

There are 2 sizes of die body, small and standard. The standard size fits directly into the drive unit. However, an adapter has to be fitted to the drive unit if the smaller sizes are to be used (see illustration).

If required fit the adapter first, simply slot it into the drive unit. The Ridgid version simply slots in where as the Rothenberger version must be retained with the large ring nut.

If the adapter is fitted but not required, simply remove by reversing the fitting instructions.

You can now fit the die to the drive unit, select the size die you need and push it into the left side of the drive unit.

Where the adapter is fitted to the Rothenberger model, turn the adapters lock collar clockwise to allow the die head to enter then release the collar. To remove simply reverse this instruction.

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

BASIC TECHNIQUES

Rothenberger model...

To switch the machine ON slide the ON/OFF thumb lever forward until it clicks in position. To switch it OFF push down on the tail of the switch and it will spring back to OFF.

To select the direction of rotation, move the selector clockwise to thread and anti-clockwise for reverse and to remove the die from the pipe. Direction of rotation must only be changed with the machine switched OFF.

Ridgid model...

To switch the machine ON push the trigger lock button forward then squeeze and hold the ON/OFF trigger. To switch it OFF simply release the trigger.

To select the direction of rotation, move the selector button to the left (revealing a solid arrow) to thread and move the selector button to the right (revealing a dotted arrow) for reverse and to remove the die from the pipe. Direction of rotation selection must only be changed with the machine switched OFF.

Whichever you are using...

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 stock onto the clamp's spindle, and the die over the end of the pipe until the dies cutters are in line with the end of the pipe.

Plug the unit into its power supply and switch the supply ON.

With the die stock located over the pipe and the vices bar, 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 switch the unit ON. Allow the machine to work at its own pace and once the thread is complete switch the machine OFF.

Keep a watchful eye on the vice as this must not move during the work. If it does, STOP and re-tighten. Never use the threader without the vice as serious personal injury may occur.

To remove the die from the pipe simply select reverse, switch ON and be ready to remove the unit once it is clear of the thread.

Clear any swarf from the die head and cutters before cutting the next thread. Release the integral vice ready for 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

Switch OFF and unplug the machine.

Remove the die head and (if fitted) the adapter, placing them back in to the carry case.

Give the machine a final clean, neatly coil its power supply cable and place it in its box ready for return to your local HSS Hire Shop.

Operating & Safety Guide 753

HSS Hire Shops



Electric Die Stock

A powerful, pipe threader for use in tight corners or where a Pipe Threader is impractical.



...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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Group Office: 25 Willow Lane, Mitcham, Surrey CR4 4TS

Web Site: <http://www.hss.co.uk>



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GENERAL SAFETY

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

There is a serious risk of personal injury if you do not follow all instructions laid down in this guide.

This equipment should be used by an able bodied, competent adult who has read and understood these instructions. Anyone with either a temporary or permanent disability, should seek expert advice before using it.

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.

 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.

Do not work near flammable gases or liquids, petrol or paint thinner fumes for example. Keep combustible materials at a safe distance- at least 5m.

Make sure you know how to switch this machine OFF before you switch it ON in case you get into difficulty.

Always switch OFF and unplug the tool prior to cleaning, checking or changing dies.

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

Never carry, lift or pull the equipment by its power supply cable.

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.

ELECTRICAL SAFETY

HSS Electric Die Stocks need a 110V power supply, obtainable from a 110V generator or from the mains via a suitable transformer. Never connect 110V units directly to the 240V mains electricity supply.

If the equipment fails, or if its flex or plug becomes damaged, return it. Never try to repair it yourself.

Keep flexes out of harm's way, and clear of the work area.

Extension leads should be fully unwound and loosely coiled, away from the equipment. Never run them through water, over sharp edges or where they could trip someone.

Keep the equipment dry, using electrical equipment in very damp or wet conditions can be dangerous.

 To reduce the risk of electric shock, use a suitable RCD (Residual Current-Operated Device) available from your local HSS Hire Shop.

Ensure the Electric Die Stock and power socket are switched OFF before plugging into the power supply.

GETTING STARTED

This unit can be used on 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.

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

Clamp the Electric Die Stock integral vice to the pipe. Open its lock jaw, slide it onto the pipe and secure in place with the end of the support bar in line with the end of the pipe.

Manoeuvre the vice so that it sits square on the pipe with the support bar level with the top of the pipe. Ensure the clamp is secure and fully tightened.

CHANGING DIES

HSS Electric Die Stocks come with a full set of dies to cover pipes from 1/2" to 2". Chose the set which corresponds to the internal diameter of the pipe being worked on.

