

# Apprentice & Journeymen Training Trust Fund

## Of the Southern California Plumbing & Piping Industry

### Pipe Threading Machine Policy & Procedure

1. Proper Protective Equipment (P.P.E.) must be worn during all pipe roll grooving operations:
  - ANSI Z87+ rated safety glasses with side shields are required.
  - Tight fitting, heavy duty leather gloves. Refer to Figure 1-10 Welding Glove Rec.
  - Work attire – long pants, long-sleeved shirt, welding jacket, sleeves or leathers.
  - Work boots must be ankle high or greater.
  - **NEVER** wear loose clothing or jewelry, to prevent entanglement.
2. Safety precautions:
  - Pipe threading machine must be plugged into an electrical receptacle equipped with a ground. Refer to Figure 1-4 Properly Grounded Power Cord & Receptacle Chart.
  - Extension cords must be heavy duty. Cord shall be no longer than 100 feet. Too light of a gauge extension cord can cause excessive voltage drop. Refer to Figure 1-3 Extension Cord Wire Gauge Selection Chart.
  - **NEVER** operate pipe threading machine in standing water.
  - **NEVER** operate pipe threading machine without a foot switch.
  - Foot switch must be locked when pipe threading machine is left unattended. Refer to Figure 1-5 Foot Switch & Lock.
  - **NEVER** operate pipe threading machine if power switch does not turn ON & OFF.

**Use of a Portable Ground Fault Circuit (GFCI) is required for all power tools connecting to a temporary power/extension cord**

**In this order: (1) Electric Plug Receptacle, (2) GFCI, (3) Cord and (4) Tool**
3. Operating pipe threading machine:
  - Pipe threading machine is designed for single person operation. Operator must control foot switch and machine.
  - Set up pipe threading machine on a level surface.
  - Verify power is switched to the off position before plugging in machine.
  - Remove any wrenches or adjusting keys before turning on machine.
  - Keep floors dry of slipper materials, such as oil.
  - Barricade work area to protect others from exposure to any potential hazards.
  - Unplug machine before making any adjustments or while changing attachments or accessories. Only use manufacturer approved attachments and accessories.
  - Verify material is properly aligned on pipe threading machine. Only use materials for which the pipe threading machine is rated.
  - Keep hands away from moving parts of machine and pipe ends.
  - Pipe jack stand must be used to level and support long lengths of material.
  - Keep hands away from rotating pipes and fittings.
  - Allow machine to come to a complete stop before touching chucks.
  - Wipe down pipe and screw on fittings after the machine has come to a complete stop.
  - **NEVER** use the machine to make up or break fittings.
4. Care of tools:
  - All manufacturer guidelines and recommendations for safety, proper use, care, maintenance, storage and record keeping must be followed.
5. Housekeeping:
  - Work clean – all scrap material, grinding dust and debris will be removed as produced and put in appropriate storage containers.
  - All tools, equipment, power cords, etc. must be kept out of paths of travel.
  - **NEVER** use pipe threading machine or other power tools in wet conditions.