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RIDGID 1224 Pipe and Bolt Threading Machine

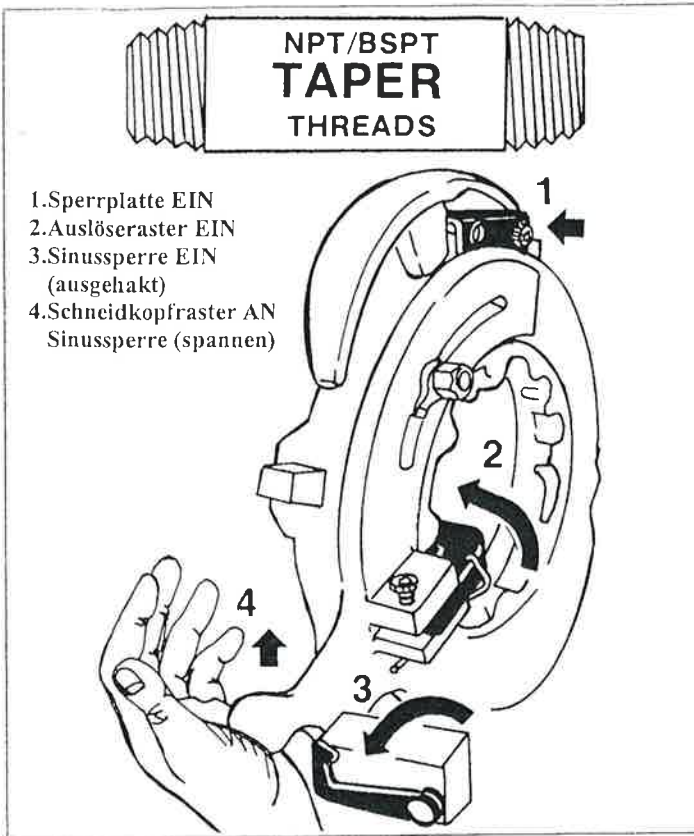


Figure 10 – Setting No. 714 or 914 Self-Opening Die Head for NPT or BSPT Threads

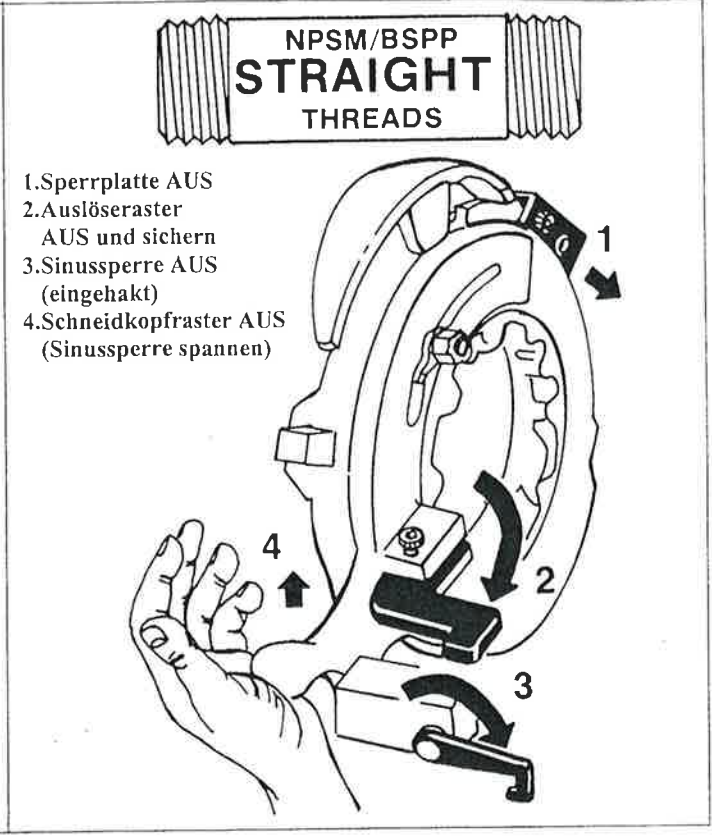


Figure 11 – Setting No. 714 or 914 Self-Opening Die Head for NPSM or BSPP Threads

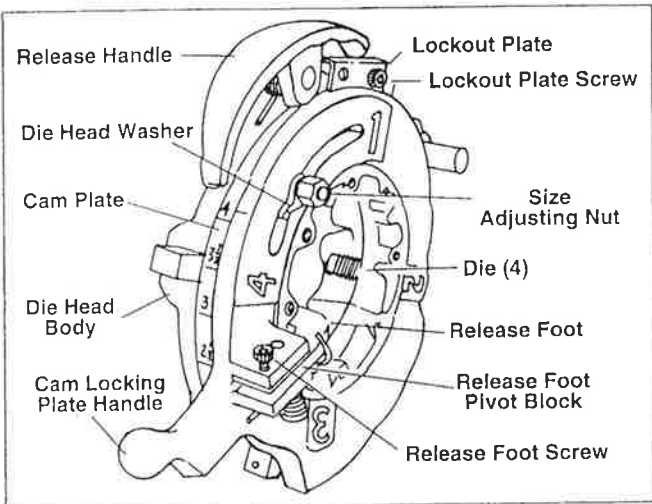


Figure 12 – Know Your 714/914 Die Head

Threading Pipe with Nos. 714 and 914 Self-Opening Die Head (NPT/BSPT)

1. Install die set. Refer to Die Installation procedure.
2. Swing cutter and reamer to UP position.
3. Position lockout plate IN. (Figures 10 & 13)
4. Release foot IN. (Figure 10)

5. Sine Bar should be IN (UNLATCHED). (Figures 10 & 13)

6. With die head in DOWN position, push UP on cam locking plate handle (Figure 10, step 4) until release foot latches in die head body.

7. Shift Knob MUST be in 12 RPM position.

NOTE! Shift Knob is in 36 RPM position when threading 2" pipe or less. When threading 2 1/2" to 4" pipe, shift knob must be in 12 RPM position.

CAUTION

Shifting should be done with machine idling. DO NOT operate shift knob while under load.

8. Turn REV/OFF/FOR switch to FOR position and step on foot switch.

9. Turn carriage handwheel counter-clockwise to bring die head against end of pipe in one continuous motion. The release foot will actuate the receding mechanism. Continue to apply pressure to handwheel to start dies.

NOTE! Carriage handwheel may be repositioned to improve leverage when starting dies. To reposition: pull handwheel out (away from machine), rotate handwheel to desired position, push handwheel in.