

No. 819 Nipple Chuck

The RIDGID No. 819 Nipple Chuck (*Figure 1*) is a quick and easy tool for holding short and close nipples or studs for threading. For use with pipe and bolt threading machines, or power drive equipped with 2 support bars, No. 311 Carriage and self-opening or quick-opening die heads.

Capacity: $\frac{1}{8}$ " to 2" Standard Pipe (NPT)
 $\frac{1}{4}$ " to 2" Bolts or Studs UNC or UNF

Pipe Adapters	Stud Adapters
$\frac{1}{8}$ ", $\frac{1}{4}$ ", $\frac{3}{8}$ ", $\frac{1}{2}$ ", $\frac{3}{4}$ ", 1", $1\frac{1}{4}$ ", $1\frac{1}{2}$ "	$\frac{1}{4}$ " to 2" UNC $\frac{1}{4}$ " to $1\frac{1}{2}$ " UNF

Short or Close Nipple Threading Procedure

⚠WARNING The REV/OFF/FOR switch should be in the OFF position until nipple chuck is set up and ready to thread.

1. Grip pipe in machine chuck. Thread and ream one end and cut nipple to desired length.
2. Place nipple chuck body (*Figure 2*) in Threading Machine chuck, gripping jaw grooves. Tighten chuck with snap spin of handwheel.
3. Position insert with small end toward chuck body for $\frac{1}{8}$ " to $\frac{3}{4}$ " pipe; large end toward chuck body for 1" pipe; no insert required for $1\frac{1}{4}$ " pipe and up.
4. Select proper size nipple chuck adapter and screw into nipple chuck (*Figure 2*) by hand. Tighten with wrench provided with nipple chuck.

⚠WARNING To prevent injury, remove wrench before turning on machine.

5. Screw nipple (*Figure 3*) threaded on one end into adapter by hand. Turn directional switch to ON and press down on foot switch. Ream and thread other end.
6. Insert pin on end of wrench (*Figure 3*) into one of holes in nipple chuck release collar and turn. Remove threaded nipple by hand.

⚠WARNING To prevent injury, remove wrench before turning on machine.

Using Nipple Chuck to Drive Studs or Nipples

1. Insert stud or nipples into tapped hole hand-tight.
2. Insert proper size stud or nipple adapter (*Figure 4*) into nipple chuck.
3. Screw nipple chuck onto stud or nipple.
4. Insert $\frac{5}{8}$ " diameter bar through hole in shank of nip-

ple chuck body and turn nipple chuck clockwise to tighten stud or nipple.

5. Using nipple chuck wrench, turn release collar in direction of arrow and remove nipple chuck from stud or nipple.

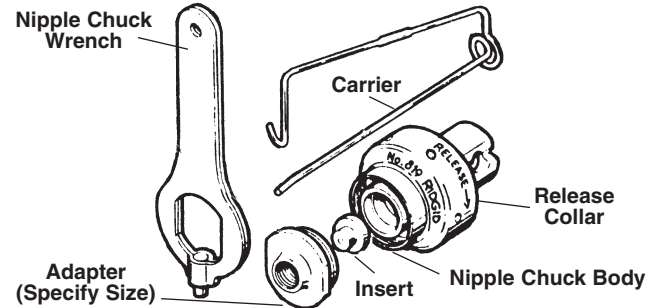


Figure 1 – No. 819 Nipple Chuck

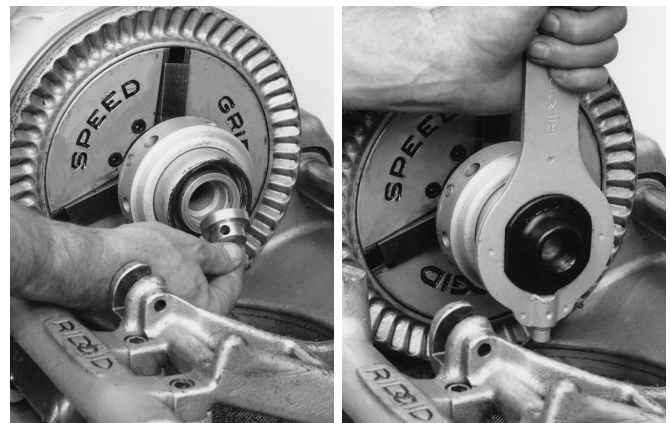


Figure 2 – Installing Nipple Chuck Body and Adapter

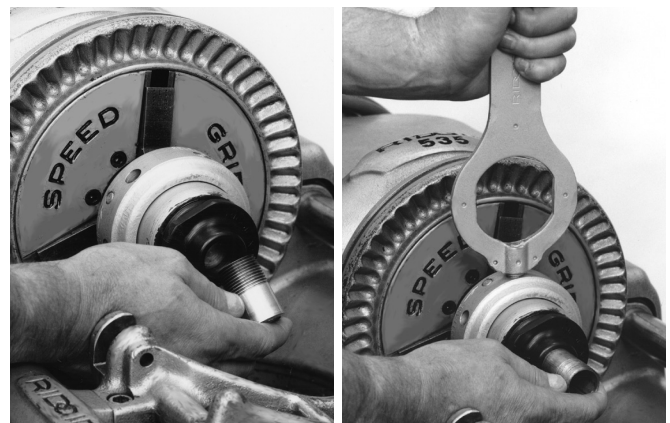


Figure 3 – Releasing Nipple with Wrench

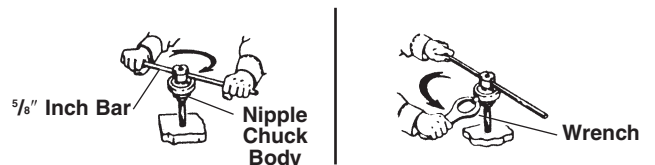


Figure 4 – Driving Studs or Nipples

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