

Quick-Acting Pipe Welding Clamp Instructions

⚠ WARNING



Read and understand these instructions and the warnings and instructions for all equipment and material being used before operating this tool to reduce the risk of serious personal injury.

SAVE THESE INSTRUCTIONS!

- Use appropriate safety equipment. Always wear proper eye and foot protection. Dust mask, face shield, hearing protection or other equipment may be needed to reduce the risk of injury.
- Do not use the Pipe Clamp for lifting, supporting or transporting. It is not designed for these uses and could allow the workpiece to fall and cause serious injury. Only use as directed in these instructions.
- Properly support the workpieces. Use pipe stands, tables, vises or other methods to support workpieces. Failure to properly support the workpiece can allow it to fall and cause serious injury.

If you have any question concerning this RIDGID® product:

- Contact your local RIDGID distributor.
- Visit RIDGID.com to find your local RIDGID contact point.
- Contact Ridge Tool Technical Service Department at rttech-services@emerson.com, or in the U.S. and Canada call (800) 519-3456.

Description

RIDGID® Pipe Welding Clamps are used to align pipes/fittings and other cylindrical workpieces for welding. It includes a quick acting feature for fast installation and use. The wing bolts that grip the pipe are made of stainless steel.

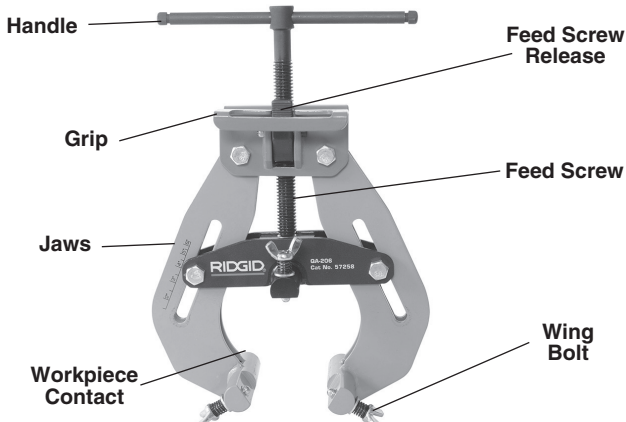


Figure 1 – Quick-Acting Pipe Welding Clamp

Specifications

Model.....	QA-206	QA-412
Catalog Number...	57258	57263
Capacity	2" to 6"	4.5" to 12"
	50 to 150 mm	112 to 300 mm
Weight	11 lbs (5 kg)	16.7 lbs (7.6 kg)
Size.....	8.5" x 12.75" x 4.25"	13.75" x 18" x 4.25"
(Closed)	(216 x 324 x 108 mm)	(349 x 457 x 108 mm)

NOTICE Use of equipment for both carbon and stainless steel pipe can lead to contamination of the stainless steel material.

This contamination could cause corrosion and premature pipe failure. To reduce the risk of ferrous contamination of stainless steel pipe, use dedicated equipment. Alternately, a stainless steel wire brush may be used to thoroughly clean the equipment when switching between materials.

Inspection/Maintenance

Clean the pipe clamp to aid inspection and improve control. Clean workpiece contact points with a wire brush to remove dirt. Inspect before each use for proper assembly, wear, damage, modification or other issues that could affect safe use. If any problems are found, do not use until corrected.

Lubricate points of relative motion with a light weight general purpose lubricating oil. Wipe off any excess oil.

Set Up/Operation

1. Make sure workpieces are secure and cannot fall.
2. Loosen the three wing bolts. The tip of the wing bolt should not contact the workpiece when initially installed.
3. To open clamp, use one hand to hold the grip and press the feed screw release **1**. Use the other hand to pull the handle **2** and open the jaws. Stay clear of pinch points. (Figure 2).

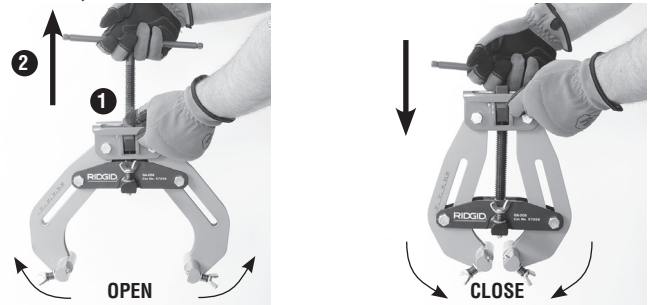
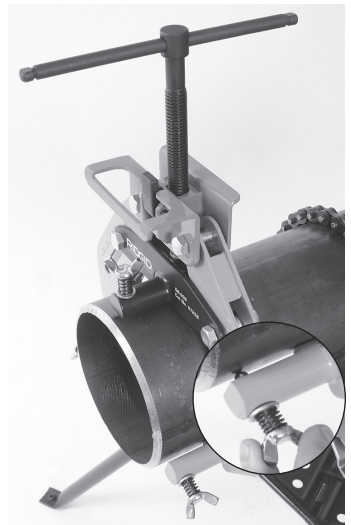


Figure 2 – Opening and Closing Clamp

4. Place the jaws around a cylindrical end of the workpiece with the wing bolts oriented towards the end. Push the handle to close the jaws (Figure 2). The three contact points should sit squarely on the workpiece surface. Tighten the handle to secure the clamp to the workpiece (Figure 3). Do not overtighten.
5. Tighten all the wing bolts until the tips lightly contact the workpiece surface. Do not overtighten (Figure 3 inset).



6. Loosen the handle (approximately 1 turn) and slide the pipe clamp so the wing bolts extend approximately 2" (50 mm) from the end of the workpiece (Figure 4). Tighten the handle and secure the clamp to the workpiece. Do not overtighten. Do not use handle extensions - the tool can be damaged.
7. Loosen one wing bolt (typically the upper wing bolt) 2-3 turns. Align the second workpiece with the first and place between the wing bolt tips, setting the desired gap between the workpieces. Tighten the loosened wing bolt.

Figure 3 – Clamp On Workpiece