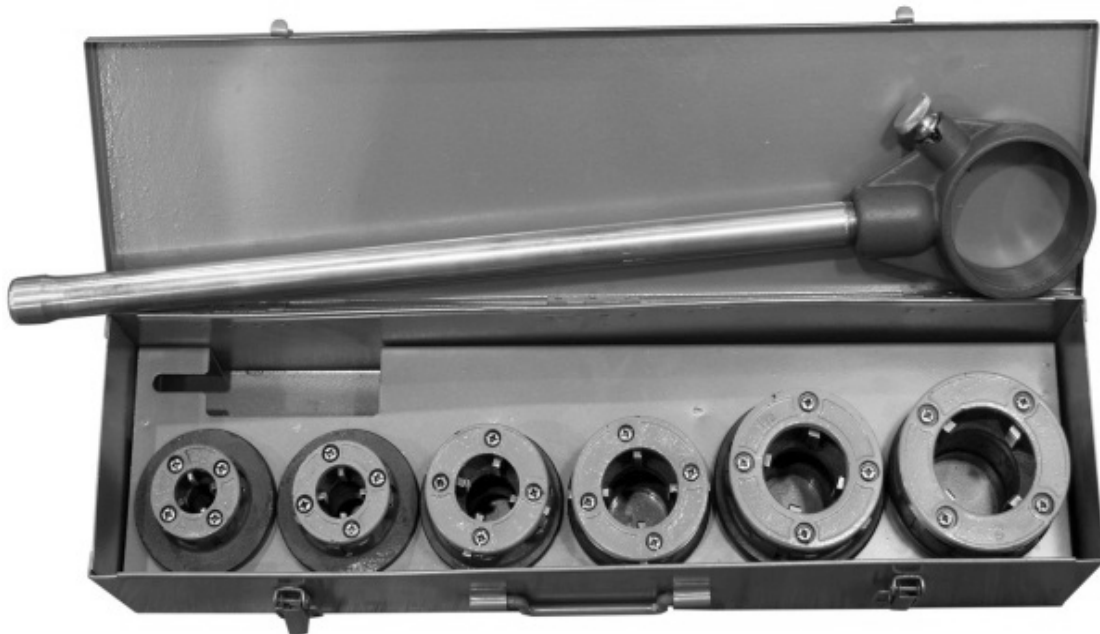


Volume

1.1

OPERATIONAL MANUAL

MODEL: PPT12R PORTABLE PIPE THREADER



by BLUEROCK® Tools

PPT12-R PIPE THREADER

UNPACKING THE ITEM

Caution: This device is packed together with items that may be sharp, oily and overly heavy objects. Remove the device from the packaging in a safe manner. Check to ensure all accessories are included with the item while unpacking. If any parts are found to be missing, contact the retailer as soon as possible. Do not throw away the packaging until the item is out of the guarantee period. Dispose of the packaging in an environmentally responsible manner. Recycle if possible. Keep all plastic bags away from children due to risk of suffocation.

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Safety

DO NOT USE THIS DEVICE UNLESS YOU HAVE READ THE OPERATING INSTRUCTIONS!



Safety glasses must be worn at all times in work areas. Use a full face mask whenever possible.



Long and loose hair must be contained.



Appropriate footwear must be worn.



Close fitting/protective clothing must be worn.



Safety gloves should be worn at all times and jewelry must not be worn.



Read operational manual prior to use.

PRE-OPERATIONAL SAFETY CHECKS

- Examine the body of the device, cutting head and cutting dies and inspect for damage or defects.
- Ensure that the die head and dies are correctly attached to the device.

OPERATIONAL SAFETY CHECKS

- ONLY to be operated by qualified personal who have read instructions.
 - NOTE: Failure to read and follow instructions could result in electrical shock, fire, property damage and/or serious injury!
- DO ensure all non-essential people are clear of the immediate work area.
- DO keep body parts, clothing & power cords clear of turning pieces. Stay alert and use common sense when using this tool.
- DO guard against electric shock by preventing body contact with grounded surfaces such as pipes, radiators, ranges, refrigerators, etc.
- DO NOT use dull cutting dies as the device is more likely to bind and the user lose control.
- DO NOT hold the work piece by hand or using body. Always mechanically clamp or secure work piece.
- DO NOT operate device outside of device specifications.
- DO NOT touch moving parts while the device is being turned as death or dismemberment could occur.
- DO NOT allow children or untrained personal to operate device.
- DO NOT use on a pipe that may contain a live electrical wire/circuit.

Specifications

<i>MECHANICAL DATA</i>	
Pipe Capacity	½" to 2" Diameter
Die Head Size	11R
Die Size	12R
Device Speed	Manual Human Powered

<i>SHIPPING DATA</i>	
Shipping Weight	60 Lbs
Shipping Carton	70cm x 20cm x 16cm

Included Accessories

<i>DESCRIPTION</i>	<i>QTY</i>
Instruction Manual	1
Ratchet Assembly	1
Ratchet Handle	1
½" Die Head and Dies	1
¾" Die Head and Dies	1
1" Die Head and Dies	1
1-1/4" Die Head and Dies	1
1-1/2" Die Head and Dies	1
2" Die Head and Dies	1
Metal Carry Case	1

Additional Available Accessories

Additional accessories for this device can be found in BLUEROCK® Tools online shop at www.bluerocktools.com or from your local retailer.

Operations

Note

THOROUGHLY READ THROUGH THE ENTIRE MANUAL BEFORE OPERATING THIS DEVICE!

PURPOSE

- The purpose of the PPT12R is for threading pipe and conduit.

OPERATIONAL PRINCIPLES

- The device uses a manual power of forward and reverse to thread pipe.
- The threading device is designed to use 11R type die heads (1/2" – 2" pipe).

DEVICE COMPONENTS

- The main components of the PPT12R is the die head assembly, ratchet assembly and ratchet handle.

TRANSPORTING THE DEVICE

- When transporting the device, always carry with both hands.
- If transporting inside a vehicle, it is recommended to transport it on its side so as to avoid the item falling over.

RUNNING THE DEVICE

- Do all pre-operational and operational safety checks from Chapter 1.
- Consider your security and stability as well as the orientation of the device in the work area.
 - Consider the work surface material, condition, strength, density and rigidity. These factors directly affect the tools operation and user safety.
- Ensure the work surface is free of debris, oil, etc.
- Also ensure the device handle is free of grease of oil.
- Check the level and quality of the cutting fluid in the oil delivery device. Fill or replace if necessary.
 - NOTE: Cutting oil is a necessary part of operations. Thread cutting oil lubricates and cools the threads during threading operations. A dirty or poor grade oil can result in poor thread quality.
- Select appropriate die head and dies. Install on device.
 - Inspect the dies to ensure they are sharp and in the correct position.
 - Improperly installed or dull cutting dies can cause binding or poor quality threads.

➤ If possible secure the pipe in a portable tri-stand or a bench vice.

○ To prevent tipping, long lengths of pipe should be supported by a pipe stand.

➤ Cut the end of the pipe to start with a clean and round edge using a pipe cutter (see figure 1 below).



Figure 1

➤ Simultaneously turn the ratchet handle and exert pressure by hand against the die head to assist in starting the thread (see figure 2 below).



Figure 2

➤ When hand threading, your weight should be above the handle ensuring maximum leverage.

○ When hand threading, your weight should be above the handle ensuring maximum leverage. If possible, do not do all the work with your arms. Use your weight.

○ Do not overreach. Keep proper footing and balance.

▪ **WARNING:** Do not slide a pipe or “cheater” over the handle to gain extra leverage. This proactive can result in serious injury or damage to the device.

○ Before applying force to the handle, ensure that the ratchet pawl is engaged.

▪ **WARNING:** Pawl may fail to engage if pushed against the side of the die head.

➤ Apply plenty of thread cutting oil to the dies during threading. This will reduce the torque required to thread and improve the thread quality (see figure 3 below).



Figure 3

- Keep turning the handle until the end of the pipe is even with the edge of the dies.
- Reverse the direction and backing off the die from the pipe.
- When the dies clear the end of the pipe, grip the handle on top of the threader and remove the threader and die head from the pipe.
 - When the dies are nearly removed from the thread, maintain close control of the threader so that the threads are not damaged when removing the die head.

Troubleshooting

Note

SERVICING SHOULD ONLY BE DONE BY A QUALIFIED TECHNICIAN.

PROBLEM	CAUSE	CORRECTION
Die head does not start threading	Dull or broken dies	Replace dies
	Device running in wrong direction	Check setting of the direction switch
	Improperly set dies	Reset dies
	Pipe end not clean	Cut pipe end using pipe cutter
Damaged Thread	Dull dies	Replace dies
	Dies not assembled in correct sequence	Put dies in correct sequence
	Low quality pipe	Make sure only pipe of good quality is used
	Bad quality or insufficient thread cutting oil	Use only thread cutting oil in adequate quantity

General Maintenance

- Inspect device die head and dies. Oil after use.
- Keep device clean and free of debris.
- Check for misalignment, binding and breakage of all moving parts. If damaged, repair tool before use.

Parts List

Part Number	Part Name
	<i>The * below list is the parts for the program.</i>
*1	Screw M6*12 (4)
*2	Head plate (1/2", 3/4", 1", 1 1/4", 1 1/2", 2")
*3	Head body (1/2", 3/4", 1", 1 1/4", 1 1/2", 2")
4	Ratchet body
5	Roll pin
6	Knob
7	Spring
8	Handle
*9	Pawl

Breakdown View

