



No. 541
No. 542



No. 713
No. 913



No. 714 (914) Style Receding Die Head.

Die Heads for Model 1224

Catalog No.	Model No.	Description	Weight	
			lb.	kg
26132	711	Universal Self-Opening R.H., NPT	¼-2	5.6
26142	713	Universal Quick-Opening L.H., NPT	¼-2	5.6
26152	714	Receding Self-Opening R.H., NPT	2½-4	13.6
26137	911	Universal Self-Opening R.H., BSPT	¼-2	5.6
26147	913	Universal Quick-Opening L.H., BSPT	¼-2	5.6
26157	914	Receding Self-Opening R.H., BSPT	2½-4	13.6
26162	541	Quick-Opening Bolt L.H./R.H.	¼-1	3.4
26167	542	Quick-Opening Bolt L.H./R.H.	1½-2	4.2
55447	725	Cut-Grooving Die Head	2½-4	13.6
57497	—	2½"-3½" Grooving Die Set	2½-3½	1
57507	—	2½"-3½" Grooving Bit only	—	—
57492	—	4" Grooving Die Set	4	1
57502	—	4" Grooving Bit only	—	—
55452	766	Blade Type Cutter	¾-4	9.5
58712	—	Cut-Off Tool Bit	—	—

Note: Die Heads do not include dies. All Die Heads are through-head oiling.

Pipe Dies 2½"-4" (for ¼"-2" see pages 4.30-4.31)

Catalog No.	Description	Capacity		Weight	
		in.	mm	lb.	kg
26192	1224 H.S. Dies NPT	2½-4	62-100	2¼	1.0
33642	1224 H.S. Dies BSPT	2½-4	62-100	2¼	1.0
31827	1224 H.S. NPT Dies for Plastic-Coated Pipe	2½-4	62-100	2¼	1.0
31832	1224 H.S. BSPT Dies for Plastic-Coated Pipe	2½-4	62-100	2¼	1.0
32237	1224 H.S. Dies NPT for PVC	2½-4	62-100	2	1.0
32242	1224 H.S. Dies BSPT for PVC	2½-4	62-100	2	1.0
33057	1224 H.S. Dies NPT for Stainless Steel	2½-4	62-100	2	1.0
33072	1224 45° Beveling Dies	2½-4	62-100	2	1.0
33077	1224 37½° Beveling Dies	2½-4	62-100	2	1.0
44992	1224 Bevel Guide Set	2½-4	62-100	2	1.0
44997	1224 37½° Bevel Bit Only	—	—	—	—
45002	1224 45° Bevel Bit Only	—	—	—	—

Note: NPSM threads are made with NPT dies by adjusting the die head. See manual for details

Accessories

Catalog No.	Model No.	Description	Capacity		Weight	
			in.	mm	lb.	kg
26212	764	¼"-4" Wheel-Type Cutter	—	—	19	8.6
26217	744	¼"-4" Blade-Type Reamer	—	—	13	5.9
34577	—	¼"-4" Reamer Blade	—	—	½	0.2
26187	—	Jaw Insert and Roll Set for PE-Coated Pipe	—	—	¼	0.1
51005	819	Nipple Chuck (See page 4.33)	½-2	12-50	10½	4.8
34157	419	Nipple Chuck 2½" NPT	—	—	5½	2.5
34162	419	Nipple Chuck 3" NPT	—	—	5½	2.5
34167	419	Nipple Chuck 4" NPT	—	—	5½	2.5
34172	419	Nipple Chuck 2½" BSPT	—	—	5½	2.5
34177	419	Nipple Chuck 3" BSPT	—	—	5½	2.5
34182	419	Nipple Chuck 4" BSPT	—	—	5½	2.5
61122	840A	Universal Drive Shaft	—	—	31	14.1
26707	—	Gear Grease (1224 & 1822)	—	—	1	0.5



Pipe Dies for Machine Die Heads

Pipe Dies for use in Universal Die Heads (Nos. 504A, 711, 713, 811A, 815A, 816, 817 and 842)

	(NPT)				(NPSM)			
	Nominal Pipe Size-Threads Per Inch				Nominal Pipe Size-Threads Per Inch			
Die Material or Type	1/8"-27	1/4"-3/8"-18	1/2"-3/4"-14	1"-2"-11 1/2	1/8"-27	1/4"-3/8"-18	1/2"-3/4"-14	1"-2"-11 1/2
Alloy RH	47735	47740	47745	47750	-	-	-	-
High-Speed RH	47755	47760	47765	47770	47845	47850	47855	47860
High-Speed •LH	39587	47810	47815	47820	-	-	-	-
H.S. For Stainless Steel RH	47775	47780	47785	47790	-	-	-	-
H.S. For Cast Iron	-	-	-	70740	-	-	-	-
H.S. For PVC RH	-	-	70745	70750	-	-	-	-
H.S. For Plastic Coated Pipe RH	-	-	50012	31822	-	-	-	-

• Requires left hand model die head.

Note: Use HS for PVC and RH for brass pipe.

Pipe Dies for use in British Universal Die Heads (Nos. 504A, 811A, 815A, 816, 817, 856, 911 and 913)

	(BSPT)				(BSPP)			
	Nominal Pipe Size-Threads Per Inch				Nominal Pipe Size-Threads Per Inch			
Die Material or Type	1/8"-28	1/4"-3/8"-19	1/2"-3/4"-14	1"-2"-11	1/8"-28	1/4"-3/8"-19	1/2"-3/4"-14	1"-2"-11
Alloy RH	*66655	*66660	*66665	*66670	-	-	-	-
High-Speed RH	*66750	*66755	*66760	*66765	*66795	*66800	*66805	*66810
H.S. For Stainless Steel RH	*66770	*66775	*66780	*66785	-	-	-	*66830
H.S. For PVC RH	-	-	*70755	*70760	-	-	-	-
H.S. For PE-Coated RH	-	-	-	-	-	-	-	-

* Requires British model die head.

Conduit Dies for Universal Die Heads

	(ISO)		(BEC)		
	Nominal Conduit Size – Pitch in mm		Nominal Conduit Size – Threads Per Inch		
Die Material or Type	16-32mm-1.5	40-63mm-1.5	1/2"-5/8"-18	3/4"-1 1/4"-16	1 1/2"-2 1/2"-14
Alloy RH	50645	50650	66700	66705	66710

Pipe Dies for use in 500A Mono Die Heads

Die Material or Type	Nominal Pipe Size-Threads Per Inch(BSPP)								
	1/8"-27	1/4"-18	3/8"-18	1/2"-14	3/4"-14	1"-11 1/2	1 1/4"-11 1/2	1 1/2"-11 1/2	2"-11 1/2
(NPT)									
High-Speed RH	50700	50705	50710	50715	50720	50725	50730	50735	50740
H.S. For Stainless Steel RH	50745	50750	50755	50760	50765	50770	50775	50780	50785
(NPSM)									
High-Speed RH	-	-	-	50895	50900	50905	50910	50915	50920

Pipe Dies for 1/4"-3/8" Dual Die Heads (No. 502)

Die Material or Type	(NPT) Nominal Pipe-Threads Per Inch
	1/4"-3/8"-18 TPI
High-Speed RH	47940

Pipe Dies for Nos. 514 (LH), 515 (RH), 555 (RH), and 1/2"-3/4" Dual Die Heads

Die Material or Type	(NPT)			(BSPT)	
	Nominal Pipe Size-Threads Per Inch			Nominal Pipe Size-Threads Per Inch	
	1/8"-27	1/4"-3/8"-18	1/2"-3/4"-14	1/4"-3/8"-19	1/2"-3/4"-14
Alloy RH	-	47875	47880	66955	66880
High-Speed RH	47855	47890	47895	66905	66970
H.S. For Stainless Steel RH	47900	47905	47910	-	66920

Pipe Dies, Bolt Dies for Machine Die Heads

Pipe Dies for No. 424 and 415 Die Head

Die Material or Type	(NPT)	(NPSM)
	Pipe Size-TPI	Pipe Size-TPI
H.S. RH	2½"-4"x8 TPI 99545	2½"-4"x8 TPI 94220



Bolt Dies for Universal Die Heads (Nos. 504A, 711, 811A, 815A, 816, 817 and 911 Die Heads)

Rod Size – TPI	(UNC)	Rod Size – TPI	(UNF)	Rod Size – RH TPI	(BSW)
	RH High-Speed		RH High-Speed		High-Speed
¼"-20	48215	¼"-28	48295	¼"-20	*67880
⅝"-18	48220	-	-	⅝"-18	*67885
⅜"-16	48225	⅜"-24	48305	⅜"-16	*67890
⅞"-14	48230	⅞"-20	48310	⅞"-14	-
½"-13	48235	½"-20	48315	½"-12	*67900
⅝"-12	48240	⅝"-18	48320	⅝"-12	*67905
⅝"-11	48245	⅝"-18	48325	⅝"-11	*67910
¾"-10	48250	¾"-16	48330	¾"-10	*67915
⅞"-9	48255	⅞"-14	48335	⅞"-9	67920
1"-8	48260	1"-14NS	48340	1"-8	*67925
1½"-7	48265	1"-12	48375	1½"-7	-
1¼"-7	48270	1½"-12	48345	1¼"-7	*67935
1½"-6	48275	1¼"-12	48350	1½"-6	-
1½"-6	48280	1½"-12	48355	1½"-6	*67945
1¾"-5	48285	1½"-12	48360	1¾"-5	-
2"-4½	48290	-	-	2"-4½	67955

* Requires British model die head.

Bolt Dies for 500B, 532 and 542 Die Heads

(8 UN)	
Rod Size – TPI	RH High-Speed
1½"-8	49215
1¼"-8	49220
1¾"-8	49225
1½"-8	49230
1¾"-8	49240
1¾"	49245
2"-8	49250
(12 UN)	
2"-8	49345

Beveling Dies

For beveling pipe prior to welding. A set of beveling dies consists of three guide segments and one cutting segment.

Catalog No.	Description	Pipe Size		Used in Die Head	Weight	
		in.	mm		lb.	kg
52192	37½° Bevel Die Set	½-¾	12-20	Universal	1	0.5
50960	37½° Bevel Die Set	1-2	25-50	Universal	1	0.5
52202	45° Bevel Die Set	½-¾	12-20	Universal	1	0.5
50965	45° Bevel Die Set	1-2	25-50	Universal	1	0.5

Cut Grooving Dies

To cut groove pipe for mechanical type couplings, consult chart for sizes and die head information.

Catalog No.	Description	Pipe Size		Used in Die Head	Weight	
		in.	mm		lb.	kg
52217	Grooving Die Set	½-¾	12-20	Universal	1	0.5
50985	Grooving Die Set	1-2	25-50	Universal	1	0.5

Note: 2 ½" - 4 Beveling Dies are available for the No. 1224 threading Machine. See accessories for No. 1224.

Note: Universal Dies fit all Universal Die Heads.



See page 4.12



Keep dies used for stainless steel separate from those used with black iron to avoid material contamination.



Threading

Bolt Dies for 500B and 531, 532, 541 and 542 Die Heads (Continued)

(UNC)			(UNF)	
Rod Size – TPI	RH High-Speed	LH High-Speed	Rod Size – TPI	RH High-Speed
¼"-20	48605	—	¼"-28	48690
⅜"-18	48610	48915	⅜"-24	48695
⅝"-16	48615	48920	⅝"-24	48700
⅞"-14	48620	48925	⅞"-20	48705
½"-13	48625	48930	½"-20	48710
⅝"-12	48630	48935	⅝"-18	48715
⅞"-11	48635	48940	⅞"-18	48720
¾"-10	48640	48945	¾"-16	48725
⅞"-9	48645	48950	⅞"-14	48730
1"-8	48650	48955	1"-12	48735
1½"-7	48655	48960	1"-14NS	49305
1¼"-7	48660	48965	1½"-12	48740
1⅝"-6	48665	48970	1¼"-12	48745
1½"-6	48670	48975	1⅝"-12	—
1¾"-5	48675	—	1½"-12	48755
2"-4½	48680	48985	—	—

For use with 531, 541 and 500B ¼"-1" Die Heads

For use with 532, 542 and 500B 1⅝"-2" Die Heads



(BSW)	
Rod Size – TPI	RH High-Speed
¼"-20	—
⅜"-18	—
⅝"-16	67615
⅞"-14	67620
½"-12	67625
⅝"-12	—
⅞"-11	67635
¾"-10	67640
⅞"-9	67645
1"-8	67650
1½"-7	67655
1¼"-7	67660
1⅝"-6	67665
1½"-6	—
1⅝"-5	67675
1¾"-5	—
1⅝"-4½	67685
2"-4½	—

For use with 531, 541 and 500B ¼"-1" Die Heads

For use with 532, 542 and 500B 1⅝"-2" Die Heads

Dies for Rebar, for use in 500B, 531, 532, 541 and 542 Die Heads

Cat No. (UNC)		Cat No. (UNF)	
RH High-Speed	Rebar Size–TPI	RH High-Speed	Rebar Size–TPI
34077	⅝"-16	85850	1"-8
34082	½"-13	79120	1½"-7
34087	⅞"-11	85855	1⅝"-6
34092	¾"-10	—	—

Acme		(S.I.) Series A Metric			Series B Metric		(ISO) International Standards. Org.	
Rod Size – TPI	RH High-Speed	Rod Size Thread Pitch	RH High-Speed	LH High-Speed	Rod Size Thread Pitch	RH High-Speed	Rod Size Thread Pitch	RH High-Speed
		in. mm			in. mm		in. mm	
—	—	M6-1.0	49795	49845	—	—	M6-1.0	50040
—	—	M7-1.0	—	49850	—	—	M7-1.0	—
—	—	M8-1.25	49805	—	—	—	M8-1.25	50050
—	—	M9-1.25	—	—	—	—	M9-1.25	—
—	—	M10-1.5	49815	—	M10-1.0	50560	M10-1.5	50060
—	—	M11-1.5	49820	49870	—	—	M11-1.5	—
¾"-6	49610	M12-1.75	49825	49875	M12-1.5	85865	M12-1.75	50070
—	—	M14-2.0	49830	—	M14-1.5	—	M14-2.0	50075
—	—	M16-2.0	49835	—	M16-1.5	50575	M16-2.0	50080
—	—	M18-2.5	49840	49890	—	—	M18-2.5	50085
—	—	M20-2.5	50480	49895	M20-1.5	50585	M20-2.5	50090
—	—	M22-2.5	50485	49900	M22-1.5	50590	M22-2.5	50095
1"-5	49585	M24-3.0	50490	49905	M24-2.0	85870	M24-3.0	50100
—	—	M25-3.0	50495	—	—	—	M27-3.0	50105
—	—	M26-3.0	—	—	—	—	M30-3.5	50110
—	—	M27-3.0	50500	—	M27-2.0	—	M33-3.5	50115
—	—	M30-3.5	50505	49915	M30-2.0	—	M36-4.0	50120
1¼"-5	49600	M33-3.5	50510	—	—	—	M39-4.0	50125
—	—	M36-4.0	50515	49925	—	—	M42-4.5	50130
1⅝"-4	—	M39-4.0	50520	49930	—	—	M45-4.5	—
—	—	M42-4.5	50525	—	—	—	M48-5.0	50140
—	—	M45-4.5	50530	—	—	—	M52-5.0	—
—	—	M48-5.0	50540	—	—	—	—	—
—	—	M50-5.0	50545	—	—	—	—	—
—	—	M52-5.0	50550	—	—	—	—	—

For use with 531, 541 and 500B ¼"-1" Die Heads

For use with 532, 542 and 500B 1⅝"-2" Die Heads

For metric high-speed rebar dies, Series B, ISO, see price list.

