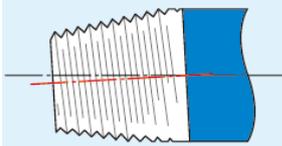
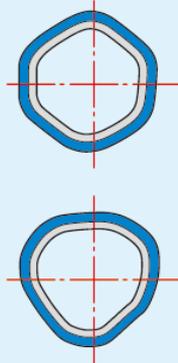


Although Asada threading machines are designed for producing accurate standard threads, defective threads may happen depending on the condition. Please refer information below in case when a defective thread occurs.

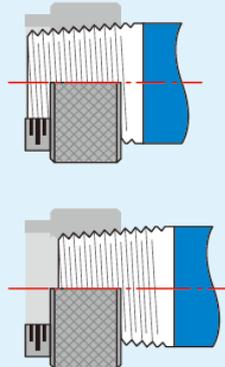
Single-Side Threads



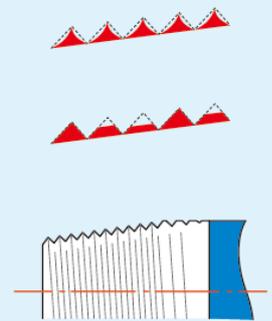
Multi-Angle Threads



Larger/Smaller Threads



Deformation of Threads



Cause

The cut surface of the pipe is not straight because of cutting by unsuitable way like Grinding machine.

Counter Measure

Use Pipe cutter on the threading machine or Band Saw for a straight cut.

Cause

The cut surface of the pipe is slanted or ridged, the dies are worn out, or use of unappropriated oil.

Counter Measure

Use Pipe cutter on the threading machine or Band Saw for a straight cut. Inspect the dies and oil regularly and replace if needed.

Cause

Failure of size selection of Die-Head.

Counter Measure

Inspect with a thread gauge after threading. In case of size failure, check size selection of Die-Head and adjust size gradually.

Cause

The dies are worn out or damaged. Use of unappropriated oil or centering failure of the machine.

Counter Measure

Replace the dies and oil, and regular check of the machine.



Ask your customers in case of trouble report

In case if oil doesn't come out:

Check!

- 1) Is the oil tank full of oil?
- 2) Are Suction pipe, Strainer, and Filter not clogged?
- 3) Is Pump in order?

In case if power is not enough:

Check!

- 1) Has the power voltage not dropped?
- 2) Is the extension cord not too long or thin?

In case if threads are not normal:

Check!

- 1) Is threading oil not contaminated or dirty?
- 2) Are there chipping of Dies?
- 3) Is the cutting surface of the pipe not oblique?

In case if threading fails:

Check!

- 1) Is Dies' size correct?
- 2) Do Die numbers match with those on Die-Head?
- 3) Is the size selection of Die-Head is correct?

