

MINIMUM REQUIREMENT



WP/SEA MINIMUM REQUIREMENTS Rigid Pipe Threading



MEMORY JOGGERS

Ensure that the following conditions are met before proceeding. If not met, address on WP/SEA.

Communicate the **“RIGHT TO STOP WORK AUTHORITY POLICY”** and is exercised by all crewmembers and other personnel that believe something or some condition has changed. The job is to be stopped and accessed before proceeding. The WP/SEA may need to be modified or a new WP/SEA maybe required before starting the work task again.

Keep your work area clean and well lit. (Cluttered benches and dark areas invite accidents)

Do not operate tools in explosive atmospheres, such as in the presence of flammable liquids, gases, or dust. Tools create sparks which may ignite the dust or fumes.

Keep by-standers and visitors away while operating tool. (Barricade area with yellow caution tape)

Keep floors dry and free of slippery materials such as oil.

Avoid body contact with grounded surfaces

Don't expose electrical tools to rain or wet conditions. Always plug equipment into a GFCI circuit.

Do not abuse cord. Never use the cord to pull the plug from the outlet. Keep cord away from heat, oil, sharp edges or moving parts.

When operating a tool outside use an outdoor extension cord marked “W-A” or “W”. These cords are rated for outdoor use.

Stay alert, watch what you are doing and use common sense operating a power tool.

Dress properly. Do not wear loose clothing, jewelry or gloves when operating machine (long hair can be caught in moving parts)

Avoid accidental starting. Be sure switch is **OFF** before plugging in. Plugging in tools that have the switch **On** invites accidents.

Remove adjusting keys before turning the tool **ON**. A wrench or key that is left attached to a rotating part of the tool may result in personal injury.

Do not over-reach. Keep proper footing and balance at all times. Proper footing and balance enables better control of the tool in unexpected situations. Operate machine from side with **REV/OFF/FOR** switch.

Support long heavy pipe with pipe supports. This practice will prevent tipping.

Do not use a threading machine if the foot switch is broken or missing. A Foot Switch is a safety device designed to prevent serious accidents. (hand held threaders do not have a Foot Switch)

Keep hands away from rotating pipe and fittings. Stop the threading device before wiping pipe threads or screwing on fittings.

Allow the threading device come to a complete stop before touching the pipe or machine chucks.

Do not use a threading device to make or break fittings.

Tighten all chucks before turning on the machine. Prevents oscillation of the pipe.

Keep covers in place. Do not operate the threading equipment with covers removed.

Allow threads to cool before handling. Threads will be hot to the touch immediately after threading.

Use proper lifting techniques when handling pipe, use the “buddy system.”

Use in ventilated area. Prevents accumulation of coolant vapors.

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Verify **All** conditions identified in the “Memory Joggers” section are met (or are not applicable); if **ANY** are not met, **STOP** and add the necessary step to the WP/SEA to ensure the safest method possible.

Check coolant systems for cutting oil, manual or automatic

Verify that the cutter, reamer and die heads fit the particular device used and is in proper working order.

Mark the pipe at the desired length.

Insert the pipe into the threading machine or pipe vise so that the end to be worked or the cutting mark is located about 4” inches to 6”inches from the front of the cutting dies.

Insert work-pieces less than 2 feet long from the front of the machine or vise. Insert longer pipes through either end so that the longer section extends out beyond the rear of the threading machine or vise.

Tighten the rear centering device or vise around the pipe. This prevents movement of the pipe.

Secure the pipe by using a vise or tightening the jaws of the threading equipment around the pipe.

Cutting Pipe & Rod: Move pipe cutter down onto pipe and align up cutter wheel with mark on pipe.

ENSURE MINIMUM REQUIREMENTS NUMBERS ARE RECORDED ON WP/SEA