

Clear any swarf from the die head and cutters before cutting the next thread.

EQUIPMENT CARE

Never push the equipment beyond its design limits. If it will not do what you want with reasonable ease, assume you have the wrong tool for the job. Ask at your local HSS Hire Shop for advice.

Keep the equipment clean. You will find this less of a chore if you clean up regularly, rather than wait until the end of the hire period.

When not in use, store the equipment somewhere clean, dry, and safe from thieves.

Keep the dies well lubricated with cutting oil on each job. Failure to use the correct type and quantity of oil will damage both the cutters and the pipe.

Use only die sets supplied by HSS Hire Shops. Anything else may damage the equipment and your pipe.

FINISHING OFF

Remove the die head and undo the two handles, and give everything a final clean.

Place everything back in to the carry case, ready for return to your local HSS Hire Shop.



...any comments?

If you have any suggestions to enable us to improve the information within this guide please fax your comments or write to the Product Manager at the address below

Fax: 0181-687 5001

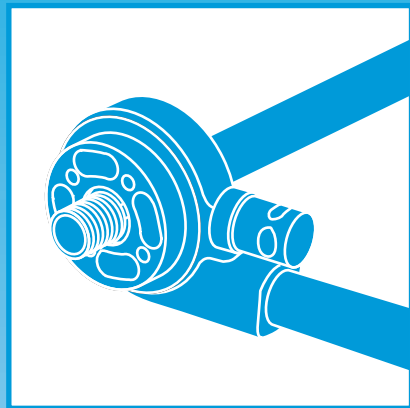
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Operating & Safety Guide 752

HSS Hire Shops



Ratchet Die Stock and Conduit Threader

A manual Threader for BSP pipe up to 2" or conduit up to 32mm.



Code 68410 / 68450

GENERAL SAFETY

For advice on the safety and suitability of this equipment contact your local HSS Hire Shop.

This equipment has been designed to be used by an able bodied adult. If you suffer from either a temporary or permanent disability, you must seek expert advice before using this equipment.

Keep children, animals and bystanders away from the work area.



Never use this equipment if you are ill, feeling tired, or under the influence of alcohol or drugs.

This equipment should only be used by a competent person who has read and understood these instructions.



Safety Goggles **MUST** be worn by everyone in the work area.



Wear practical, protective clothing, gloves and footwear. Avoid loose garments and jewellery that could catch in moving parts, tie back long hair.

Ensure the work area is well lit and ventilated.

Avoid contact with the die head, the threaded surfaces and any swarf, immediately after threading as high temperatures are generated by the threading process.

When working, adopt a stable, well-balanced stance that lets you see what you are doing while leaving your hands and body behind the cutting edge at all times.

Take care when handling or fitting dies – they are sharp.

Check the condition of the equipment before use. If it shows signs of damage or excessive wear, return it to your local HSS Hire Shop.

COSHH Information sheets are available from your local HSS Hire Shop.

GETTING STARTED

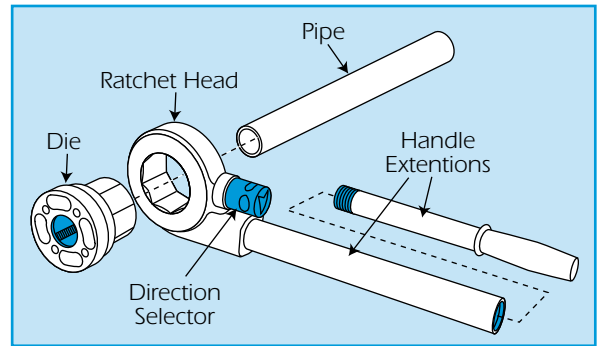
BSP pipe threading...

This unit can be used on black iron or galvanised pipework which is in situ or on loose pipes. If the pipe is loose it must be held securely in either a pipe stand and vice or a bench mounted vice.

BSP & Conduit...

Where appropriate, you should grip the work in a suitable vice, making sure that there is enough pipe exposed for the die head.

Unpack the ratchet head and the two handle extensions. Fit the handles together then to the ratchet head.



CHANGING DIES

HSS Ratchet Die Stocks and Conduit Threaders come with a full set of die heads to cover either pipes from 1/2" to 2", or conduit up to 32mm. Choose the set which corresponds to the size of the pipe/conduit being worked on.

To fit the die head to the ratchet head, select the size die you need and push it into the left side of the ratchet head.

When removing any previously fitted die head, return it to the box. Treat them with great care as the cutters are fragile.

BASIC TECHNIQUES

Check that the pipe end is cut square and is free of burrs. Pipe cutters and die grinders are available for hire from your local HSS Hire Shop.

Now slot the die head over the end of the pipe/conduit until the dies cutters are in line with the end of the pipe/conduit.

To select the direction of rotation, pull then turn the selector 180 degrees and release. The arrow in the selector should point down to thread and up for reverse and to remove the die from the pipe.

Which ever you are using...

With the die located over the pipe/conduit, place a small quantity of cutting oil (available from your local HSS Hire Shop) onto the die head through one of its slots.

Ensure the direction of rotation is set for threading, then placing firm pressure on the handle begin threading.

Move the die 1/4 turn at a time to keep the work cool, avoid long cuts as this will increase the heat.

Keep a watchful eye on the pipe/conduit as this must not move during the work. If it does, STOP and re-tighten.

To remove the die from the pipe simply select reverse, move the handle in the opposite direction and be ready to remove the unit once it is clear of the thread.