

November, 2023

THREADING PIPE

Purpose/Application

To guide workers on the safe methods for threading pipe.

PPE

- Strike Minimum PPE

TRAINING

- Review of equipment with an experienced worker
- Strike New Worker Orientation

TOOLS/EQUIPMENT

- Reamer
- Threader
- Generator
- Chop saw
- Pipe wrenches
- Pipe Vise
- Pipe dope/pipe thread tape
- Fittings
- Tape
- File
- Wire brush
- Cutting fluid

#	Job Steps	Hazards	Control Measures
1.	Inspect all tools for any damage prior to each use	<ul style="list-style-type: none"> ❖ Flammable – Look for leaks or drips ❖ Injury – Sharp edges or slippery sections of equipment ❖ Motion – Poor housekeeping in the work area, wet ground conditions, or material in the way ❖ Chemical – Exposure to cutting fluid 	<ul style="list-style-type: none"> ▪ Review the manufacturer’s instructions before using a tool ▪ Check the handle and body casing of the tool for cracks or other damage, or missing screws, and installed securely ▪ Unplug machine before carrying out inspections and/or maintenance ▪ If the tool has auxiliary or double handles, check to see that they’re installed securely ▪ Inspect cords for defects: check the power cord for cracking, fraying, and other signs of wear or faults in the cord insulation ▪ Check for damaged switches and any with faulty trigger locks ▪ Inspect the plug for cracks and for missing, loose or faulty prongs ▪ Verify you have access to SDS for cutting oil ▪ Keep rags on hand ▪ Make sure the controls operate smoothly ▪ Check operation of chuck should lock and unlock evenly ▪ Ensure slides are clean and operating smoothly ▪ Check condition of die, ensure that die is sharp and not damaged and is clear
2.	Measure the pipe	<ul style="list-style-type: none"> ❖ Motion – Keep work area clear of tripping hazards, rolling or falling material 	<ul style="list-style-type: none"> ▪ Keeps the work area clean ▪ Watch your footing ▪ Ensure material is secured against rolling or falling

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3.	Cutting the pipe (Chop saw/Cold cut attachment/Hand Cutters/Zip disk etc.)	<ul style="list-style-type: none"> ❖ Motion - Flying debris, burs on cut-offs, sharp edges of the pipe, snags, pinch points around the material being cut, wrong cutting disk/blade ❖ Flammable - Sparks 	<ul style="list-style-type: none"> ▪ Secure the pipe using chain vise, clamps, or other method ▪ Use a spill tray to contain all fluids ▪ Use a pipe reamer/file to clean out the end of the pipe (do not use your hand to clean the end of the pipe) ▪ Wear double eye protection where required ▪ Do not wear loose or ragged clothing or gloves when operating the power drive (threader), keep your sleeves and jackets buttoned up ▪ Comply with SWP 26 Grinder Operations when cutting pipe ▪ Machine should be set up on a firm, level surface
4.	Power Threading/Hand Threading Pipe	<ul style="list-style-type: none"> ❖ Motion - Pinch points around moving pipe, rolling pipe, flying debris, burs, snags, and equipment starting unintentionally ❖ Flammable – Sparks 	<ul style="list-style-type: none"> ▪ Secure the pipe using chain vise, clamps, or other method ▪ Avoid accidental starting and be sure the switch is off before plugging it in ▪ Use a spill tray to contain all fluids ▪ Use the reamer or file to clean the end of the pipe ▪ Use the wire to clean threads, do not use your hand to remove burs from the end of the pipe ▪ Do not handle shavings; they can be very sharp ▪ Use a rag to clean up excessive cutting fluid off the pipe ▪ Do not force cutting die onto pipe-allow to feed on at own rate ▪ Swing die head out of way if using cutting tool on pipe
	Removing Pipe from Machine	<ul style="list-style-type: none"> ❖ Motion - Moving Objects, Cuts to hands, Rough or sharp edges 	<ul style="list-style-type: none"> ▪ Stop machine and turn switch to reverse to remove die from pipe ▪ Release the foot switch and remove your foot from the housing and turn the power switch to off ▪ All the machine to come to a complete stop before removing pipe ▪ Repeated and forceful clockwise spins of the speed chuck handwheel at the front of the machine to release the pipe from the chuck jaws ▪ If necessary, loosen the rear centering devise using a clockwise
5.	Clean Up	<ul style="list-style-type: none"> ❖ Slips, trips, falls, pinch points 	<ul style="list-style-type: none"> ▪ Dispose of contaminated rags in designated areas ▪ Do not handle pipe shavings, dump directly into disposal

