

Pipe Dies

Selection: Models 00-R, 11-R, 12-R, 0-R,
Ratchet Threaders or 30A, 31A 3-Way Pipe Threaders



Die Material or Type	Catalog No.								
	Nominal Pipe Size – Threads Per Inch								
	1/8-27	1/4-18	3/8-18	1/2-14	3/4-14	1-11½	1¼-11½	1½-11½	2-11½
(NPT) National Pipe Taper									
Alloy RH	37810	37815	37820	37825	37830	37835	37840	37845	37850
High-Speed RH	37855	37860	37865	37870	37875	37880	37885	37890	37895
High-Speed LH	–	38050	38055	38060	38065	38070	38075	38080	38085
H.S. For Stainless Steel RH	37900	37905	37910	37915	37920	37925	37930	37935	37940
H.S. For PVC RH	–	–	70685	70690	70695	70700	70705	70710	70715
HS Reversible RH*	–	–	–	49707	49712	49717	49722	49727	–
(NPSM) National Pipe Straight Mechanical									
Alloy RH	37945	37950	37955	37960	37965	37970	37975	37980	37985
(API) American Petroleum Institute***									
High-Speed RH			70720	70725	70730				
(BSPT) British Standard Pipe Taper**									
	1/8-28	1/4-19	3/8-19	1/2-14	3/4-14	1-11	1¼-11	1½-11	2-11
Alloy RH	45848	45853	45858	45863	45868	45873	45878	45883	45888
High-Speed RH	66310	66315	66320	66325	66330	66335	66340	66345	66350
High-Speed LH	66405	66410	66415	66420	66425	66430	66435	–	66445
HS Reversible RH*	–	–	56337	56342	56347	56352	–	–	56367
(BSPP) British Standard Pipe Parallel**									
Alloy RH	66190	66195	66200	66205	66210	66215	66220	66225	66230

* Dies can be reversed in die head for close-to-wall threading.

** Requires British Die Head.

*** Requires API Die Head.

ISO International Standards Organization	Nominal Conduit Size in mm – Thread Pitch in mm			
	20-1.5	25-1.5	32-1.5	40-1.5
Alloy RH	85830	76305	85835	76315

Requires 11-R ISO Die Head, see page 4.6.

BEC British Electrical Conduit (1)	Nominal Conduit Size – Threads Per Inch					
	1/2-18	5/8-18	3/4-16	1-16	1¼-16	1½-14
Alloy RH	66155	66160	–	–	66175	–

(1) Requires 11-R BEC Die Head.

Bolt Threaders Button Dies

Selection: Model 00-RB Ratchet Bolt Threaders,
or 31B, 33B, 35B, 37B 3-Way Bolt Threaders

Die Material or Type	Catalog No.									
	Rod Diameter – Threads Per Inch									
(UNC) Unified National Course	1/4-20	5/16-18	3/8-16	7/16-14	1/2-13	5/8-12	3/4-11	7/8-10	1-9	1-8
Alloy RH	38335	38340	38345	38350	38355	38360	38365	38370	38375	38380
(UNF) Unified National Fine	1/4-28	5/16-24	3/8-24	7/16-20	1/2-20	5/8-18	3/4-16	7/8-14	1-12	
Alloy RH	38385	38390	38395	38400	38405	38410	38415	38420	38425	15317



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Pipe Dies for Machine Die Heads



Pipe Dies for use in Universal Die Heads (Models 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 (Models 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-15	40-63mm-15	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

	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 (Model 502)

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

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

	(NPT)			(BSPT)	
	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	1/4"-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
Die Material or Type	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)

(UNC)		(UNF)		(BSW)	
Rod Size – TPI	RH High-Speed	Rod Size – TPI	RH High-Speed	Rod Size – RH TPI	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
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
1⅜" - 6	48275	1¼" - 12	48350	1⅜" - 6	-
1½" - 6	48280	1⅜" - 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
1⅜" - 8	49225
1½" - 8	49230
1¾" - 8	49240
1⅞" - 8	49245
2" - 8	49250
(12 UN)	
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
¾"-16	48615	48920	¾"-24	48700
7/16"-14	48620	48925	7/16"-20	48705
½"-13	48625	48930	½"-20	48710
⅞"-12	48630	48935	⅞"-18	48715
⅝"-11	48635	48940	⅝"-18	48720
¾"-10	48640	48945	¾"-16	48725
7/8"-9	48645	48950	7/8"-14	48730
1"-8	48650	48955	1"-12	48735
1 ⅛"-7	48655	48960	1"-14NS	49305
1 ¼"-7	48660	48965	1 ⅛"-12	48740
1 ⅝"-6	48665	48970	1 ¼"-12	48745
1 ¾"-6	48670	48975	1 ⅝"-12	-
1 ⅞"-5	48675	-	1 ¾"-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 1 ⅛"-2" Die Heads

(BSW)	
Rod Size - TPI	RH High-Speed
¼"-20	-
⅝"-18	-
¾"-16	67615
7/16"-14	67620
½"-12	67625
⅞"-12	-
⅝"-11	67635
¾"-10	67640
7/8"-9	67645
1"-8	67650
1 ⅛"-7	67655
1 ¼"-7	67660
1 ⅝"-6	67665
1 ¾"-6	-
1 ⅞"-5	67675
1 ⅞"-5	-
1 ⅞"-4½	67685
2"-4½	-

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

For use with Models 532, 542 and 500B 1 ⅛"-2" Die Heads

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

Cat No.		Cat No.	
(UNC)		(UNF)	
RH High-Speed	Rebar Size– TPI	RH High-Speed	Rebar Size– TPI
34077	¾"-16	85850	1"-8
34082	½"-13	79120	1 ⅛"-7
34087	⅝"-11	85855	1 ⅝"-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 in. mm	RH High-Speed	LH High-Speed	Rod Size Thread Pitch in. mm	RH High-Speed	Rod Size Thread Pitch in. mm	RH High-Speed
-	-	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
1 ¼"-5	49600	M33-3.5	50510	-	-	-	M39-4.0	50125
-	-	M36-4.0	50515	49925	-	-	M42-4.5	50130
1 ⅝"-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 1 ⅛"-2" Die Heads

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