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THREADER PIPE DIES

MODEL:811A

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VEVOR

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THREADER PIPE



This is the original instruction, please read all manual instructions carefully before operating. VEVOR reserves a clear interpretation of our user manual. The appearance of the product shall be subject to the product you received. Please forgive us that we won't inform you again if there are any technology or software updates on our product.



Warning-To reduce the risk of injury, user must read instructions manual carefully.

SAFETY INSTRUCTIONS

WARNING:

Read this material before using this product. Failure to do so can result in serious injury.

Assembly precautions

1. Assemble only according to these instructions. Improper assembly can create hazards.
2. In order to ensure your own safety, please make sure to ANSI-approved safety goggles and heavy-duty work gloves when installing this product.
3. Keep the assembly area clean and well lit.
4. Keep bystanders out of the area during assembly.
5. Do not assemble when tired or when under the influence of alcohol, drugs or medication.
6. Product capabilities apply to properly and completely assembled product only.
7. Assemble on a flat, level, hard and smooth surface capable of safely supporting a fully loaded Welding Curtain.

Use precautions

TO PREVENT SERIOUS INJURY AND DEATH FROM TIPPING:

1. DO NOT SIT OR STAND ON THIS ITEM.
2. This product is not a toy. Do not allow children to play with or near this item.
Please keep small spare parts out of children's reach.
3. Use only on a flat, level, hard and smooth surface capable of safely supporting a fully loaded Welding Curtain.

- 4. Use as intended only.
- 5. Inspect before every use; do not use if parts are loose or damaged.
- 6. Keep away from sharp points,blades and other items,so as not to scratch the product.

SPECIFICATIONS

Model	811A
Pipeline Capacity	1/8 - 2 inch
Bolt Capacity	1/4 - 2 inch
Models Supported	RIDGID 97065,Split-type VEVOR Pipe Puller

Usage Instructions

Installing the die:

Insert the corresponding die into the groove of the die head. When inserting the die, the following points must be noted: The dies are configured in sets, so they must be used as a complete set. When one die is damaged, the other three dies must be replaced simultaneously to avoid affecting the quality of thread chasing.

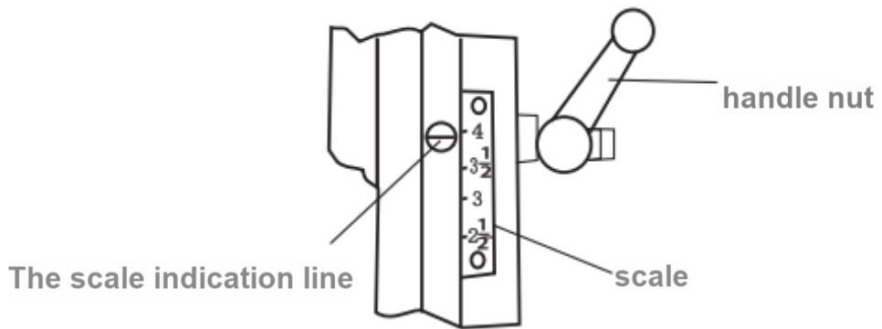
Note: When the die is inserted into the die groove to the correct depth, its locking notch will engage with the chuck locking key. Then, turn the curve disc, and the die can be correctly positioned.

Remove the die:

- 1. Loosen the handle nut of the die head, move it to the farthest end, and then tighten it slightly.
- 2. Move the profiling block on the right side until the roller of the die head comes into contact with the bottom plate (datum plane). At this point, the die can be taken out.

Precautions for Thread Chasing:

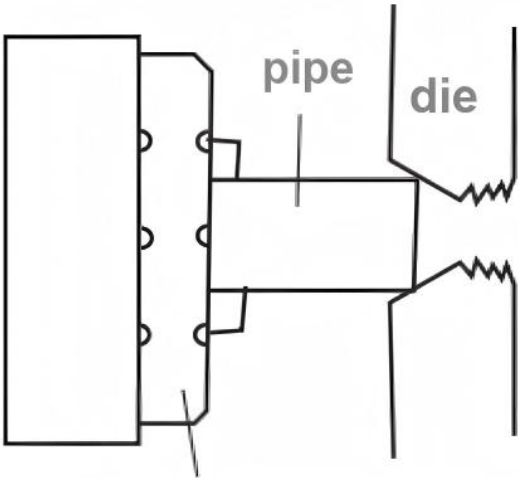
When the die comes into contact with the pipe, the force applied to rotate the carriage hand wheel should be gradually increased until the die bites into the pipe for 3 to 4 turns. If, after that, you can apply a little more force on the carriage handle to ensure that it moves synchronously with the die head, the best thread chasing quality can be achieved. The above threads must be chased in two steps.



Thread chasing:

1. Lift up the cutter frame and the chamfering frame to clear the position. Lower the opening die head to make it contact the profiling block (inclined block). When the die head is reliably positioned, press the button to start the machine.
2. The pipe must be rotated counterclockwise, and then turn the carriage hand wheel to make the die head approach the pipe. Before starting thread chasing, the amount of cooling lubricating oil must be adjusted first (you can rotate the oil volume adjusting screw below the carriage).
3. After that, release the carriage hand wheel. The machine will start automatic thread chasing. When the rollers of the die head pass over the profiling block and drop down, the dies will open automatically, and the thread chasing process will be completed.
4. Stop the machine and retract the carriage until the entire die head is withdrawn from the end of the pipe. Pull out the locking handle of the die

head and lift up the die head at the same time.



Hammering Disc

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