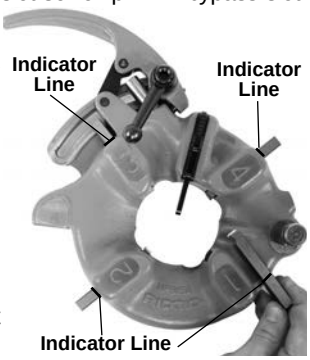

Figure 3 – Inserting Dies

7. Move size bar so index line on lock screw is aligned with desired size mark. Adjust die insertion as needed to allow movement.
8. Make sure roll pin points toward REMOVE DIES mark.
9. Tighten the clamp lever.

Adjusting Thread Size

1. Install the die head per the *Threading Machine Instructions* and move the die head into threading position.
2. Loosen clamp lever.
3. Postion size bar so index line on lock screw is aligned with desired size mark on size bar.
4. If thread size needs to be adjusted, set the lockscrew index line slightly off the mark on size bar in the direction of OVER (larger diameter thread, less turns of fitting engagement) or UNDER (smaller thread diameter, more turns of fitting engagement) markings.
5. Tighten clamp lever.

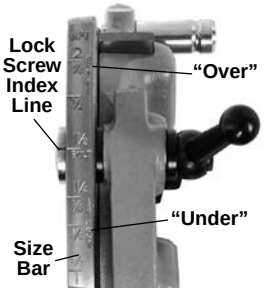

Figure 4 – Adjusting Thread Size

Trigger Slide Adjustment

Position the Trigger Slide for the size of pipe being threaded *(see Figure 5)*.

- 1/2" and 3/4" – End of pipe should hit foot of Trigger Slide.
- 1" to 2" – End of pipe should hit the shank of the Trigger Slide.

For

- 1/8", 1/4" and 3/8" pipe
- Longer or shorter threads
- Bolt threading

Die head must be opened manually. Push trigger slide up and out of the way.

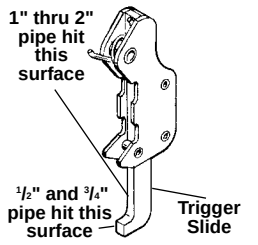

Figure 5 – Setting the Trigger

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Threading

Install the die head per the *Threading Machine Instructions*. Move the die head into threading position. Move the throwout lever to CLOSE position.

Following the *instructions for the Threading Machine*, thread the stock.

Opening the Die head at the End of the Thread

When using trigger it will contact the end of pipe, causing the die head to automatically open. Stay clear of the spring loaded Throwout Lever when it releases.

To open the die head manually (with trigger slide up), at the end of the thread:

- Tapered Pipe Threads – End of pipe is flush with the end of the number 1 die.
- Bolt and Straight Threads – Thread the desired length – watch closely for any interference between the parts.

Move the throwout lever to the OPEN position, retracting dies. Do not run machine in reverse (REV) with dies engaged.

Turn machine OFF per the instructions.

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