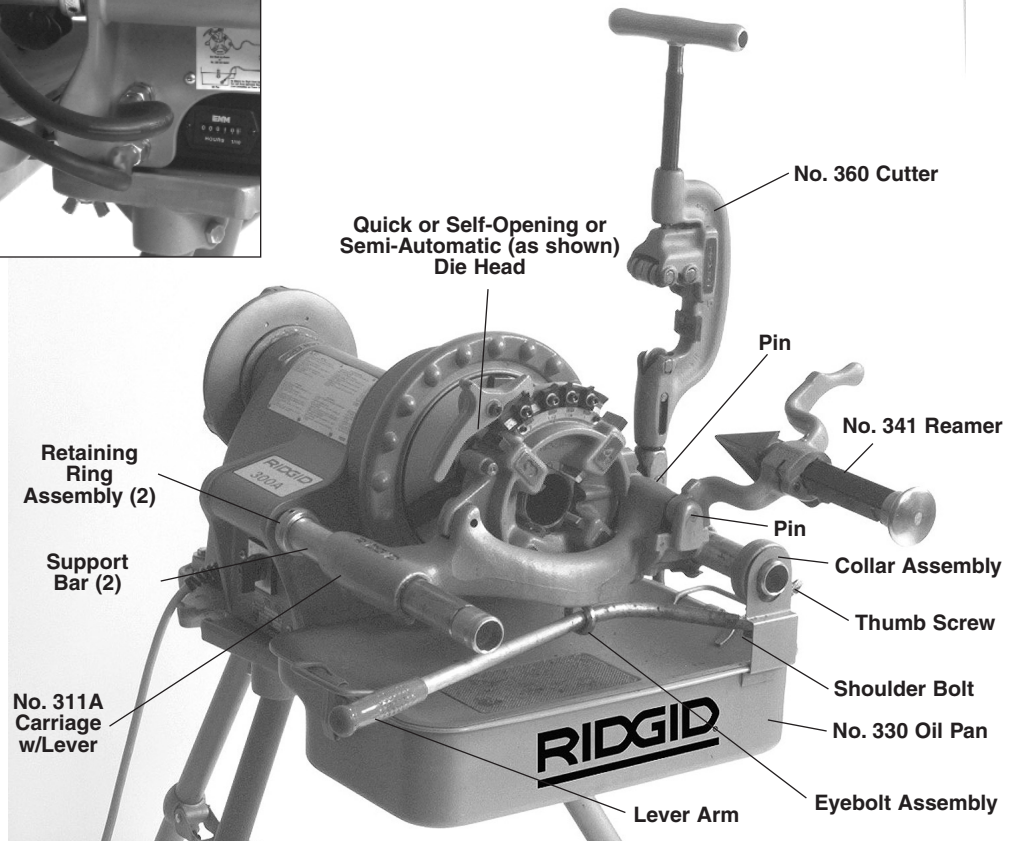
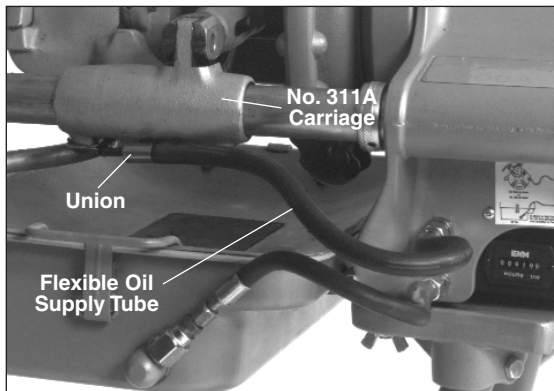




# Installing No. 311A Carriage, Die Head, No. 341 Reamer, No. 360 Cutter and No. 330 Oil Pan



**NOTE!** Disconnect Power Drive from power source before mounting No. 311A Carriage onto Power Drive.

1. Pull 2 Support Bars on Power Drive forward.
2. Slide 2 Retaining Ring Assemblies against Power Drive body and secure with 2 set screws.
3. Secure Eyebolt Assembly to No. 311A Carriage.
4. Slide Lever Arm through Eyebolt Assembly and secure to Collar Assembly with Shoulder Bolt.
5. Slide No. 311A Carriage and Collar Assembly onto Support Bars.
6. Tighten Collar Assembly Thumb Screw into second groove from end of Support Bar.
7. Insert Die Head Post into mating hole in Carriage.

**NOTE!** When fully inserted, springloaded ball will hold Die Head in place.

8. Install No. 360 Cutter and No. 341 Reamer and secure with pins.

9. Install No. 330 Oil Pan on Support Bars and lock in position with corner bracket. Connect nylon tube between lower fitting on Power Drive body and Union on side of Oil Pan.

10. When using Through-Head-Oiling Die Heads, connect flexible Oil Supply Tube between No. 311A Carriage Union and upper fitting on Power Drive body. When using other die heads, connect No. 309 Oil Spout.

11. Pour approximately 1 gallon (4 liters) of RIDGID Thread Cutting Oil into oil pan.

**NOTE!** Machine is assembled for right hand operation. For left hand operation, reverse connections on side of Power Drive body.

12. Install pipe. Refer to *Operation Using Hand Tools in Operator's Manual*.

**CAUTION** Connect oil line to Carriage when using Through-Head-Oiling Die Heads. Using other Die Heads with line connected could cause oil back-pressure damage.