

MINOR 2000 - USE OF DIEHEADS

The Minor 2000 Diehead system is intended to cut the following screw threads. BSPT, API/NPT and Metric Conduit, threading plain seam welded tube of 22 ton tensile to BS1387 for BS21 and similar gas and water pipes, and electrical conduit.

The Dieheads are made with a locating guide in the body for the size of the pipe, and have fixed replaceable chaser dies. They have no adjustment facility.

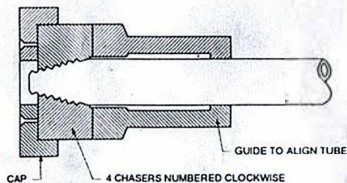
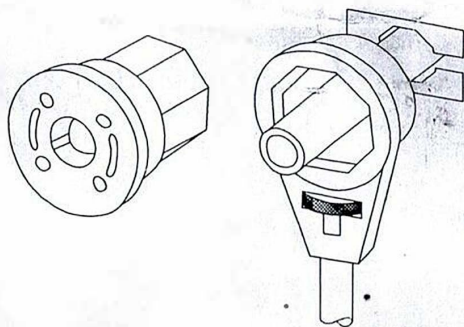
The simple rules below will give a long and trouble free tool life.

USE LIGHT OIL FOR LUBRICATION

Grease or Tallow should not be used as it will cause difficulties with cuttings, and lack of oil will result in poor thread finish or undersize threads.

Use of grease or tallow will result in the swarf being held in the threads, on welded tube this will cause pick up. On metric conduit parallel thread it will cause trouble when reversing the diehead. Heavy duty drawn pipe will cause problems by the overloading of the diehead, backing off and taking a second cut can help.

Galvanised pipe will increase wear to the cutting edges, and will result in a shorter life. Stainless steel pipe is very wear resistant, and work hardens, sharp dies must be used at all times.



Basic Application:-

After securing the pipe in a tube vice or similar securing device the ratchet should be placed over the pipe, and by holding the aluminium cap of the diehead, locating the guide over the pipe a hand start can be easily achieved.

APPLY OIL AT THIS STAGE

The ratchet can then be clicked onto the octagonal body and a combination of ratchet movement and pressure on the aluminium cap will start the thread.

The diehead is intended to cut the required length of thread when the pipe reaches through to the aluminium cap.

The use of a light cutting oil to enable a smooth thread to be cut, failure to use any oil will result in a torn or undersize thread.

If a rough sawn angle is on the end of the pipe, some difficulty will arise in starting, we recommend a roller tube cutter to be used, to give a start to the thread.

PRESTO
Engineers Cutting Tools

