

DISCLAIMER: These Standard Operating Procedures (SOP's) are for the exclusive use of Navy Public Works Center (PWC) Norfolk. They are promulgated as guidance for their NAVFAC Commands. If intended to be used by other activities, they must be tailored to each activity's particular requirements and must be reviewed/approved by the activity's safety professionals prior to use.

Standard Operating Procedure Pipe Threader Operation

Safety equipment required:

- Gloves
- Hearing protection
- Safety glasses
- Safety shoes

Equipment required:

- Pipe threading machine and associated equipment

PROCEDURE

1. Ensure the work area is clear of debris and personnel.
2. Select the proper size die head for the pipe to be threaded and install it on the machine.
3. Position the length of pipe in the machine and tighten the chuck and the guide.
4. Cut the end of the pipe square and deburr it.
5. Position the oil spray arm toward the end of the pipe.
6. Thread the end of the pipe.
7. Disengage the die head, clean the oil from the threaded end of the pipe and remove it from the machine.
8. Clean up the area and the machine. Properly dispose of any waste material.