

# Threading Lightwall Pipe

## Welding on Dyna-Flow® Pipe

Allied Tube & Conduit's **BLT/XL** "lightwall threadable" sprinkler pipe, is manufactured to provide exceptional hydraulics and economy to the end user. However, these properties that make **BLT/XL** such an exceptional value also raise concerns. The National Fire Protection Association recommends that all threads on lightwall threadable pipe be checked with thread gauges for conformity with ANSI B1.20.1.

Allied also recognizes these concerns and would like to suggest several techniques that have been employed to produce clean, sharp threads on lightwall pipe.

Incorporating some or all of these suggestions will serve to facilitate the threading process.

1. Change cutting oil regularly. (RIGID recommends a change every 40 hours of use.)
2. Keep oil reservoir clean of all metal shavings.
3. Maximize the volume of oil being applied to the pipe.
4. Use high-sulfur (3 – 6%) content cutting oil (ie; Chevron Fluid Grade 21, Texaco SulTex D, Metalub MelKut 6012). This will serve to improve adhesion to the pipe and provide better lubrication.
5. Use clean, sharp dies. Worn dies cause excessive friction and wear.
6. Make sure pipe is properly supported and that chasers are properly aligned.
7. Visually inspect threads for sharpness, realizing that the appearance of some "flat" threads are expected with this type of pipe. Test basic fit with approved thread gauge and fittings.