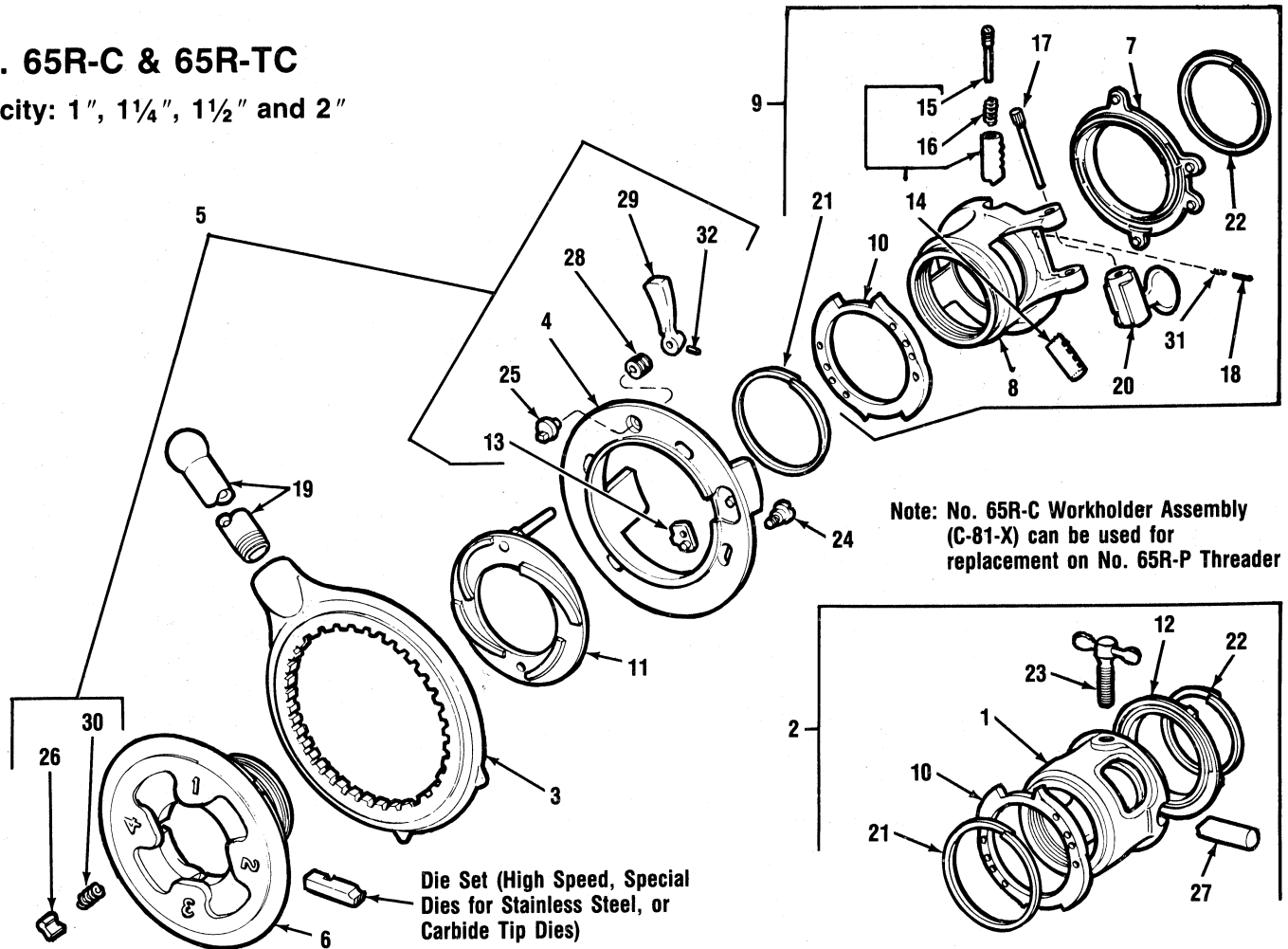


RIDGID® Nos. 65R-C & 65R-TC Pipe & Conduit Threaders

Nos. 65R-C & 65R-TC

Capacity: 1", 1¼", 1½" and 2"



Ref. No.	Description	Catalog No.	Old Part No.
1	65R-C Workholder (Cam Type) N.P.T.	39335	C-81
	65R-C Workholder (Cam Type) B.S.P.T.	68100	
2	65R-C Workholder Assy. (Cam Type) N.P.T.	39340	C-81-X
	65R-C Workholder Assy. (Cam Type) B.S.P.T.	68110	
3	Ratchet Ring	39205	C-104
4	Drive Plate	39215	C-148-1
5	Jam Proof Drive Plate Assembly	39220	C-148-1-X
6	Head N.P.T.	39245	C-246
	Head B.S.P.T.	68060	
7	Gauge Ring	39290	C-418
8	Tru-Center Workholder N.P.T.	39295	C-491
	Tru-Center Workholder B.S.P.T.	68070	
9	65R Tru-Center Workholder Assy. N.P.T.	39300	C-491-X
	65R Tru-Center Workholder Assy. B.S.P.T.	68075	
10	Change Plate N.P.T.	39400	D-34
	Change Plate B.S.P.T.	68125	
11	Cam Plate	39450	D-78
12	Gauge Ring	39370	D-114
13	Throwout Plate	39405	D-350
14	Workholder Jaw (3 per set) (2 solid & 1 spring loaded)	39425	D-470-X

Ref. No.	Description	Catalog No.	Old Part No.
15	Set Screw	39485	E-1124
16	Compression Spring	39490	E-1125
17	Locking Cam Pin	39500	E-1128
18	Stop Pin	39505	E-1129
19	Pipe Handle	39545	E-1347
20	Locking Cam	39555	E-1425
21	Change Plate Spring Ring	39975	F-68
22	Gauge Plate Spring Ring	39980	F-69
23	Clamp Screw	39985	F-73
24	Drive Plate Screw (4)	39990	F-74
25	Release Cam	39995	F-75-X
26	Pawl (2)	39875	F-107
27	Workholder Jaw (2)	39880	F-132
28	Release Cam Flat Spring (2)	39885	F-163
29	Release Cam Lever	39895	F-213
30	Pawl Spring (2)	39900	F-263
31	Coil Spring	39915	F-282
32	Cam Lever Pin	39965	F-671

The Ridge Tool Co., Elyria, Ohio, U.S.A.

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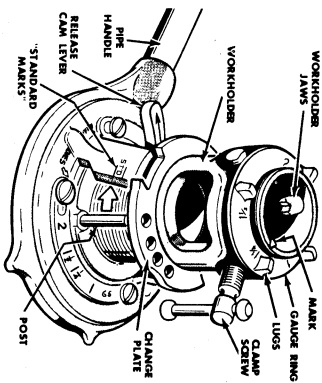


Form No. 65R-C/P-I-386
999-998-280

Operating Instructions for Threading Pipe with 65R-C & 65R-P Threaders

1. ADJUSTING THREADER FOR SIZE:

- Place threader in position shown and unscrew workholder by turning counter clockwise until change plate is clear of posts.
- Move "Post" to pipe size desired. Screw workholder clockwise until change plate slides over post.
- FOR STANDARD THREAD:** Set Change Plate between the two "STANDARD" ☐ STD ☐ marks.
- OVERSIZE or SHALLOW THREADS:** Set Change Plate slightly below the "STANDARD" marks.
- UNDERSIZE or DEEP THREADS:** Set Change Plate slightly above the "STANDARD" marks.



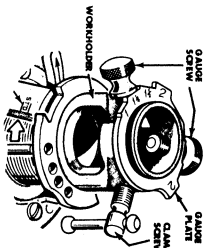
2. TO SET WORKHOLDER: (ON 65R-C CAM TYPE)

- Turn gauge ring until desired size lines up with mark on top of workholder.
- DRIP THREADS:** Move gauge ring off mark to throw pipe off-center. Tighten threader on pipe with workholder set in this position.

TO SET WORKHOLDER ON 65R-P (PLATE TYPE):

Turn correct size flats of gauge plate to line up with gauge screws and tighten screw shoulders against plate.

DRIP THREADS: FOR 65R-P (PLATE TYPE) WORKHOLDER: Loosen gauge screws slightly to throw pipe off-center any desired degree. Tighten threader on pipe with workholder set in this position.



DISCONTINUED

3. THREADING PIPE: (To thread conduit see step 5)

FOR BEST RESULTS ALL PIPE SHOULD BE CUT OFF "SQUARE" USE A PIPE CUTTER--NOT A HACK SAW. FLOOD DIES WITH RIDGID THREAD CUTTING OIL.

- Release cam Lever must be at "CLOSE" position for cutting threads.
- With pipe held securely slide threader on pipe, workholder end first. Center end of pipe in dies.
- Tighten Clamp Screw of workholder securely.

- To thread, use pipe handle in a pumping action. When threading with a power drive, turn die head approximately one turn manually, start motor, and cut desired length of thread. FLOOD DIES WITH PLENTY OF RIDGID THREAD CUTTING OIL.

THREADER IS JAM PROOF. AUTOMATIC KICK-OUT DISENGAGES RATCHET ACTION. PREVENTS JAMMING.

E. TO REMOVE THREADER FROM FINISHED THREAD.....

- Turn release cam lever to "open" and spin threader back to the "standard" position. Loosen clamp screw and slide threader off.

---O R---

- Turn release cam lever to "OPEN" and loosen clamp screw. Pull threader straight off pipe. (No spinning off necessary)

4. TO REMOVE OR INSERT DIES:

- Place 65R in position shown and screw workholder upwards until change plate is clear of post. Turn release cam lever to "OPEN" position.
- Push post all the way to the left past 2" mark. Turn 65R over and remove dies. If dies stick--tap ratchet ring lightly behind die.

- TO INSERT DIES:** Place #1 die in the #1 slot--the #2 die in the #2 slot, etc. Move post to engage dies. Turn threader over. Set post to desired size. Screw workholder down so change plate rests between the "STANDARD" size marks and you are ready to resume threading.

5. CONDUIT THREADS: (According to American Standards Association are tapered threads)

This threader will cut a conduit (straight) thread without special dies. Follow paragraphs A, B, & C in Step 1...

- You must engage the dies in the conduit about 4 turns.
- Release workholder clamp screw so that workholder is free to turn on the conduit. This disengages the taper action and results in a straight or running thread.

NOTE--SPECIAL DIES

Due to new materials in the manufacture of pipe such as special alloys, plastic, etc., we suggest that a sample of the pipe be forwarded to us, so that we can determine type of dies most suitable for your particular requirements.