

Pipe Threader

Facility:	Written By:	Approved By:	Date Created:	Date of Last Revision

Hazards Present:	PPE or Devices Required:	Additional Training Required:
	Safety glasses	Operators Manual
	Gloves	
	Steel toed boots	
	Hearing protection	

Safe Work Procedure:

- 1) Inspect pipe threader before beginning and replace dies or any part that shows signs of wear
- 2) Mount your pipe firmly in the pipe vise by placing it in the vise and then tightening until it is held tightly.
- 3) Cut the end of the pipe cleanly and squarely by using a pipe cutter.
- 4) Ream the cut end of the pipe to remove any burrs from the cut using a reamer, which is a cylinder-shaped rotary cutting tool that you run smoothly across the freshly cut edges of the pipe to remove rough edges.
- 5) Select your die head according to the size and type of pipe you are threading and the thread form you require.
- 6) Place the die head over the pipe on the threader.
- 7) Press steadily on the front of the die head, while simultaneously pushing the handle down to start the threader.
- 8) Use your weight as leverage to apply pressure on the handle, while holding it firmly.
- 9) Apply threading oil generously while threading.
- 10) Cease threading when the end of the threading die is flat against the end of the pipe.
- 11) Reverse the ratchet mechanism and turn the die head in the opposite direction.
- 12) Stand the pipe on end and gently tap it to remove any particles that may be lodged within.
- 13) Clean the pipe with a cloth, removing any oil.
- 14) Seal the threading with Teflon tape or a pipe thread compound when attaching the pipe to the connector.
- 15) Clean the pipe threader machine thoroughly after use so the oils and metal pieces do not damage the machine, which could cause sub-standard threading during your next project.

If an emergency situation occurs while conducting this task, or there is an equipment malfunction, engage the emergency stop and follow the lock out procedure

REPORT ANY HAZARDOUS SITUATIONS TO YOUR SUPERVISOR

Guidance Documents/Standards: MB Workplace Safety & Health Act & Regulations: <i>Part 6 Personal Protective Equipment</i> <i>Part 16 Machines, Tools and Robots</i>	This Safe Work Procedure will be reviewed any time the task, equipment or materials change and at a minimum of every three years
	Reviewed By WSH Committee: Date: