

SAFE JOB PROCEDURE SJP-21

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

ThreaderGeneratorChop saw

Pipe wrenches

Pipe Vise

Pipe dope/pipe thread tape

Fittings

Tape

• File

Wire brush

Cutting fluid

#	Job Steps	Hazards	Control Measures		
1.	Job Steps Inspect all tools for any damage prior to each use	 ★ 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 	 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 smoothy 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	 Motion – Keep work area clear of tripping hazards, rolling or falling material 	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.)	 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 	 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	 Motion - Pinch points around moving pipe, rolling pipe, flying debris, burs, snags, and equipment stating unintentionally Flammable - Sparks 	 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 			
	Removing Pipe from Machine	 Motion - Moving Objects, Cuts to hands, Rough or sharp edges 	 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	 Slips, trips, falls, pinch points 	 Dispose of contaminated rags in designated areas Do not handle pipe shavings, dump directly 			



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			into disposalEnsure all power is off to mechanical components		

ADDITIONAL PRECAUTIONS

- Follow the manufacturer's instructions for use of the machine and installation of dies.
- When using power threading machines, keep your hands away from rotating pipes and fittings.
- Stop the machine before wiping pipe threads or screwing on fittings. Allow the machine to come to a complete stop before touching the pipe.
- Remember releasing the foot switch does not immediately stop the machine from winding. Using it as a mechanical means to thread connections to the pipe is an unsafe practice. Always hand thread connections onto the pipe.

ADDITIONAL INFORMATION

SWP 26 - Grinder Operations

SWP 18 - Tools/ Equipment/ Machinery

SWP 22 – Ergonomics – Manual Material Handling

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