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## Richfar Tools 97065

# Instruction Manual

### Richfar Tools 811A Quick-Opening Universal Die Head

Model: 97065 | ASIN: B00KNNVV7K

## Product Overview

The Richfar Tools 811A Quick-Opening Universal Die Head is a high-quality replacement part designed for compatibility with various Ridgid threading machines. This die head is engineered for efficient and precise pipe and bolt threading operations.

- BRAND NEW No. 811A Quick-Opening Universal Die Head, Right Hand, NPT, it is 100% the compatible with Ridgid 97065.
- Exactly the same size and specification as Ridgid 97065, No. 811A Quick-Opening Universal Die Head Universal Die head is right handed.
- Pipe capacity is 1/8 - 2 inch and Bolt capacity is 1/4 - 2 inch.
- Fits Ridgid Model 300, 300A, 500, 500A, 535, 535A, 800, 801, 802, and 1822 Machines.
- Dies are not included but are available separately.

## Setup

Before operating, ensure the die head is properly installed on your threading machine. Follow these steps for correct setup:

1. **Inspect the Die Head:** Upon unboxing, visually inspect the 811A die head for any signs of shipping damage. Ensure all components are intact.
2. **Install Dies:** If dies are not pre-installed, carefully insert the appropriate threading dies into the die head slots. Ensure they are seated correctly and secured according to your machine's instructions.
3. **Mount on Machine:** Align the die head with the spindle of your compatible Ridgid threading machine (e.g., Model 300, 535). Securely attach the die head following the machine's specific mounting procedure.
4. **Lubrication:** Apply a suitable cutting oil to the dies and the workpiece before beginning any threading operation. This reduces friction and extends die life.




Image: The Richfar Tools 811A Quick-Opening Universal Die Head, shown new in its cardboard packaging. This view highlights the top of the die head, including the quick-opening lever and the die slots.




Image: The Richfar Tools 811A Quick-Opening Universal Die Head, also new in its packaging, but from a slightly different angle. This view provides a clearer look at the front face of the die head, showing the markings for pipe capacity and the mechanism for opening and closing the dies.

## Operating Instructions

The 811A die head is designed for efficient threading. Always refer to your specific threading machine's manual for detailed operation procedures.

1. **Prepare Workpiece:** Cut the pipe or bolt to the desired length and ream the inside edge to remove burrs.
2. **Secure Workpiece:** Clamp the pipe or bolt securely in the threading machine's vise.
3. **Engage Die Head:** Position the die head against the end of the workpiece. Ensure the quick-opening lever is in the "closed" or "engaged" position to allow the dies to cut.
4. **Start Threading:** Activate the threading machine. The die head will begin to cut threads onto the workpiece. Continuously apply cutting oil during the threading process.
5. **Monitor Progress:** Observe the threading process. The quick-opening feature allows for rapid disengagement once the desired thread length is achieved.
6. **Disengage:** Once threading is complete, move the quick-opening lever to the "open" position. This retracts the dies, allowing the die head to be easily removed from the newly threaded workpiece without reversing the machine.
7. **Clean Workpiece:** Remove any metal shavings and excess oil from the threaded part.

## Maintenance

Proper maintenance ensures the longevity and performance of your 811A die head.

- **Cleaning:** After each use, clean the die head thoroughly to remove all metal chips and cutting oil residue. Use a brush and a suitable cleaning solution if necessary.
- **Die Inspection:** Regularly inspect the threading dies for wear, chips, or damage. Worn dies will produce poor quality threads and should be replaced.
- **Lubrication:** Periodically apply a light machine oil to the moving parts of the die head, especially the quick-opening mechanism, to ensure smooth operation.
- **Storage:** Store the die head in a clean, dry place to prevent rust and corrosion. The original packaging or a dedicated storage case is recommended.

## Troubleshooting

| Problem | Possible Cause | Solution |
|---|---|---|
| Poor thread quality (rough, incomplete) | Worn or dull dies; insufficient cutting oil; incorrect die installation. | Replace dies; ensure adequate cutting oil flow; re-install dies correctly. |
| Die head not engaging/cutting | Quick-opening lever in "open" position; incorrect die size for workpiece. | Ensure lever is in "closed" position; verify correct die size. |
| Excessive friction/heat during threading | Lack of cutting oil; dull dies. | Apply more cutting oil; replace dies if worn. |

## Specifications

| Attribute | Detail |
|---|---|
| Model Number | 97065 (Compatible with Ridgid 97065) |
| Type | Quick-Opening Universal Die Head |
| Handing | Right Hand |
| Thread Type | NPT (National Pipe Taper) |
| Pipe Capacity | 1/8 - 2 inch |
| Bolt Capacity | 1/4 - 2 inch |
| Compatible Machines | Ridgid Model 300, 300A, 500, 500A, 535, 535A, 800, 801, 802, 1822 |
| Item Weight | 12.32 pounds |
| Manufacturer | Richfar Tools |

## Warranty and Support

For specific warranty information or technical support regarding your Richfar Tools 811A Die Head, please contact the seller or manufacturer directly. Refer to your purchase documentation for contact details.

Protection plans may be available for purchase separately. Please check with your retailer for options such as 3-Year or 4-Year Protection Plans.

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