



PIPE TOOLS & VISES  
SINCE 1896

# R811 Universal Die Head Operating Instructions

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## 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.

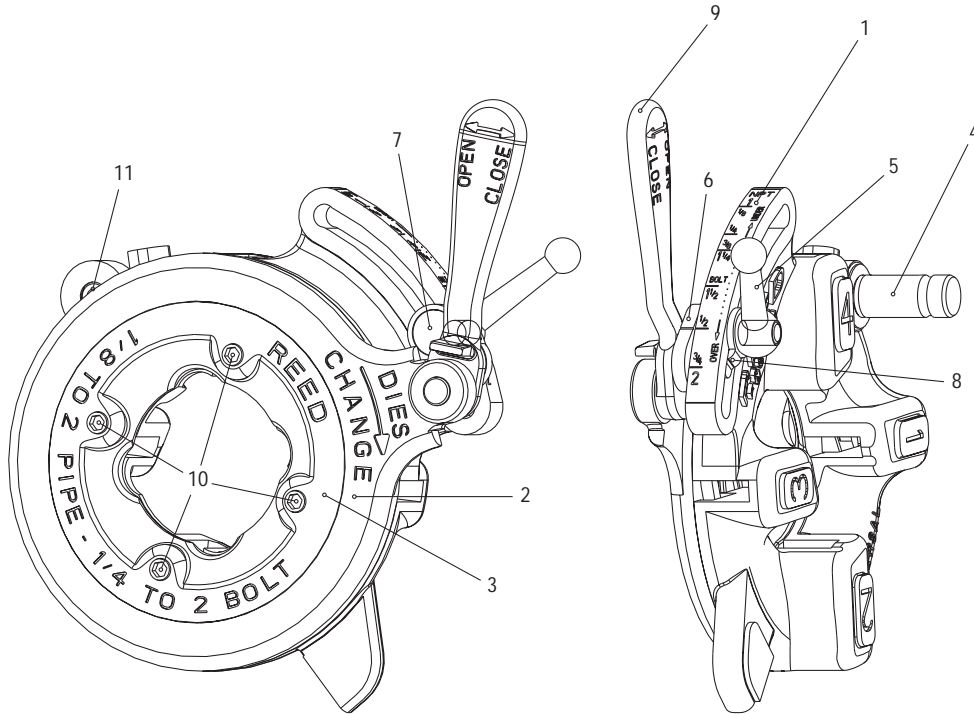
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# R811 Universal Die Head Parts



**Recommended Accessories:**  
 Reed Universal Dies in geometries for  
 NPT, NPSM and BSPT.

## Parts List

Ref. No.	Description	Item Code	Qty. Used
1	Head	98701	1
2	Cam Plate	98702	1
3	Retaining Ring	98703	1
4	Mounting Post	98705	1
5	Clamp Lever	98706	1
6	Link	98707	1
7	Lock Screw	98708	1
8	Lever Washer	98709	1
9	Throw-Out Lever	98718	1
10	Socket Cap Screw	30105	4
11	Socket Set Screw	30301	1