

Power Threading Machines



Model 1224 Threading Machine

- The Model 1224 threads a wide range of pipe including black, galvanized and plastic-coated pipe, together with stainless steel, IMC and heavy-wall conduit, as well as rod up to 30 Rockwell C.
- An induction motor helps minimize noise.
- A special capacitor-start / capacitor-run motor allows the 1224 to thread a full range of material where voltage drop is experienced.
- 1/4"-2" Universal Die Head; 2 1/2"-4" receding die head allows cutting of tapered or straight NPT/NPSM or BSPT/BSPP threads.
- Constant and proper lubrication of dies and workpiece with through-head oiling.

Specifications

- Nominal Pipe Capacity – 1/4"-2" (6mm-100mm) @ 36 RPM, 2-1/2"-4" (65mm-100mm) @ 12 RPM, 4"-6" (100mm-150mm) with 161 Geared Threader.
- Bolt Capacity – 1/4"-2" (6mm-50mm).
- Motor Control – Reverse/Off/Forward, heavy-duty rotary-type and integral foot switch.
- Gear Box – Two-speed gear box 3:1 ratio.
- Chuck – Hammer-type with replaceable rocker-action jaw inserts.
- Rear Centering Device – Cam action.
- Oiling Pump – Self-priming, gerotor-type, automatic-reversing, constant-flow.
- Oiling – Through die head.

Catalog No.	Model No.	Description	Die Head	RPM	Voltage (V)	Frequency (Hz)	Phase	Motor Type	Amp Draw (A)	Power	Weight	
											lb.	kg
26092	1224	1/2" - 4" NPT Hammer Chuck Machine	711/714	36/12	120	50 - 60	1	Induction	15	1 1/2 HP	509.0	231.0
26097	1224	1/2" - 4" NPT Hammer Chuck Machine	711/714	36/12	230	50 - 60	1	Induction	8	1 1/2 HP	509.0	231.0
26127	1224	1/2" - 4" BSPT Hammer Chuck Machine	911/914	36/12	120	50 - 60	1	Induction	15	1 1/2 HP	509.0	231.0
26112	1224	1/2" - 4" BSPT Hammer Chuck Machine	911/914	36/12	115	50 - 60	1	Induction	15	1700 W	463.0	210.0
26122	1224	1/2" - 4" BSPT Hammer Chuck Machine	911/914	36/12	230	50 - 60	1	Induction	8	1700 W	509.0	231.0
31442	1224	1/2" - 4" NPT Hammer Chuck Machine	711/714	36/12	230	50 - 60	1	Induction	8	1700 W	463.0	210.0

Standard Equipment

Catalog No. Model No.	26092 1224	26097 1224	26127 1224	26112 1224	26122 1224	31442 1224
26132 - Diehead, 711 SO Univ L/Dies	•	•				•
26152 - Diehead, 714 SO Recd L/Dies	•	•				•
26137 - Diehead, 911 SO BSPT L/Dies			•	•	•	•
26147 - Diehead, 913 QO BSPT L/Dies			•	•	•	
26192 - Dies, 1224 2-1/2"-4NPT HS	•	•				•
47745 - Dies, Univ 1/2-3/4 NPT	•	•				•
47750 - Dies, Univ 1-2 NPT	•	•				•
33642 - Dies, 1224 2-1/2"-4 BSPT HS			•	•	•	•
66665 - Dies, Univ 1-2 BSPT			•	•	•	•
66670 - Dies, Univ 1/2-3/4 BSPT			•	•	•	•
26212 - 1/4"-4" Wheel-Type Cutter	•	•	•	•	•	•

Catalog No. Model No.	26092 1224	26097 1224	26127 1224	26112 1224	26122 1224	31442 1224
26217 - 1/4"-4" Blade-Type Reamer	•	•	•	•	•	•
33125 - Wheel, Cutter F229 3 & 4 HD	•	•	•	•	•	•
46030 - Key, Hex 3/16	•	•	•	•	•	•
46040 - Key, Hex 7/32	•	•	•	•	•	•
46190 - Key, Hex 1/4	•	•	•	•	•	•
70835 - Nu-Clear Oil	•	•	•		•	
83975 - Wrench, 3/4 COMB	•	•	•	•	•	
53693 - Tool Box	•	•	•	•	•	•
11931 - Thread Cutting Oil				•		•
26212 - Cutter, 764 1/4"-4" Pipe						•



THREADING



Model 541
Model 542



Model 713
Model 913



Model 714 (914) Style Receding Die Head

Stands

Catalog No.	Model No.	Description	Weight	
			lb.	kg
22563	–	Steel Cabinet	42	19.30
92457	100A	Universal Leg & Tray Stand	75	34.50
92462	150A	Universal Wheel & Tray Stand	103	46.70
92467	200A	Universal Wheel & Cabinet Stand	104	47.20

Die Heads

Catalog No.	Model No.	Description	Capacity		Weight	
			in.	mm	lb.	kg
26132	711	Diehead, 711, SO Univ. L/Dies	1/4 - 2	6.4 - 50.8	12.2	5.6
26137	911	Universal Self-Opening R.H., BSPT	1/4 - 2	6.4 - 50.8	12.2	5.6
26142	713	Universal Quick-Opening L.H., NPT	1/4 - 2	6.4 - 102	12.2	5.6
26147	913	Universal Quick-Opening L.H., BSPT	1/4 - 2	6.4 - 50.8	12.2	5.6
26152	714	Diehead, 714 SO Recd L/Dies	2 1/2 - 4	6.4 - 50.8	30.0	13.6
26157	914	Receding Self-Opening R.H., BSPT	2 1/2 - 4	6.4 - 102	30.0	13.6
26162	541	Quick-Opening Bolt L.H./R.H.	1/4 - 1	6.4 - 25.4	7.5	3.4
26167	542	Quick-Opening Bolt L.H./R.H.	1 1/8 - 2	29 - 50.8	9.2	4.2
55447	725	Cut-Grooving Die Head	2 1/2 - 4	6.4 - 102	30.0	13.6
55452	766	Blade Type Cutter	3/4 - 4	6.4 - 88.9	21.0	9.5
57492	–	4" Grooving Die Set*	–	–	2.2	1.0
57497	–	2 1/2"-3 1/2" Grooving Die Set*	2 1/2 - 3 1/2	102	2.2	1.0
57502	–	4" Grooving Bit only*	–	–	–	–
57507	–	2 1/2"-3 1/2" Grooving Bit only*	–	19 - 102	–	–
58712	–	Cut-Off Tool Bit	–	–	–	–

Not for use with stainless steel

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

Pipe Dies

Catalog No.	Description	Capacity		Weight	
		in.	mm	lb.	kg
26192	Dies. 1224 2 - 1/2" - 4 NPT HS	2 1/2 - 4	62 - 100	2.2	1.0
31827	1224 H.S. NPT Dies for Plastic-Coated Pipe	2 1/2 - 4	62 - 100	2.2	1.0
31832	1224 H.S. BSPT Dies for Plastic-Coated Pipe	2 1/2 - 4	62 - 100	2.2	1.0
32237	1224 H.S. Dies NPT for PVC	2 1/2 - 4	62 - 100	2.0	1.0
32242	1224 H.S. Dies BSPT for PVC	2 1/2 - 4	62 - 100	2.0	1.0
33057	1224 H.S. Dies NPT for Stainless Steel	2 1/2 - 4	62 - 100	2.0	1.0
33072	1224 45° Beveling Dies	2 1/2 - 4	62 - 100	2.0	1.0
33077	1224 37 1/2° Beveling Dies	2 1/2 - 4	62 - 100	2.0	1.0
33642	1224 H.S. Dies BSPT	2 1/2 - 4	62 - 100	2.2	1.0
44992	1224 Bevel Guide Set	2 1/2 - 4	62 - 100	2.0	1.0
44997	1224 37 1/2° 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
51005	819	Nipple Chuck Complete, 1/2" - 2" NPT	0.5 - 2.0	6.0 - 50.0	10.5	4.8
61122	840A	Universal Drive Shaft	–	–	31.0	14.1
26187	–	Jaw Insert and Roll Set for PE-Coated Pipe	–	–	0.2	0.1
26212	764	1/4" - 4" Wheel-Type Cutter	–	–	19.0	8.6
26217	744	1/4" - 4" Blade-Type Reamer	–	–	13.0	5.9
26707	–	Gear Grease (1224 & 1822)	–	–	1.0	0.5
34157	419	Nipple Chuck 2 1/2" NPT	–	–	5.5	2.5
34162	419	Nipple Chuck 3" NPT	–	–	5.5	2.5
34167	419	Nipple Chuck 4" NPT	–	–	5.5	2.5
34172	419	Nipple Chuck 2 1/2" BSPT	–	–	5.5	2.5
34177	419	Nipple Chuck 3" BSPT	–	–	5.5	2.5
34182	419	Nipple Chuck 4" BSPT	–	–	5.5	2.5
34577	–	1/4" - 4" Reamer Blade	–	–	0.5	0.2



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