



Safe Work Procedure

Nipple Chuck

Department and Program: Physical Plant Maintenance

Date First Approved: October 2018

Date Reviewed: February 2023

Version 2.0 SWP-PP-GEN-029

This Safe Work Procedure must be reviewed any time the task, equipment, or materials change and at a minimum every three years.

DO NOT perform this procedure until you have been appropriately trained and authorized to do so.

Required Training

- Must be trained by experienced competent person

Required Personal Protective Equipment and Devices



CSA Approved Safety Footwear Required



No jewelry, watches, rings, necklaces etc.



Eye Protection Required



No loose fitting clothing



Long or loose hair must be tied back or contained



Hearing Protection Required



Gloves must not be worn when operating this equipment

Potential Hazards

- Cuts, lacerations and amputations
- Dust/debris irritation
- Noise
- Projectile work pieces/tools from improper set up
- Burns
- Fumes
- Hot materials

Pre-Operational Safety Checks

- Inspect required personal protective equipment and replace if required.
- Ensure no slip/trip hazards are present in workspaces and walkways.
- Make sure guards, if present, are installed and are working properly.
- Faulty equipment must not be used. Immediately report suspect machinery.
- Locate and ensure you are familiar with the operation of the ON/OFF starter.
- Disconnect power supply before making any adjustments, changing accessories, or storing the tool.
- Do not use if foot switch is missing or broken
- Remove nipple chuck wrench before proceeding

- If work piece extends beyond the machine set-up guards or barricades to create a safety zone. Use pipe stands to support pipe that extends 1.2 meters (4 feet) beyond the machine.

Prohibited Activities

- Do not leave nipple chuck wrench in nipple chuck release collar
- Do not leave this equipment unattended while running
- Do not use for other purposes such as drilling holes
- Do not use this machine to make or break fittings
- Do not reach across the machine or work piece.
- Do not loosen work holder until dies have been disengaged from pipe.

Safe Work Procedure

1. Inspect required personal protective equipment and replace if required.
2. Put on all required personal protective equipment.
3. Make all adjustments with POWER OFF.
4. Grip pipe in machine chuck. Thread and ream one end and cut nipple to desired length.
5. Place nipple chuck body in Threading Machine chuck, gripping jaw grooves. Tighten chuck with snap spin of hand wheel.
6. Position insert with small end toward chuck body for 1/8" to 3/4" pipe; large end toward chuck body for 1" pipe; no insert required for 1-1/4" pipe and up.
7. Select proper size nipple chuck adapter and screw into nipple chuck by hand. Tighten with wrench provided with nipple chuck.
8. Screw nipple threaded on one end into adapter by hand. Turn directional switch to ON and press down on foot switch. Ream and thread other end.
9. Insert pin on end of wrench into one of holes in nipple chuck release collar and turn. Remove threaded nipple by hand.
- 10. Remove nipple chuck wrench form nipple chuck release collar**
11. Clean up dust and debris with POWER OFF.

If an emergency situation occurs while conducting this task, or there is an equipment malfunction, shut the equipment off immediately and follow the lock out procedure listed below

REPORT ANY HAZARDOUS SITUATION TO YOUR INSTRUCTOR/SUPERVISOR IMMEDIATELY

Housekeeping

- Switch off the machine and reset all guards to a fully closed position.
- Leave the machine in a safe, clean and tidy state.
- When servicing equipment, power must be disconnected.
- Ensure switch levers are kept clean and free of foreign matter

Guidance Documents/ Standards/ Applicable Legislation/ Other:

Guidance Documents:

- Operator's Manual

CSA Standards:

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Manitoba Regulation 217/06:

- 2.1 Safe Work Procedures
- 6.1 Personal Protective Equipment
- 12.3 Hearing Protection
- 16.4, 16.14 & 16.35 Machine and Tool Safety

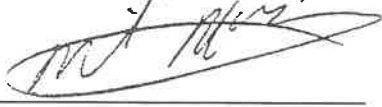
Date Written: 2017/08/16

Procedure Developed By: Travis Poersch, Brent Cuvelier, Ian Smith

Date Revised:

Approved By: Michael McCormick, Director of Physical Plant

Signature: _____

A handwritten signature in black ink, appearing to read 'Michael McCormick', written over a horizontal line.

Date Approved: 2023/2/1

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