Saved from manuals.plus.
Open the live page for links to other documents and user manuals.

RIDGID 66655

RIDGID 66655 Universal 1/8 BSPT Threading Dies Instruction Manual

Model: 66655

1. Introduction

This manual provides essential information for the safe and effective use of the RIDGID 66655 Universal 1/8 BSPT Threading Dies. These dies are designed for creating precise British Standard Pipe Taper (BSPT) threads on various pipe materials when used with a compatible RIDGID die head and threading machine or hand tool. Proper understanding and adherence to these instructions will ensure optimal performance and longevity of the product.

2. Safety Information

Always prioritize safety when operating any tools. Failure to follow these safety guidelines may result in injury or damage to the equipment.

- **Wear Eye Protection:** Always wear ANSI-approved safety glasses or goggles to protect against flying debris.
- **Read All Instructions:** Before use, thoroughly read and understand all instructions provided with the dies, die head, and threading machine.
- **Use Correct Dies:** Ensure the correct type and size of dies are selected for the material and thread specification required.
- **Secure Workpiece:** Always securely clamp the pipe or workpiece to prevent rotation during threading.
- **Use Cutting Oil:** Apply ample high-quality cutting oil during the threading process to reduce friction, dissipate heat, and ensure clean threads.
- **Keep Hands Clear:** Maintain a safe distance from moving parts during operation.
- **Inspect Dies:** Before each use, inspect dies for damage, wear, or dullness. Replace worn or damaged dies immediately.

3. Product Overview

The RIDGID 66655 dies are a set of four individual chasers designed to be inserted into a universal die head. These chasers work in unison to cut precise 1/8 inch British Standard Pipe Taper (BSPT) threads.



An image showing the RIDGID 66655 Universal 1/8 BSPT threading dies. The dies are made of durable metal, featuring precision-cut teeth designed for creating accurate British Standard Pipe Taper threads. The brand name 'RIDGID UNIVERSAL' is engraved on the top surface of one of the die segments.

4. Setup

Proper installation of the dies into the die head is crucial for accurate threading.

1. **Select Correct Dies:** Ensure you have the RIDGID 66655 1/8 BSPT dies.
2. **Clean Die Head:** Before inserting, ensure the die head slots are clean and free of debris or metal shavings.
3. **Insert Dies:** Carefully slide each die into its corresponding slot in the universal die head. The dies are typically numbered or marked to indicate their correct position. Ensure they are seated fully and correctly.

4. **Secure Dies:** Depending on your die head model, ensure the dies are properly secured, usually by a retaining ring or mechanism. Refer to your specific die head's manual for detailed instructions.
5. **Inspect Assembly:** Verify that all dies are correctly installed, aligned, and securely held in place before proceeding.

5. Operating Instructions

Follow these steps for effective pipe threading:

1. **Prepare the Pipe:**
    - Cut the pipe to the desired length, ensuring a clean, square cut.
    - Ream the inside of the pipe to remove any burrs that could obstruct flow or damage the die.
    - Chamfer the outside edge of the pipe to facilitate easier starting of the die.
2. **Secure the Pipe:** Firmly clamp the pipe in a pipe vise or the chuck of a threading machine. The pipe must not rotate during threading.
3. **Apply Cutting Oil:** Liberally apply high-quality threading oil to the end of the pipe where the thread will be cut. Continue to apply oil throughout the entire threading process. This cools the dies, lubricates the cutting action, and flushes away chips.
4. **Start the Thread:**
    - Position the die head squarely onto the end of the pipe.
    - Apply firm, steady pressure while rotating the die head clockwise (for right-hand threads). The dies will begin to engage the pipe.
5. **Thread the Pipe:** Once the dies have started, maintain consistent rotation and continuous oil flow. Continue threading until the desired thread length is achieved. For BSPT threads, this typically means the pipe end is flush with the face of the dies, or as specified by your application.
6. **Remove the Die Head:** Once threading is complete, reverse the rotation of the die head to back it off the newly cut thread. Clean any metal shavings from the pipe and the die head.

6. Maintenance

Regular maintenance extends the life of your threading dies and ensures consistent performance.

- **Cleaning:** After each use, remove the dies from the die head and thoroughly clean them. Use a stiff brush to remove all metal chips and residue. Compressed air can also be used, but wear eye protection.
- **Lubrication:** Lightly coat the dies with a thin layer of threading oil or rust preventative before storage to prevent corrosion.
- **Inspection:** Periodically inspect the cutting edges of the dies for signs of wear, chipping, or dullness. Dull dies will produce poor quality threads and require excessive force. Replace worn dies promptly.
- **Storage:** Store dies in a clean, dry environment, preferably in their original packaging or a dedicated die case, to protect them from damage and corrosion.

7. Troubleshooting

Addressing common issues can help maintain efficient operation.

Problem	Possible Cause	Solution

Problem	Possible Cause	Solution
Poor quality or rough threads	Dull or damaged dies; insufficient cutting oil; incorrect pipe preparation; incorrect threading speed.	Replace dies; apply more cutting oil; properly ream and chamfer pipe; adjust threading speed.
Difficulty starting thread	Pipe not chamfered; dies not properly aligned; excessive pressure.	Chamfer pipe end; ensure dies are correctly installed and aligned; apply steady, not excessive, pressure.
Excessive die wear or breakage	Lack of cutting oil; threading hard materials without appropriate dies; forcing dull dies.	Use ample cutting oil; ensure dies are suitable for material; replace dull dies.
Chips clogging dies	Insufficient cutting oil; improper chip clearance.	Increase cutting oil flow; clean dies regularly.

8. Specifications

Feature	Specification
Brand	RIDGID
Model Number	66655
Thread Type	1/8 inch BSPT (British Standard Pipe Taper)
Item Dimensions (L x W x H)	9 x 5 x 0.6 inches (for the set)
Number of Pieces	1 (referring to one set of four chasers)
Material	High-grade Steel
UPC	095691666550

9. Warranty and Support

RIDGID products are known for their quality and durability. For specific warranty information regarding your RIDGID 66655 dies, please refer to the official RIDGID website or the warranty documentation included with your original purchase. For technical support, replacement parts, or service inquiries, please contact RIDGID customer service directly through their official channels.

RIDGID Official Website: www.ridgid.com

© 2023 RIDGID. All rights reserved. Information subject to change without notice.

Ask a question about this manual

Ask about setup, troubleshooting, compatibility, parts, safety, or missing instructions. Manuals+ will review the question

and use this page's manual context to help answer it.

Name

Anonymous

Email

you@example.com

After a successful submission, we securely hash the supplied account or form email before sending it to Microsoft Advertising for conversion attribution. Privacy details.

Question

Example: How do I reset this device or fix this error?

Details

Model number, symptoms, what you tried, or the section of the manual you are using.

Submit question

Open the live page

https://manuals.plus/asin/B0042T7XFU

More documents and user manuals: **https://manuals.plus/**