



PIPE TOOLS & VISES
SINCE 1896

R811 Universal Die Head Operating Instructions

Installing Dies in the R811 Universal Die Head

The Universal Die Head requires one set of 4 Universal Dies to thread pipe ranging from 1/8" to 2". One set of dies is required for each of the following pipe size ranges:

- 1/8"
- 1/4" and 3/8"
- 1/2" and 3/4"
- 1" and 2"

Note: Bolt threading requires a separate set of dies for each bolt size.

1. Lay die head on bench with numbers face up.
2. Flip throwout lever to OPEN position.
3. Loosen clamp lever approximately three turns.
4. Lift tongue of clamp lever washer up out of slot under size bar. Slide throwout lever all the way to end of slot in the OVER direction indicated on size bar.
5. Remove dies from die head.
6. Die numbers 1 through 4 must agree with those on die head.
7. Insert dies to mark on side of die head.
8. Slide throwout lever back so that tongue of clamp lever washer will drop in slot under size bar.
9. Adjust die head size bar until index line on lock screw or link is aligned with proper size mark on size bar.

10. Tighten clamp lever. For bolt threads, align index line with bolt line on size bar.
11. If oversize or undersize threads are required, set the index line in direction of OVER or UNDER size mark on size bar.

Threading Pipe with the R811 Die Head

1. Install die set. Refer to die installation procedure.
2. Swing cutter and reamer to out-of-way position.
3. Lower die head into threading position.
4. Apply Reed Threadguard Cutting Oil to pipe end.
5. Turn REV/OFF/FOR switch to FOR position and step on foot switch.
6. Engage dies with pipe using carriage lever and oil dies with plenty of Reed Threadguard Cutting Oil until thread is completed.
7. Quick-Opening Die Head: When thread is completed, raise throwout lever to open head position, retracting dies. NOTE: Quick-opening die heads eliminate slow back-off.
8. Release foot switch and turn REV/OFF/FOR switch to OFF position.
9. Move carriage lever away from pipe end and return die head to up and out-of-way position.

Reed Manufacturing Company
1425 West 8th St.
Erie, PA 16502 USA



Phone: 800-666-3691 or 814-452-3691
Fax: 800-456-1697 or 814-455-1697
www.reedmfgco.com