

# THREADING

## Pipe Dies for Machine Die Heads



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

Die Material or Type	(NPT)				(NPSM)			
	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"-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 (Models 504A, 811A, 815A, 816, 817, 856, 911 and 913)

Die Material or Type	(BSPT)				(BSPP)			
	Nominal Pipe Size-Threads Per Inch				Nominal Pipe Size-Threads Per Inch			
	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

Die Material or Type	(ISO)		(BEC)		
	Nominal Conduit Size – Pitch in mm		Nominal Conduit Size – Threads Per Inch		
	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 Model 500A Mono Die Heads

Die Material or Type	Nominal Pipe Size-Threads Per Inch (NPT)								
	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

Die Material or Type	(NPT) Nominal Pipe-Threads Per Inch
	High-Speed RH

### Pipe Dies for Models 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	-	-	47880	66955	66880
High-Speed RH	47885	47890	47895	66905	23297
H.S. For Stainless Steel RH	47900	47905	47910	-	66920



# Pipe Dies, Bolt Dies for Machine Die Heads

## Pipe Dies for Models 424 and 415 Die Head

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



## Bolt Dies for Universal Die Heads (Models 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
¾" - 16	48225	¾" - 24	48305	¾" - 16	*67890
7/16" - 14	48230	7/16" - 20	48310	7/16" - 14	-
½" - 13	48235	½" - 20	48315	½" - 12	*67900
9/16" - 12	48240	9/16" - 18	48320	9/16" - 12	*67905
⅝" - 11	48245	⅝" - 18	48325	⅝" - 11	*67910
¾" - 10	48250	¾" - 16	48330	¾" - 10	*67915
7/8" - 9	48255	7/8" - 14	48335	7/8" - 9	67920
1" - 8	48260	1" - 14NS	48340	1" - 8	*67925
1⅛" - 7	48265	1" - 12	48375	1⅛" - 7	-
1¼" - 7	48270	1⅛" - 12	48345	1¼" - 7	*67935
1⅝" - 6	48275	1¼" - 12	48350	1⅝" - 6	-
1½" - 6	48280	1⅝" - 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 Models 500B, 532 and 542 Die Heads

(8 UN)	
Rod Size – TPI	RH High-Speed
1⅛" - 8	49215
1¼" - 8	49220
1⅝" - 8	49225
1½" - 8	49230
1¾" - 8	49240
1⅞" - 8	49245
2" - 8	49250
<b>(12 UN)</b>	
2" - 12	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: 2½" - 4 Beveling Dies are available for the Model 1224 threading Machine. See accessories for Model 1224.

Note: Universal Dies fit all Universal Die Heads.



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**Bolt Dies for Models 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
⅝"-18	48610	48915	⅝"-24	48695
⅜"-16	48615	48920	⅜"-24	48700
⅞"-14	48620	48925	⅞"-20	48705
½"-13	48625	48930	½"-20	48710
⅝"-12	48630	48935	⅝"-18	48715
⅝"-11	48635	48940	⅝"-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
1⅜"-6	48665	48970	1¼"-12	48745
1½"-6	48670	48975	1⅜"-12	—
1¾"-5	48675	—	1½"-12	48755
2"-4½	48680	48985	—	—

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



◁ For use with Models 532, 542 and 500B 1⅜"-2" Die Heads

(BSW)	
Rod Size - TPI	RH High-Speed
¼"-20	—
⅝"-18	—
⅜"-16	67615
⅞"-14	67620
½"-12	67625
⅝"-12	—
⅝"-11	67635
¾"-10	67640
⅞"-9	67645
1"-8	67650
1½"-7	67655
1¼"-7	67660
1⅜"-6	67665
1½"-6	—
1⅝"-5	67675
1¾"-5	—
1⅞"-4½	67685
2"-4½	—

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

◁ For use with Models 532, 542 and 500B 1⅜"-2" Die Heads

**Dies for Rebar, for use in Models 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	⅝"-11	85855	1⅜"-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
1⅜"-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 Models 531, 541 and 500B ¼"-1" Die Heads

◁ For use with Models 532, 542 and 500B 1⅜"-2" Die Heads

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

