

Semi-Automatic 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 rttechservices@emerson.com, or in the U.S. and Canada call (800) 519-3456.

Description

The RIDGID® Universal Semi-Automatic Die Heads include Model 816 NPT and 817 NPT Die Heads. These die heads can be quickly adjusted from size to size and are manually opened for user specified thread length. The die heads operate with a system of four Position Blocks on the cam plate. Each block can be adjusted and set independently, allowing the operator to change sizes quickly and accurately.

The 816 Die Head is for 1/8" to 3/4" and 817 die head is for 1" to 2" size range. Both use RIDGID Universal dies.

The Semi-Automatic Die Heads can be used on RIDGID equipment such as the 1215, 1233 535, 535A, 300 Compact Threading Machines and 300 Power Drive.

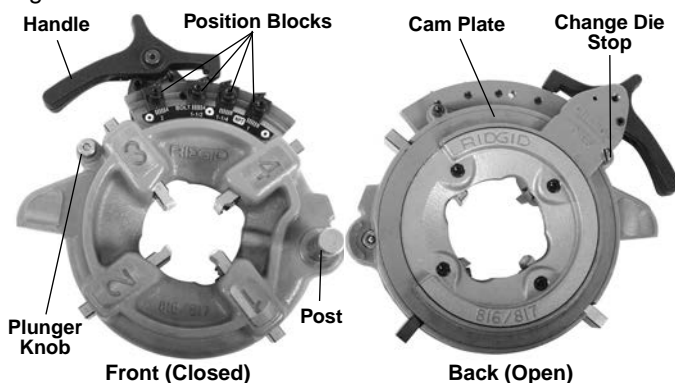


Figure 1 – Semi-Automatic Die Head

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"). Die heads cannot be used for BSPT threads.

See the *RIDGID catalog* for dies available for your die head.

1. Place the die head with numbers facing up.
2. Depress handle so that cam plate rests against the change die stop (*Figure 1*). The cam plate/handle assembly is spring loaded and will move when depressed.
3. Pull the plunger knob and rotate the handle and cam plate counter-clockwise until it stops.
4. Remove dies from the die head.
5. Insert appropriate dies into the die head, numbered edge up until the indicator line is flush with the edge of the diehead (*see Figure 2*). 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.

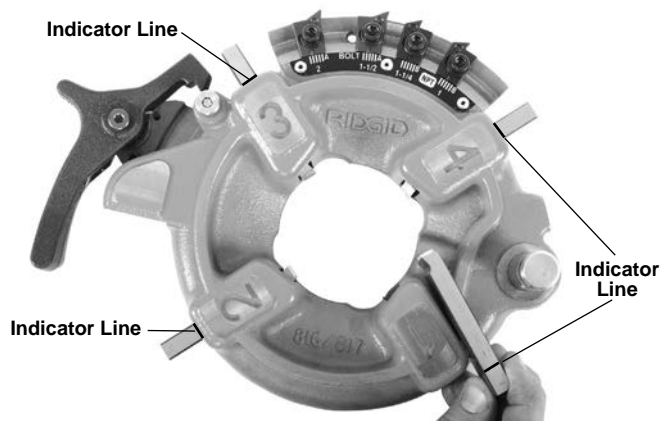


Figure 2 – Inserting Dies

6. Move the handle clockwise so that the plunger knob is flush against the die head. Adjust die insertion as needed to allow movement.

Adjusting Thread Size

1. Install the die head per the *Threading Machine Instructions* and move the die head into threading position.
2. Loosen the screw for the position block for desired pipe size.
3. Start with the position block index line on the middle size bar mark.

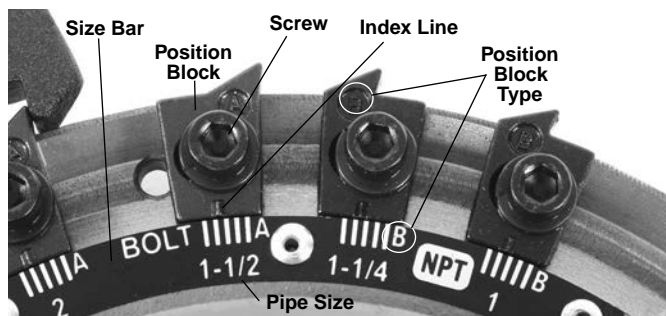


Figure 3 – Adjusting Thread Size

4. If thread size needs to be adjusted, set the index line slightly off the mark on size bar in the direction of the handle for larger diameter thread, (less turns of fitting engagement) or away from handle for smaller thread diameter (more turns of fitting engagement).

5. Securely tighten the position block screw.
6. Always make sure position block type matches (*Figure 3*).

Threading

Install the die head per the *Threading Machine Instructions*. Move the die head into threading position. Hook the handle over the appropriate position block to close.

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

Opening the Die Head at the end of the Thread

When the end of the pipe is flush with the end of the number 1 die, press the handle to open die head and retract the dies. Do not run machine in reverse (REV) with dies engaged.

Turn machine OFF per the instructions.

For inspecting threads, refer to the *Threading Machine Operator's Manual*.



99 Washington Street
Melrose, MA 02176
Phone 781-665-1400
Toll Free 1-800-517-8431



Visit us at www.TestEquipmentDepot.com