

# RIDGID Quick-Opening Die Head Instruction Sheet

## Quick-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](http://www.RIDGID.com) or [www.RIDGID.eu](http://www.RIDGID.eu) to find your local RIDGID contact point.
- Contact Ridge Tool Technical Service Department at [rttech-services@emerson.com](mailto:rttech-services@emerson.com), or in the U.S. and Canada call (800) 519-3456.

### Description

RIDGID® Quick-Opening Die Heads are manually opened and closed for user specified thread length, and include the following models.

Model	RH/LH	Dies	Capacity		Machines Used
			Pipe	Bolt	
811A NPT/BSPT	RH	Univ.	1/8" – 2"	1/4" – 2"	*
842 NPT	LH	Univ.	1/8" – 2"	–	*
531 Bolt	RH /LH	Bolt	–	1/4" – 1"	*
532 Bolt	RH /LH	Bolt	–	1 1/8" – 2"	*
500A	RH	Mono	Specific	–	*
555	RH	Dual/Bolt	1/8" – 3/4"	–	*
713 NPT	LH	Univ.	1/4" – 2"	–	1224
913 BSPT	LH	Univ.	1/4" – 2"	–	1224
541 Bolt	RH /LH	Bolt	–	1/4" – 1"	1224
542 Bolt	RH /LH	Bolt	–	1 1/8" – 2"	1224

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

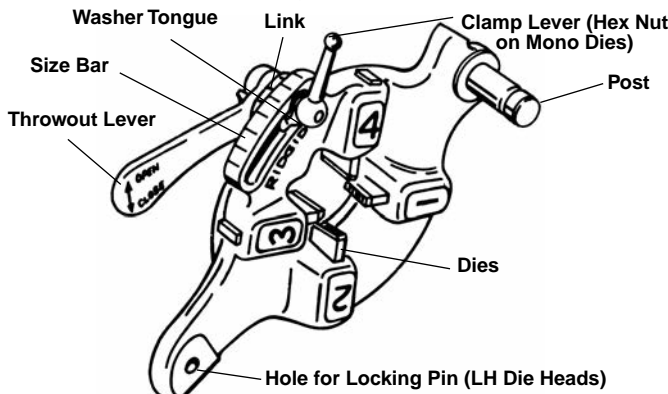


Figure 1 – Quick-Opening Die Head

### 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 and 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 using Universal Dies for pipe 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.

Die heads using Mono or Bolt dies require a dedicated set of dies for each specific thread size.

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

1. Place the die head with numbers facing up.
2. Move throwout lever to OPEN position (*Figure 2*).

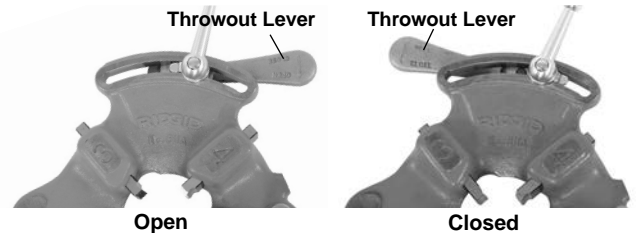


Figure 2 – Open/Closed Lever Position

3. Loosen clamp lever (Hex nut on Mono die heads) approximately three turns.
4. Lift tongue of washer out of slot in size bar. Move washer to end of slot (*Figure 3*).
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 die head (*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.
7. Move link index mark to align with desired size mark on size bar. Adjust die insertion as needed to allow movement. Washer tongue should be in slot to left.
8. Tighten clamp lever (Hex nut on Mono die heads).

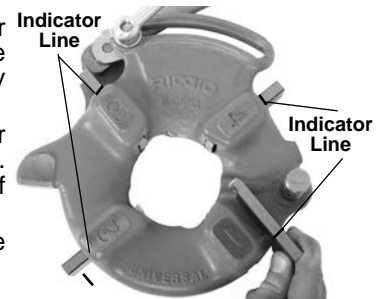


Figure 3 – Inserting Dies

### 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 (Hex nut on Mono die heads).
3. Start with link index mark aligned with desired size mark on size bar. On Mono and Bolt die heads, set link mark at line in size bar. For bolt threads with Universal die head, set all bolt dies at BOLT line on size bar.
4. If thread size needs to be adjusted, set the link index mark slightly off the mark on size bar in the direction of OVER (larger diameter thread, less turns of fitting engagement) or

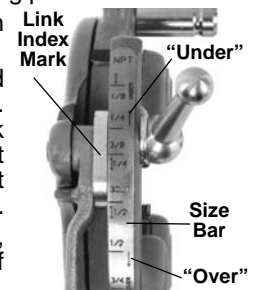


Figure 4 – Adjusting Thread Size

UNDER (smaller thread diameter, more turns of fitting engagement) markings.

5. Tighten clamp lever.

### **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**

At the end of the thread:

- 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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