

## THREADING

- Dependable heavy duty machines for maximum up-time, superior quality threads and minimal threading time.
- Industry's widest selection of hand and power threading equipment.
- Manual "hammer" type chuck and "auto-chuck" models.







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Nipple Chucks/Adapters	–	–	4.31



See page 4.12

## Threader Selection

Pipe Threads (inches)				Bolt Threads			Model	Page No.	
NPT	BSPT	NPSM	BSPP	UNF	UNC	ACME			
1/8-1	1/8-1	1/8-1	—	1/4-1	1/4-1	—	 <b>Manual Ratchet Threaders</b>	00-RB	4.4
1/8-1 1/4	1/8-1 1/4	1/8-1 1/4	1/8-1 1/4	—	—	—		11-R	4.3
1/8-2	1/8-2	1/2-2	1/4-2	—	—	—		12-R	4.3
1/2-1	1/2-1	1/2-1	1/2-1	—	—	—		31-A Series*	4.3
1-2	1-2	—	—	—	—	—	 <b>Receding Threaders</b>	65-R	4.8
2 1/2-4	2 1/2-4	—	—	—	—	—		141	4.10
4-6	4-6	—	—	—	—	—		161	4.10
1/8-1 1/4	1/8-1 1/4	1/8-1 1/4	3/8-1	—	—	—	 <b>Power Drives</b>	600-1	4.13
1/8-2	1/8-2	1/2-2	1/4-2	—	—	—		690-1	4.14
1/8-2	1/8-2	1/8-2	1/4-2	1/4-1	1/4-1	—		700	4.15
1/8-2	1/8-2	1/8-2	1/4-2	1/4-2	1/4-2	3/4-1 3/8		300	4.16
1/8-2	1/8-2	1/8-2	1/4-2	1/4-2	1/4-2	3/4-1 3/8	 <b>Threading Machines</b>	300 Compact	4.23
1/8-2	1/8-2	1/8-2	1/4-2	5/16-2	5/16-2	5/16-2		535-A	4.18
1/8-2	1/8-2	1/8-2	1/4-2	1/4-2	1/4-2	3/4-1 3/8		535	4.20
1/8-2	1/8-2	1/8-2	1/4-2	1/4-2	1/4-2	3/4-1 3/8		1215	4.22
1/4-4	1/4-4	1/8-2	1/4-2	1/4-2	1/4-2	3/4-1 3/8		1224	4.26

Minimum wall thickness for threading is Schedule 40.

\* Standard configuration but can use any 12-R dies.

See page 4.12



# Manual Ratchet Threaders



## EXPOSED RATCHET THREADER SETS

All matched Threader/Sets include Die Heads, Ratchet Assembly, Ratchet Handle and Alloy Dies. All Threader Sets use same 12-R Dies in Die Head.

- Model 00-R: Capacity 1/8" - 1" without carrying case.
- Model 12-R: Capacity 1/8" - 2" with carrying case.

Catalog No.	Model No.	Description	Die Heads Include		Weight	
			in.	mm	lb.	kg
36345	00-R		1/2 - 1	12 - 25	10	4.5
36355			3/8 - 1	10 - 25	1 1/4	5.1
36375			1/8 - 1	3 - 25	13 3/4	6.2
36480	12-R	NPT	1/2 - 1 1/4	12 - 32	23 3/4	10.8
36475			1/2 - 2	12 - 50	34 3/4	15.8
36505			1/8 - 2	3 - 50	45 1/2	20.7
55207*			1/2 - 2	12 - 50	35 1/2	16.1
65175	00-R		1/2 - 1	12 - 25	10	4.5
65255	12-R	BSPT	1/2 - 2	12 - 50	34 3/4	15.8
65285			1/8 - 2	3 - 50	45 1/2	20.7
36510			NPSM	1/2 - 2	12 - 50	34 3/4

\*For plastic-coated pipe



Model 11-R

## ENCLOSED RATCHET THREADER SET

- All matched Threader/Sets include Die Heads, Ratchet Assembly, Ratchet Handle and Alloy Dies. All Threader Sets use same 12-R Dies in Die Head.
- No 11-R capacity: 1/8" - 1 1/4".

Catalog No.	Model No.	Description	Die Heads Include		Weight	
			in.	mm	lb.	kg
36390	11-R	NPT	1/2 - 1 1/4	12-32	16	7.3

## RATCHET & HANDLE ONLY

- Ratchet knob indicates forward and reverse.
- Die heads snap in from both sides and lock in place.



Catalog No.	Model No.	Description	Type of Ratchet
38540	00-RB & 00-R		Exposed
37777	11-R		Enclosed
38550	11-R	Ratchet & Handle Only	Enclosed
30118	12-R		Exposed
38535	0-R		Exposed



See page 4.12

# Manual Ratchet Threaders

## THREE-WAY PIPE THREADERS

- Each model cuts three thread sizes and uses 12-R ratchet threader dies.



Catalog No.	Model No.	Capacity		Dies Used	Weight	
		in.	mm		lb.	kg
36540	31-A NPT	½ - 1	12 - 25	RH Alloy - NPT	10	4.6
36550		½ - 1	12 - 25	RH High Speed - NPT		
36555		½ - 1	12 - 25	RH High Speed For Stainless Steel - NPT		
65320	31-A BSPT	½ - 1	12 - 25	RH Alloy BSPT		
36560	31-A NPSM	½ - 1	12 - 25	RH Alloy - NPSM		

## EXPOSED RATCHET BOLT THREADER SETS

- No. 00-RB: Capacity 1/4"-1".
- All matched threader sets include button die heads, ratchet assembly (00-R) and ratchet handle. Button dies can be reversed to thread close to bolt shoulder or head.



Catalog No.	Model No.	Description	No. Die Heads Complete	Thread Type	Capacity Range		Weight	
					in.	mm	lb.	kg
36680	00-RB	Ratchet Bolt Threader	10	UNC	¼ - 1	6 - 25	20	9.1
36690			10	UNF	¼ - 1	6 - 25		

## CARRYING CASES

- Helps keep die sets organized.



Catalog No.	Description	Thread Type	Length		Height		Weight	
			in.	mm	in.	mm	lb.	kg
38605	Metal Case		19 ⅝	497	3 ⅜	81	7 ½	3.4
38610			19 ⅝	485	3 ⅜	81		
38615			25 ⅝	650	6 7/8	158	7 ¾	3.51
38620			24 ⅝	612	9 11/16	246		
38625	Metal Case (Holds 6 Die Heads)		25 7/8	657	6 ½	165	13	5.9
97375	Metal Case (Holds 9 Die Heads)		24 ⅝	619	10	254	15	6.8
21218	Plastic Case		25	635	14	355	6	2.72

Cases contain no die heads

See page 4.12



# Die Heads

**MODELS 00-R, 12-R, 11-R & 00-RB**  
**Selection: North American Standards**



	Catalog No.									
	Nominal Pipe Size (in.)									
	1/8	1/4	3/8	1/2	3/4	1	1 1/4	1 1/2	2	
<b>Model No. 12-R</b>										
<b>(NPT)</b>										
Alloy RH	37375	37380	37385	37390	37395	37400	37405	37410	37415	
High-Speed LH	–	–	–	37435	37440	37445	37450	37455	37460	
High-Speed RH	37465	37470	37475	37480	37485	37490	37495	37500	37505	
High-Speed for Stainless Steel RH	37510	37515	37520	37525	37530	37535	37540	37545	37550	
High-Speed for PVC RH	–	83450	83455	83460	83465	83470	83475	83480	83485	
High-Speed for Plastic Coated Pipe	–	–	–	51857	51862	51867	51872	51877	51882	
Alloy for IMC RH	–	–	–	92690	92695	92700	92705	92710	92715	
<b>(NPSM)</b>										
Alloy RH	37555	37560	37565	37570	37575	37580	37585	37590	37595	
<b>Model No. 11-R</b>										
<b>(NPT)</b>										
Alloy RH	37025	37030	37035	37040	37045	37050	37055	20923	20943	
High-Speed RH	37095	37100	37105	37110	37115	37120	37125	20928	20948	
High-Speed for Stainless Steel RH	37130	37135	37140	37145	37150	37155	37160	20933	20953	
<b>(NPSM)</b>										
Alloy RH	37165	37170	37175	37180	37185	37190	37195	20938	20958	
<b>Model No. 00-R</b>										
<b>(NPT)</b>										
Alloy RH	36875	36880	36885	36890	36895	36900	–	–	–	
High-Speed RH	36935	36940	36945	36950	36955	36960	–	–	–	
High-Speed for Stainless Steel RH	36965	36970	36975	36980	36985	36990	–	–	–	
<b>(NPSM)</b>										
Alloy RH	36995	37000	37005	37010	37015	37020	–	–	–	
API High-Speed	–	–	83435	68775	68780	–	–	–	–	
<b>Model No. 00-RB</b>										
	<b>1/4</b>	<b>5/16</b>	<b>3/8</b>	<b>7/16</b>	<b>1/2</b>	<b>9/16</b>	<b>5/8</b>	<b>3/4</b>	<b>7/8</b>	<b>1</b>
	<b>20 TPI</b>	<b>18 TPI</b>	<b>16 TPI</b>	<b>14 TPI</b>	<b>13 TPI</b>	<b>12 TPI</b>	<b>11 TPI</b>	<b>10 TPI</b>	<b>9 TPI</b>	<b>8 TPI</b>
<b>(UNC)</b>										
Alloy RH	37610	37615	37620	37625	37630	37635	37640	37645	37650	37655
Alloy LH	–	–	–	37675	–	–	–	37695	–	–
<b>(UNF)</b>										
	<b>28 TPI</b>	<b>24 TPI</b>	<b>24 TPI</b>	<b>20 TPI</b>	<b>20 TPI</b>	<b>18 TPI</b>	<b>18 TPI</b>	<b>16 TPI</b>	<b>14 TPI</b>	<b>14 TPI</b>
Alloy RH	37710	37715	37720	37725	37730	37735	37740	37745	–	37755
Alloy LH	–	–	–	37775	37780	37785	37790	37795	37800	37805

Unless highlighted, all die heads come complete with selected dies and are set at the factory.  
 n Highlighted die heads require assembly with supplied dies.  
 All matched threader/sets include die heads, ratchet assembly, ratchet handle and specified dies.  
 n Not for manual hand threading.



12-R Exposed



11-R Enclosed



00-R Exposed



See page 4.12

## Die Heads

### RATCHET THREADERS – MODELS 00-R, 12-R, 11-R Selection: British & International Standards



	Catalog No.								
	Nominal Pipe Size (in.)								
	1/8	1/4	3/8	1/2	3/4	1	1 1/4	1 1/2	2
<b>Model No. 00-R</b>									
<b>(BSPT)</b>									
Alloy RH	65705	65710	65715	65720	65725	65730	–	–	–
High-Speed RH	65765	65770	65775	65780	65785	65790	–	–	–
<b>Model No. 12-R</b>									
<b>(BSPT)</b>									
Alloy RH	65950	65955	65960	65965	65970	65975	65980	65985	65990
High-Speed LH	–	–	–	–	–	66020	–	66030	66035
High-Speed RH	–	–	–	66040	66045	66050	66055	66060	66065
Alloy for JIS RH	–	–	–	92585	92590	92595	92600	92605	92610
<b>(BSPP)</b>									
Alloy RH	–	49932	49937	49942	49947	49952	–	49962	49967
<b>Model No. 11-R</b>									
<b>(BSPT)</b>									
Alloy RH	65550	65555	65560	65565	65570	65575	65580	–	–
High-Speed RH	–	–	65620	65625	65630	65635	65640	–	–
<b>(BSPP)</b>									
Alloy RH	–	–	65680	65685	65690	65695	65700	–	–

Unless highlighted, all die heads come complete with selected dies and are set at the factory.

□ Highlighted die heads require assembly with supplied dies.

All matched threader/sets include die heads, ratchet assembly, ratchet handle and specified dies.

#### SELECTION: BRITISH & INTERNATIONAL STANDARDS

	Catalog No.		
	Nominal Pipe Size (mm)		
	20 mm	25 mm	40mm
<b>Model No. 11-R</b>			
(ISO) Alloy RH	75005	75010	75020

See page 4.12



# Pipe Dies

Selection: Models 00-R, 11-R, 12-R, O-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	1-11 1/2	1 1/4-11 1/2	1 1/2-11 1/2	2-11 1/2
<b>(NPT) National Pipe Taper</b>									
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	–
<b>(NPSM) National Pipe Straight Mechanical</b>									
Alloy RH	37945	37950	37955	37960	37965	37970	37975	37980	37985
<b>(API) American Petroleum Institute***</b>									
High-Speed RH	–	–	70720	70725	70730	–	–	–	–
<b>(BSPT) British Standard Pipe Taper**</b>									
	1/8-28	1/4-19	3/8-19	1/2-14	3/4-14	1-11	1 1/4-11	1 1/2-11	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
HS Reversible RH*	–	–	56337	56342	56347	56352	–	–	56367
<b>(BSPP) British Standard Pipe Parallel**</b>									
Alloy RH	–	–	–	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	40-1.5
Alloy RH	85830	76305	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	1 1/4-16
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									
	1/4-20	5/16-18	3/8-16	7/16-14	1/2-13	5/8-12	3/4-11	1-10	1 1/8-9	1-8
<b>(UNC) Unified National Course</b>										
Alloy RH	38335	38340	38345	38350	38355	38360	38365	38370	38375	38380
<b>(UNF) Unified National Fine</b>										
Alloy RH	38385	38390	38395	38400	38405	38410	38415	38420	38425	15317

Alloy dies thread aluminum and black pipe.  
 High-speed dies thread galvanized pipe.  
 Stainless steel dies thread red brass pipe.  
 PVC dies thread yellow brass pipe.



See page 4.12

# Manual Receding Threaders



## NO. 65R-TC MANUAL RECEDING THREADER

- Threads 1" - 2" pipe.
- True centering workholder.
- Jam-proof.
- Right-hand only.

Catalog No.	Model No.	Description	Capacity/Pipe Size		Weight	
			in.	mm	lb.	kg
36570	65R-TC	NPT with 1 Set High-Speed Dies	1 - 2	25 - 50	27	12.3
65345		BSPT with 1 Set High-Speed Dies	1 - 2	25 - 50		
96720	-	Metal Carrying Case for 65R Series Threaders	-	-	8	3.7



## NO. 65R-C MANUAL RECEDING THREADER

- Threads 1"-2" pipe.
- Jam-proof drive pawl.
- Cam workholder sets instantly.
- Right-hand only.

Catalog No.	Model No.	Description	Capacity/Pipe Size		Weight	
			in.	mm	lb.	kg
36565	65R-C	NPT with 1 Set High-Speed Dies	1 - 2	25 - 50	25	11.4
65340		BSPT with 1 Set High-Speed Dies	1 - 2	25 - 50		
96720	-	Metal Carrying Case for 65R Series Threaders	-	-	8	3.7

### Accessories: Receding Threaders Pipe Dies for Models 65R-C & 65R-TC Ratchet Threaders

Die Material or Type	Catalog No.	
	(NPT) National Pipe Taper	(BSPT) British Std. Pipe Taper
	1" Thru 2"-11 1/2 TPI	1" Thru 2"-11 TPI
High-Speed RH	38100	66450*
H.S. For Stainless Steel RH	38105	-
H.S. For Cast Iron RH	38110	-

\* Requires BSPT Threader.

### Accessories: Pipe Dies for 4PJ Geared Pipe Threaders

Die Material or Type	Catalog No.							
	(NPT) National Pipe Taper Nominal Pipe Size-Threads Per Inch				(NPSM) National Pipe <sup>†</sup> Nominal Pipe Size-Threads Per Inch			
	2 1/2"-8	3"-8	3 1/2"-8	4"-8	2 1/2"-8	3"-8	3 1/2"-8	4"-8
High-Speed RH	38220	38225	38230	38235	46732	46737	46742	46747
H.S. For Cast Iron RH	38240	38245	38250	38255	-	-	-	-

\* Requires NPSM Threader.

Die Material or Type	Catalog No.			
	(BSPT) British Standard Pipe Taper Nominal Pipe Size-Threads Per Inch			
	2 1/2"-11	3"-11	3 1/2"-11	4"-11
High-Speed RH	66535*	66540*	-	66550*

\* Requires BSPT Threader.

See page 4.12





# Geared Threader Configurations

## POWER THREADING WITH GEARED THREADERS – MODELS 141, 161



300 Front-Mount

### 300 POWER DRIVE FRONT-MOUNT

Application for 141 and 161 Geared Threader requires:

- Pipe Support (pg. 2.5).
- 460-6 TRISTAND® (pg. 2.2, 36273).
- 418 Oiler (pg. 4.12, 10833).
- 844 Drive Bar (pg. 4.10, 42405).
- 758 Loop – for 141 (pg. 4.10, 19366).
- 346 Support Arms – for 161 (pg. 4.10, 40005).

### 300 POWER DRIVE REAR-MOUNT

Application for 141 and 161 Geared Threader requires:

- 460-6 TRISTAND® (pg. 2.2, 36273).
- 418 Oiler (pg. 4.12, 10833).
- 840A Universal Drive Shaft (pg. 4.10, 61122).



300 PD Rear-Mount

### 535 THREADING MACHINE FRONT-MOUNT

pg. 4.21, 97882

### 535 THREADING MACHINE REAR-MOUNT (MANUAL CHUCK ONLY)

Application for 141 and 161 Geared Threader requires:

- 460-6 TRISTAND (pg. 2.2, 36273).
- 418 Oiler (pg. 4.12, 10833).
- 840A Universal Drive Shaft (pg. 4.10, 61122).

### 300 COMPACT THREADING MACHINE FRONT-MOUNT

Application for 141 Geared Threader requires:

- 844 Drive Bar (pg. 4.10, 42405).
- 768 Drive Link Assembly (pg. 4.10, 42415).

### 1224 THREADING MACHINE REAR-MOUNT

Application for 161 Geared Threader requires:

- 840A Universal Drive Shaft (pg.4.10, 61122).
- 460-6 TRISTAND (pg. 2.2, 36273).
- 418 Oiler (pg. 4.12, 10883).



See page 4.12

# Manual Receding Threaders



## RECEDING GEARED THREADERS

- Jaw clutch prevents jamming.
- Simple adjustment for tapered or straight threads.
- Cam-type workholder sets instantly.
- Fully enclosed gearing.
- Right-hand only.

## SPECIFICATIONS

- Model 141 threads 2 1/2", 3", 3 1/2", 4" pipe with one set of dies
- Model 161 threads 4", 4 1/2", 5", 6" pipe with one set of dies

Catalog No.	Model No.	Description	Capacity Nominal Pipe Size		Weight	
			in.	mm	lb.	kg
36620	141	NPT with 1 Set High-Speed Dies	2 1/2 - 4	62 - 100	93	42.3
65380		BSPT with 1 Set High-Speed Dies	2 1/2 - 4	62 - 100		
36630	161	NPT with 1 Set High-Speed Dies	4 - 6	100 - 150	158	71.8
39380	D-1440	Ratchet and Handle	-	-	9 1/2	4.3
96725	-	Metal Carrying Case for 141 Geared Threaders	-	-	17	7.7

## Accessories

Catalog No.	Model No.	Description	Weight	
			lb.	kg
42505	46	Adjustable Pipe Support	23	10.4
61122	840A	Universal Drive Shaft	31	14.1
19366	758	Loop	1 1/4	0.6
40005	346	Support Arms	10 1/2	4.8
42405	844	Drive Bar for 141	5 3/4	2.6
42415	768	Drive Link Assembly for 141	2 1/2	1.1
97882	535A	Kit 141 on 535 Auto Chuck with High-Clearance Carriage*	12	5.5
16723	-	Drive Link Assembly for High Clearance Carriage**		5.5

\*Kits include all accessories necessary for threading with a 141 mounted on a 535 with a high-clearance carriage; 1/2=1/2  
 \*\*Drive bar for 16723 not included



## Model 141 Geared Pipe Threader Dies

Catalog No.	Description	Thread Type	Pipe Threading Capacity	
			in.	TPI
38120	High-Speed RH	NPT	2 1/2 - 4	8
38125	H.S. For Cast Iron RH	NPT	2 1/2 - 4	8
38130	H.S. For PVC RH	NPT	2 1/2 - 4	8
38140	H.S. 37 1/2" Bevel	Bevel	2 1/2 - 4	4
66625*	High-Speed RH	BSPT	2 1/2 - 4	11
70640	H.S. for Stainless Steel RH	NPT	2 1/2 - 4	8
70645*	H.S. for Stainless Steel RH	BSPT	2 1/2 - 4	11

## Model 161 Geared Pipe Threader Dies

Catalog No.	Description	Thread Type	Pipe Threading Capacity	
			in.	TPI
38155	High-Speed RH	NPT	4 - 6	8
70655	H.S. For Stainless Steel RH	NPT	4 - 6	8
66620*	High-Speed RH	BSPT	4 - 6	11

(NPSM) National Pipe Straight Mechanical - Use (NPT) dies and rotate thread guide post 180°. (BSPP) British Standard Pipe Parallel - Use (BSPT) dies and rotate thread guide post 180°. \* Requires BSPT Threads.

See page 4.12



# Geared Threader Accessories

## MODEL 840A UNIVERSAL DRIVE SHAFT

- A telescoping 41"-50" (104-127cm) drive shaft for operation of Models 141 and 161 Geared Threading with Threading Machines.

## GEARED THREADER OPERATION

- The Models 141 and 161 Geared Threaders, in conjunction with these accessories, threading machines to thread up to 4" and 6" pipe.



Catalog No.	Model No.	Description	Weight	
			lb.	kg
42505	46	Adjustable Pipe Support	23	10.4
61122	840A	Universal Drive Shaft	31	14.1
19366	758	Loop	1 ¼	0.6
40005	346	Support Arms	10 ½	4.8
42405	844	Drive Bar for 141	5 ¾	2.6
42415	768	Drive Link Assembly for 141	2 ½	1.1
97882	535A	Kit 141 on 535 Auto Chuck with High-Clearance Carriage*		5.4
16723	-	Drive Link Assembly for High Clearance Carriage**	12	5.5

\*Kits include all accessories necessary for threading with a 141 mounted on a 535 with a high-clearance carriage; 1/2=1/2  
 \*\*Drive bar for 16723 not included



See page 4.12

# Threading Accessories



\*Flip top included with every quart bottle.

\*\*FBC™ System Compatible indicates that this product has been tested and is monitored on an ongoing basis to assure chemical compatibility with FlowGuard Gold®, BlazeMaster™ and Corzan® pipe and fittings.

FlowGuard Gold®, BlazeMaster®, Corzan® and FBC™ are trademarks of The Lubrizol Corporation. FBC™ is a trademark of The Lubrizol Corporation.

\*\*\*Aerosol can.

## THREAD CUTTING OIL

RIDGID® thread cutting oils are free of chlorine and other halogens, PCBs and heavy metals. Complete material safety data sheet available.

- Cools threads and pipe during operation.
- Speeds metal removal.
- Improves thread quality.
- Reduces threading torque.

Feature	Dark	Nu-Clear	Endura-Clear	Extreme Performance
Low Odor	I	I	I	I
Anti-Mist Formulation	I	I	I	I
Extended Die Life			I	I
FBC™ System Compatible**			I	
Designed for Stainless Steel				I
Working Viscosity	0°F	-20°	-20°	0°

Catalog No.	Description	Container Size		Containers Per Case	Weight Per Case	
		qt/gal	l		lb	kg
41590*		1 qt	0.9	12	22	10
70830	Dark	1 gal	3.8	6	50	23
41600		5 gal	18.9	1	42	19
41610		55 gal	207.9	1	465	221
70835	Nu-Clear	1 gal	3.8	6	50	23
41575	Nu-Clear	5 gal	18.9	1	42	19
41585		55 gal	207.9	1	465	211
32808**	Endura-Clear	1 gal	3.8	6	50	23
74012	Extreme Performance	1 gal	3.8	6	50	23
74047		5 gal	18.9	1	42	19
76767		55 gal	207.9	1	465	211
22088	Extreme Performance Aerosol	0.1 gal	0.4	12	12	6



## SPECIFICATIONS

- Chip pan diameter—14 ¼ in.
- Chip pan depth—8 ¾.
- Hose length—55 in.
- Capacity—1 gallon.

## MODEL 418 OILER

The Model 418's durable pump assembly and heavy-duty reservoir are designed to increase productivity.

- An ergonomic 2-finger trigger design that reduces user fatigue.
- Die cast, heavy-duty body with swivel nozzle with no exposed parts for longer life.
- The 418 oiler features a patented fastener-less twist and lock drip pan that easily locks in place.
- The material withstands abrasion, is lighter than metal and does not rust.
- The reservoir will not crack or leak.
- Material is so strong that under normal use, no dents will form on impact or shape changes will occur over time. As a result, the drip pan will fit squarely on the reservoir time after time.
- Integral molded body eliminates leaks at the hose-reservoir connection.
- Convenient anti-slip grip design with integral hood for easy hanging.

Catalog No.	Model No.	Description	Weight	
			lb.	kg
10883	418	Oiler with One Gallon Premium Thread Cutting Oil	20 ½	9.4
72342	402	Hand operated oiler with attachment for 1 gallon and 5 gallon containers and 54" hose.	2 ½	1.2
72332	#4	Hand-operated oiler only	1 ¼	0.5
72327		Hand-operated oiler with 54" hose and fittings	2 ¼	1

# Hand-Held Power Drives



### 600-1 HAND-HELD POWER DRIVE

The lightest and easiest to handle RIDGID® Power Drive.

- Lightweight and easy to handle for service and repair.
- Over molded handle and contoured grip provide optimal control.
- Screw-in brush covers reduces service time.
- Durable die cast gear housing and fiberglass reinforced plastic body to withstand demanding jobsite conditions.
- Dual "V" Jaw Support Arm firmly prevents slipping.

### SPECIFICATIONS

- Capacity – 1/8"-1-1/4" (3mm - 32mm) 11 R Die Heads
- Motor – Single Phase, Universal Motor
- Weight – 12.7 lbs. (5.8 kg), Power Drive only
- Size – 20 in. (508 mm) L x 3.75 in. (95 mm) W x 7.50 in. (191 mm) H
- Controls – Forward/reverse slide switch. On/off two-step momentary contact
- Gear Head – Die cast aluminum permanently greased
- Body & Handle – Durable heavy-duty fiberglass reinforced plastic

Catalog No.	Model No.	Description	RPM	Voltage		Phase	Amp Draw A	Power (W)	Weight	
				V	Hz				lb.	kg
44913		Power Drive (Only) Case & Support Arm	36	115	60	1	12	1270	29.1	13.2
44918	600-1	Power Drive w/ 1/2"-1 1/4" NPT 11R Die Heads, Case and Support Arm	36	115	60	1	12	1270	41	18.6

### Standard Equipment

Catalog No. Model No.	Description	44913 600-1	44918 600-1
45923	602 Support Arm	I	I
46668	Carrying Case	I	I
37040	1/2" NPT 11R Die Head		I
37045	3/4" NPT 11R Die Head		I
37050	1" NPT 11R Die Head		I
37055	1 1/4" NPT 11R Die Head		I

### Accessories

Catalog No.	Model No.	Description	Weight	
			lb.	kg
10883	418	Oiler with One Gallon Premium Thread Cutting Oil	20.5	9.4
16703	425	Portable TRISTAND® Chain Vise	32	14.5
36273	460-6		42.8	19.4



See page 4.12

# Hand-Held Power Drives



### 690-1 HAND-HELD POWER DRIVE

Featuring the RIDGID® die head quick release system.

- RIDGID die head retaining system is a simple twist and release for the 1 ½", 2" Die Heads and Die Head Adapter.
- Lightweight and portable for maintenance, repair and service plumbers.
- Over molded handle and contoured grip provide optimal control.
- Screw-in brush covers improve serviceability.
- Durable die cast gear housing and fiberglass reinforced plastic body to withstand demanding job site conditions.
- Dual "V" Jaw Support Arm firmly prevents slipping.



### SPECIFICATIONS

- Capacity – ½" - 2" (3mm - 50mm) 11 R Die Heads
- Motor – 1270 Watt, Single Phase, Universal Motor
- Weight – 21.1 lbs. ( 9.59 kg) Power Drive only
- Size – 24.1 in. (613 mm) L x 4.75 in. (121 mm) W x 8 in. (203mm) L
- Controls – Forward/reverse slide switch, on/off two-step momentary contact
- Gear Head – Die cast aluminum permanently greased
- Body & Handle – Durable heavy-duty fiberglass reinforced plastic



Turn to Unlock



Pull Die Head



Release to Lock

Catalog No.	Model No.	Description	RPM	Voltage	Frequency	Phase	Amp Draw	Power	Weight	
				V	Hz		A		lb.	kg
44923	690-1	Power Drive ½" - 2" NPT Die Heads, Case, & Support Arm	36	115	60	1	12	1270	59.4	26.9
44928		Power Drive Only W/ Case and Support Arm	36	115	60	1	12	1270	42.4	19.2

### Standard Equipment

Catalog No. Model No.	Description	44923 690-1	44928 690-1
45928	692 Support Arm		
46673	Carrying Case		
39187	Ratcheting Ring		
37040	½" NPT 11R Die Head		
37045	¾" NPT 11R Die Head		
37050	1" NPT 11R Die Head		
37055	1 ¼" NPT 11R Die Head		
20923	1 ½" NPT 11R Die Head		
20943	2" NPT 11R Die Head		

### Accessories

Catalog No.	Model No.	Description	Weight	
			lb.	kg
39187	-	Ratcheting Ring	1.1	0.5
10883	418	Oiler with One Gallon Premium Thread Cutting Oil	20.5	9.4
16703	425		32	14.5
36273	460-6	Portable TRISTAND® Chain Vise	42.8	19.4

See page 4.12



# Hand-Held Power Drives



### MODEL 700 POWER DRIVE

- Heavy-duty hand-held Power Drive.
- Designed for RIDGID® Model 12-R die heads. Other RIDGID die heads (00-R, 00-RB, 11-R) can be used using adapters. It can also be used with 258/258XL pipe cutters.

### SPECIFICATIONS

- Capacity – 1/8" - 2" Pipe (6 - 50 mm). 1/4" - 1" (8 - 25 mm) Bolt (using 00-RB Die Heads)
- Motor – Single Phase, Universal
- Weight – 25 lbs. (11 kg) Power Drive only
- Length – 28 1/4" (71.7 cm)
- Switch – Double-throw reversible
- Gear Head – Spur gear reduction face gear drive. Spring-loaded adapter pawls. Hardened steel spindle gear
- Body – Cast aluminum
- Die Heads – 12-R. Other Die Heads with adaptors: 00-R, 00-RB, 11-R



Catalog No.	Model No.	Description	RPM	Voltage		Frequency	Phase	Amp Draw	Power	Weight	
				V	Hz					lb.	kg
41935	700	700 Power Drive	36	115	50 - 60	1	13	1/2 HP	25	11	
41940		700 Power Drive w/ 1/2"-2" NPT Die Heads, Case and Support Arm	36	230	50 - 60	1	6	1/2 HP			
45178		700 Power Drive w/ 1/2"-2" NPT Die Heads, Case and Support Arm	36	115	50 - 60	1	13	1/2 HP	-		

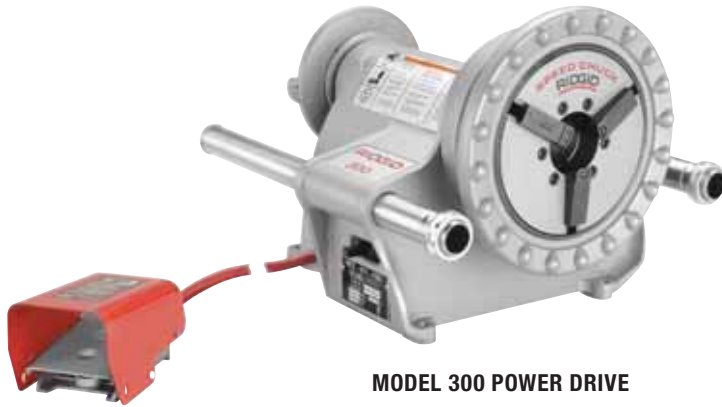
### Accessories

Catalog No.	Model No.	Description	Weight	
			lb.	kg
10883	418	Oiler with One Gallon Premium Thread Cutting Oil	20.5	9.4
42600	770	Adapter for 00-R and 00-RB	4.4	2
42605	771	Adapter for 0-R		
42610	772	Adapter for 11-R and R-200 (1/8" - 1 1/4")	2.2	1
42615	773	Adapter for 111-R		
42620	774	Square Drive Adapter - 15/16"	4.4	2
42625	775	Support Arm for No. 700	11	5
42950	B-171-X	Metal Carrying Case	28.8	13



See page 4.12

# Power Threading Machines



### MODEL 300 POWER DRIVE

- RIDGID® speed chuck.
- Reversible 1/2 HP universal motor.
- Recessed On/Off/Reverse switch.
- Convert a 300 Power Drive to a portable threading machine.
- Ideal for use with RIDGID roll groovers.

### SPECIFICATIONS

- Capacity – 1/8" - 2" (6mm - 50mm) Pipe, 2 1/2" - 4" (65mm - 100mm) with 141, and 4" - 6" (100mm-150mm) with 161 Geared Threaders, 1/4" - 2" (6mm - 52mm) Rod
- Switch – Heavy-duty forward/off/reverse and integral foot switch
- Chuck – RIDGID speed chuck with replaceable rocker-action jaws
- Rear Centering Device – Cam-action turns with chuck
- Support Bars – Two heavy-duty

Catalog No.	Model No.	Description	RPM	Voltage	Frequency	Phase	Motor Type	Amp Draw	Power	Weight	
				V	Hz			A		lb.	kg
41855	300	Power Drive Only	38	115	50 - 60	1	Universal	15	1/2 HP	94	43
41860			38	230	50 - 60	1	Universal	8	1/2 HP		
75075			57	115	50 - 60	1	Universal	18	1/2 HP		
75435			38	230	50 - 60	1	Universal	8	1/2 HP		

### Accessories

Catalog No.	Model No.	Description	Weight	
			lb.	kg
10883	418	Oiler with One Gallon Premium Thread Cutting Oil	20 1/2	9.4
51005	819	Nipple Chuck Complete, 1/2" - 2" NPT	10 1/2	4.8
97065	811A	NPT Die Head Quick-Open R.H.	13	5.7
97075	815A	815A 1/8" - 2" NPT Die Head, Self-Opening, RH		5.9
42360	1206	Stand 1206	31	14.10
42365	341	341 Reamer	6 3/4	3.2
42370	360	Model 360 1/8"-2" Full Floating, Self Centering Cutter	8 1/2	3.9
42385	312	Lever Carriage Feed Kit	3	1.4
42575	32	#32 Transport Cart	14 1/4	6.5
46660	E-863	Reamer Cone (L.H. & R.H.)	7	3.2
68815	311	Carriage with Lever	15	6.8
97365		Insert Set f/Plas. Coated Pipe	1/2	0.2
22638	1452	Clip-On Tool Tray	6	2.7
68160	819	Nipple Chuck 1/2"-2" BSPT	10 1/2	4.8
97070	811A	815A 1/8" - 2" NPT Die Head, Self-Opening, RH	12 1/2	5.7
97080	815A	815A 1/8"-2" BSPT Self-Opening Die Head	13	5.9

See page 4.12





# Power Threading Machines



## MODEL 300 POWER DRIVE COMPLETE

- RIDGID® speed chuck.
- Reversible 1/2 HP universal motor.
- Ideal for use with RIDGID roll groovers.

## SPECIFICATIONS

- Recessed Switch – Heavy-duty forward/off/reverse and integral foot switch
- Chuck – Speed chuck with replaceable rocker-action jaws
- Rear Centering Device – Cam-action turns with chuck
- Support Bar – Heavy duty

Catalog No.	Model No.	Description	Oiler	Die Head	RPM	Voltage		Phase	Motor Type	Amp Draw		Power		Weight	
						V	Hz			A		lb.	kg		
15682	300 Complete	115V, 50/60 Hz (NPT)	418	811A	38	115	50 - 60	1	Universal	15	1/2 HP	212	96.2		
15722			418	811A	57	115	50 - 60	1	Universal	18	1/2 HP				
97415*		230V, (NPT)	-	811A	38	230	50 - 60	1	Universal	8	1/2 HP	202			
97420*			-	811A	38	230	50 - 60	1	Universal	8	1/2 HP				

Other voltages available upon request. Export machines equipped with special power cord sets.  
 \*300A includes automatic oiling.

## Standard Equipment

Catalog No. Model No.	Description	15682 300 Complete	15722 300 Complete	97415 300 Complete	97420 300 Complete
97065	NPT Die Head Quick-Open R.H.				
47745	1/2" - 3/4" Universal Alloy Die Set				
47750	1" - 2" Universal Alloy Die Set				
42370	Model 360 1/8"-2" Full Floating, Self Centering Cutter				
68815	CARRIAGE, 311 W/LEVER				
42575	#32 Transporter (for Power Drives and Tristand Vises)				
42365	REAMER, 341				
42360	STAND 1206				
10883	Oiler w/1 Gal. Premium Thread Cutting Oil				
22638	Clip-On Tool Tray				
41855	Power Drive Only				
75075	Power Drive Only				
96945	Model 311A Carriage With Lever				
97245	Model 330 Oil Pan (300A Power Drive)				
66665	1/2" - 3/4" universal alloy set				
66670	1-2" universal alloy set				
97070	811A BSPT Quick-Open Die Head				



See page 4.12

# Power Threading Machines



## MODEL 1215 THREADING MACHINE

- Compact, lightweight design.
- One-piece aluminum housing.
- Two easy-to-use carrying handles.
- Integral foot switch hanger.
- Powerful motor and transmission.
- Through die head oiling.
- Adjustable oil flow control.
- Approved to CSA/ UL standards (115V)

## SPECIFICATIONS

- Pipe Capacity – ¼"-1 ½" (6mm-37mm)
- Bolt Capacity – 5/16"-1" (6mm-25mm)
- Motor Control – On/off heavy-duty switch and integral foot switch
- Front Chuck – Hammer type with replaceable rocker action jaw inserts
- Rear Centering Device – Cam action
- Oiling – Through die head adjustable
- Pump – Self-priming constant flow, gerotor type

Catalog No.	Model No.	Description	RPM	Voltage	Frequency	Phase	Motor Type	Amp Draw	Power	Weight	
			RPM	V	Hz	Phase	Motor Type	A	Power	lb.	kg
61142	1215	½" - 1 ½" NPT Hammer Chuck Machine	44	115	60	1	Universal	24	½ HP	80	36

## Standard Equipment

Catalog No.	Model No.	Description	61142 1215
97065	811A	NPT Die Head Quick-Open R.H.	I
47745	-	½" - ¾" Universal Alloy Die Set	I
47750	-	1" - 2" Universal Alloy Die Set	I
58657	732	Cutter Assembly	I
34612	344	½" - 2" Reamer	I
70835	-	Nu-Clear Oil	I

## Accessories

Catalog No.	Model No.	Description	Weight	
			lb.	kg
61187	1203	Tripod Stand	15	-
62457	1219	Nipple Chuck, NPT For 1215	5 ¾	-
97045	531	Bolt Die Head Quick-Open R.H./L.H. ¼"-1"	7 ½	3.4
84537	816	½" - ¾" Semi-Automatic Die Head	13	5.9
84532	817	½" - 2" Semi-Automatic Die Head		

See page 4.12



# Power Threading Machines



## MODEL 300 COMPACT THREADING MACHINE

- Heavy-duty proven performance.
- Lightweight, portable design.
- Fast transport and set-up.
- Self-contained oil system with adjustable flow control.
- Versatility for threading and grooving.
- Quiet operation.

## SPECIFICATIONS

- Pipe Capacity – 1/8" - 2" (3mm-50mm)
- Bolt Capacity – 1/4" - 2" (6mm-50mm)
- Motor Control – Heavy-duty rotary forward/off/reverse and integral foot switch
- Chuck – Hammer-type with replaceable, rocker-action jaw inserts
- Oiling System – Through-the-head, with integral oil reservoir with self-priming, constant-flow, gerotor pump

Catalog No.	Model No.	Description	Die Head	RPM	Voltage	Frequency	Phase	Motor Type	Amp Draw	Power	Weight	
											V	Hz
66947	300 Compact	1/2" - 2" NPT Hammer Chuck	811A	36	115	50 - 60	1	Universal	15	1/2 HP	115	52.3
67182	300 Compact Kit	1/2" - 2" NPT Hammer Chuck w/ 250 Folding Wheel Stand	811A	36	115	50 - 60	1	Universal	15	1/2 HP	160	72.7
73447*	300 Compact	1/2" - 2" NPT Hammer Chuck	811A	52	115	50 - 60	1	Universal	18	1/2 HP	115	52.3
75602*	300 Compact Kit	1/2" - 2" NPT Hammer Chuck w/ 250 Folding Wheel Stand	811A	52	115	50 - 60	1	Universal	18	1/2 HP	160	72.7
58752	300 Compact	1/2" - 2" BSPT Hammer Chuck (Australia)	811A	36	230	50 - 60	1	Universal	7.5	1/2 HP	115	52.3
58757		1/2" - 2" NPT Hammer Chuck (Export Only)	811A	36	230	50 - 60	1	Universal	7.5	1700W		

\*20 amp, 115V circuit required.

## Standard Equipment

Catalog No. Model No.	66947 300 Compact	67182 300 Compact Kit	73447 300 Compact	75602 300 Compact Kit	58752 300 Compact	58757 300 Compact
70835 - Nu-Clear Oil						
97065 - NPT Die Head Quick-Open R.H. 811A						
34612 - Model 344 1/8"-2" Reamer						
42370 - Model 360 1/8"-2" Full Floating, Self Centering Cutter						
47745 - 1/2" - 3/4" Universal Alloy Die Set						
47750 - 1" - 2" Universal Alloy Die Set						
46030 - Key, Hex 3/16						
46015 - Key, Hex 5/32						
46045 - Key, Hex 5/16						
67657 - STAND 250 FOLDING F/NA						
66665 - 1/2" - 3/4" universal alloy set						
97070 - Diehead, 811A Q0 BSPT L/Dies						
97075 - 815A 1/8" - 2" NPT Die Head, Self-Opening, RH						

## Die Heads

Catalog No.	Model No.	Description	Weight	
			lb.	kg
84537	816	1/8" - 3/4" Semi-Automatic Die Head	13	5.9
97045	531	Bolt Die Head Quick-Open R.H./L.H. 1/4"-1"	7 1/2	3.4
97050	532	Bolt Die Head Quick-Open R.H./L.H. 1/8"-2"	9	4.1
97065	811A	NPT Die Head Quick-Open R.H.	13	5.7
97075	815A	815A 1/8" - 2" NPT Die Head, Self-Opening, RH		5.9
84532	817	1/2" - 2" Semi-Automatic Die Head	12 1/2	5.7
97070	811A	815A 1/8" - 2" NPT Die Head, Self-Opening, RH		5.7
97080	815A	815A 1/8"-2" BSPT Self-Opening Die Head	13	5.9

## Accessories

Catalog No.	Model No.	Description	Weight	
			lb.	kg
51005	819	Nipple Chuck Complete, 1/2" - 2" NPT	10 1/2	4.8
67662	-	Adapter Bracket for 300 Compact	30	13.6
68160	819	Nipple Chuck 1/2"-2" BSPT	10 1/2	4.8

## Stands

Catalog No.	Model No.	Description	Weight	
			lb.	kg
67657	250	Folding Stand F/NA	45	21
92457	100A	Universal Leg & Tray Stand	75	34.5
92462	150A	Universal Wheel & Tray Stand	103	46.7
92467	200A	Universal Wheel & Cabinet Stand	104	47.2
22563	-	Steel Cabinet	42	19.3



See page 4.12

## Power Threading Machines



### MODEL 535 THREADING MACHINE

The Model 535 maintains the ruggedness of the industry workhorse while adding the features that makes the threading operation more productive. A large chip tray and oil reservoir makes the 535 ideal for longer uninterrupted threading. The 535 is designed around maximum uptime with the upgrades that matter most to the pipe working professional. Users also benefit from the part commonality between the 535, the 535A Automatic and other RIDGID® equipment.

- Large 1.75 gallon (6.6 L) oil tray.
- Large chip tray.
- Generous top cover for keeping tools and fittings handy.
- High clearance carriage makes threading easier.
- Speed chuck with rocker-action jaws centers and grips work piece instantly.
- Can be used with geared Models 141 and 161 threaders.
- Uses Model 816/817 semiautomatic, Model 815A self-opening or Model 811A quick-opening die heads.
- Length gauge for quick, accurate cut-off.

### SPECIFICATIONS

- Pipe Capacity – 1/8"-2" (3mm-50mm) 2 1/2"-4" (62mm-100mm), 4"-6" (100mm-150mm) with 141 and 161 geared threaders
- Bolt Capacity – 1/4"-2" (6mm-50mm)
- Switches – Forward/off/reverse and integral foot switch
- Chuck – Speed Chuck™ with three replaceable rocker-action jaw inserts
- Rear Centering Device – Cam-action, turns with chuck
- Cutters – Self-centering, full-floating. Two models available: Standard Model 820 Wheel-Type Cutter, pipe capacity 1/8"-2" (3mm-50mm), bolt capacity 1/4"-1" (6mm-25mm). Optional Model 821 Blade-Type cutter, pipe capacity 1/2"-2" (12mm-50mm). See ordering chart.
- Reamer – 5-flute cone, RH, 1/8"-2" (3mm-50mm)
- Oil Pump – Self-priming gerotor oil pump
- Reamers – RH/LH combination reamer available



See page 4.12



# Power Threading Machines

## MODEL 535 AUTOMATIC THREADING MACHINE (CONTINUED)

Catalog No.	Model No.	Description	Die Head	RPM	Voltage	Frequency	Phase	Motor Type	Amp Draw	Power	Weight	
					V	Hz			A		lb.	kg
93287	535	½" - 2" NPT Hammer Chuck Machine	811A	36	115	50 - 60	1	Universal	15	½ HP	260	117.9
96497		Hammer Chuck Machine Only - No Die Head or Dies	-	36	115	50 - 60	1	Universal	15	½ HP	245	111.1
96502		½" - 2" NPT Hammer Chuck Machine	811A	54	115	50 - 60	1	Universal	20	½ HP	260	117.9
96507			811A	36	230	50 - 60	1	Universal	7.5	½ HP		

Machines Listed as 1/2-2" include Standard Equipment. Machine Only includes Standard Equipment less all Die Heads and Dies.

All machines have 50/60 Hz Universal 1/2 HP single-phase motors.

Note: NPT Dies are for NPT Die Heads only. BSPT Dies are for BSPT Die Heads only.

Please use Catalog Item Numbers when ordering. Use High Speed Dies for machines of 45 or more RPM.

### Standard Equipment

Catalog No. Model No.	Description	93287 535	96497 535	96502 535	96507 535
42365	REAMER, 341				
42390	Wheel-Type Cutter				
44185	Wheel, Cutter E1032				
46015	Key, Hex 5/32				
46030	Key, Hex 3/16				
47745	Dies, Univ. ½-¾ NPT				
47750	Dies, Univ. 1-2 NPT				
70835	Nu-Clear Oil				
97065	NPT Die Head Quick-Open R.H.				

### Accessories

Catalog No.	Model No.	Description	Weight	
			lb.	kg
16723	-	Drive Link Assembly for High Clearance Carriage	12	5.5
42405	844	Drive Bar for 141	5 ¾	2.6
42415	768	Drive Link Assembly for 141	2 ½	1.1
51005	819	Nipple Chuck Complete, ½" - 2" NPT	10 ½	4.8
84537	816	⅛" - ¾" Semi-Automatic Die Head	13	5.9
42365	341	341 Reamer	6 ¾	3.2
42390	820	Wheel-Type Cutter	8 ½	3.9
58007	-	Machine stand adapter bracket for 535's built before 1996	17	7.7
96517	MJ-1	535M Left Hand Threading Kit	3 ½	1.6
97365	-	Insert Set f/Plas. Coated Pipe	½	0.2
84532	817	½" - 2" Semi-Automatic Die Head	13	5.9

### Stands

Catalog No.	Model No.	Description	Weight	
			lb.	kg
92457	100A	Universal Leg & Tray Stand	75	34.5
92462	150A	Universal Wheel & Tray Stand	103	46.7
92467	200A	Universal Wheel & Cabinet Stand	104	47.2



No. 100A



No. 150A



No. 200A with Steel Cabinet

### STEEL CABINET

- 17-gauge steel walls and welded construction.
- Two internal and one external storage shelves.
- Oversized bi-fold door with steel clasp.
- Cut-outs for power cord and foot switch storage.
- Two drain plugs for easy cleaning.



See page 4.12

## Power Threading Machines



Stand not included



No. 100A



No. 150A



No. 200A with Steel Cabinet

### MODEL 535A AUTOMATIC THREADING MACHINE

The Model 535A maintains the ruggedness of the industry workhorse while adding features that make the threading operation more productive. A large chip tray and oil reservoir make the 535A ideal for longer uninterrupted threading. The 535 features a high clearance carriage that makes the threading operation easier and a generous top cover area that is ideal for keeping tools and work related materials handy. The 535A is designed around maximum uptime with the upgrades that matter most to the pipe working professional. Users also benefit from the part commonality between the 535, the 535A Automatic and other RIDGID® equipment.

- Automatic chuck.
- Large 6.6 l (1.75 gallon) oil reservoir.
- Large chip tray.
- Generous top cover area for keeping tools and fittings handy.
- High clearance carriage.
- Can be used with geared threader Model 141.
- Uses Model 816/817 semi-automatic, Model 815A self-opening or Model 811A quick-opening die heads.
- Length gauge for quick, accurate cut-off.

### SPECIFICATIONS

- Pipe Capacity – 1/8"-2" (3 mm-50 mm) 2 1/2"-4" (62 mm-100 mm) with 141 geared threader
- Bolt Capacity – 1/4"-2" (8 mm-50 mm)
- Switches – Forward/off/reverse and integral safety foot switch
- Chuck – Automatic with four reversible forged jaws
- Rear Centering Device – Automatic, centering only
- Cutters – Self-centering, full-floating. Two models available:
  - Model 820 Wheel-Type Cutter, pipe capacity 1/8"-2" (6-50 mm), bolt capacity 1/4"-1" (8-25 mm)
  - Model 821 Blade Type Cutter, pipe capacity 1/2"-2" (15-50 mm)
- Reamer – 5-flute cone, RH, 1/8"-2" (3 mm-50 mm)
- Oil Pump – Self-priming gerotor oil pump
- RH/LH combination reamer available

### STEEL CABINET FEATURES

- 17-gauge steel walls and welded construction.
- Two Internal and one external storage shelves.
- Oversized bi-fold door with steel clasp.
- Cut-outs for power cord and foot switch storage.
- Two drain plugs for easy cleaning.

See page 4.12



# Power Threading Machines

## MODEL 535A AUTOMATIC THREADING MACHINE (CONTINUED)

Catalog No.	Model No.	Description	Die Head	RPM	Voltage		Phase	Motor Type	Amp Draw	Power	Weight	
					V	Hz					lb.	kg
84097	535A	½" - 2" NPT Automatic Chuck Machine	811A	16/46/58	120	60	1	Induction	18	2 HP	350	159
91142		Automatic Chuck Machine Only - No Die Head or Dies		16/46/58	120	60	1	Induction	18	2 HP	340	155
91322		½" - 2" NPT Automatic Chuck Machine	816/817	16/46/58	120	60	1	Induction	18	2 HP	360	163

### Standard Equipment

Catalog No.	Model No.	Description	84097 535A	91142 535A	91322 535A
74012	—	Extreme Performance Thread Cutting Oil	I	I	I
97065	811A	NPT Die Head Quick-Open R.H.	I		
47765	—	½" - ¾" Pipe Dies for use in Universal Die Heads (Nos. 504A, 711, 713, 811A, 815A, 816, 817 and 842)	I		I
47770	—	1" - 2" Pipe Dies for use in Universal Die Heads (Nos. 504A, 711, 713, 811A, 815A, 816, 817 and 842)	I		I
42365	341	REAMER	I	I	I
42390	820	Wheel-Type Cutter	I	I	I
41185	E1032	Wheel, Cutter	I	I	I
46030	—	Key, Hex ⅜	I	I	I
46015	—	Key, Hex ⅝	I	I	I
84537	816	Die Head			I
84532	817	Die Head			I

### Model 535A Machine Accessories

Catalog No.	Model No.	Description	Weight	
			lb.	kg
42365	341	341 Reamer	6 ¾	3.2
42390	820	Wheel-Type Cutter	8 ½	3.9
92457	100A	Universal Leg & Tray Stand	75	34.5
92462	150A	Universal Wheel & Tray Stand	103	46.7
92467	200A	Universal Wheel & Cabinet Stand	104	47.2
51005	819	Nipple Chuck Complete, ½" - 2" NPT	10 ½	4.8
35867	839	Adapter Kit for Model 1822/535A Machine	16 ½	7.5
97882	535A	Kit 141 on 535 Auto Chuck with High-Clearance Carriage	12	5.4
12138		Left Hand Threading Kit	2 ½	1.2
42485	4U	4 Heads	8 ½	3.9
42490	6U	6 Heads	12 ½	
97065	811A	NPT Die Head Quick-Open R.H.		5.7
97075	815A	815A ⅛" - 2" NPT Die Head, Self-Opening, RH	13	5.9
23282	842	Universal Die Head LH		
97070	811A	815A 1/8" - 2" NPT Die Head, Self-Opening, RH	12 ½	5.7
97080	815A	815A 1/8"-2" BSPT Self-Opening Die Head	13	5.9
97045	531	Bolt Die Head Quick-Open R.H./L.H. ¼"-1"	7 ½	3.4
97050	532	Bolt Die Head Quick-Open R.H./L.H. 1 ⅛"-2"	9	4.1
84537	816	⅛" - ¾" Semi-Automatic Die Head		
84532	817	½" - 2" Semi-Automatic Die Head	13	5.9
68160	819	Nipple Chuck ½"-2" BSPT	10 ½	4.8
23297	856	British Universal	12 ½	5.7

Note: Mono Die Heads available ⅛", ¼", ⅜", ½", ¾", 1", 1 ¼", 1 ½", 2". All Die Heads are through-head oiling.



See page 4.12

## Power Threading Machines



No. 100A

### THREADER STANDS

Stands are available to satisfy every operational situation. The Model 250 Folding Wheel Stand provides increased field maneuverability and productivity.

Catalog No.	Model No.	Description	Weight	
			lb.	kg
92457	100A	Universal Leg & Tray Stand	75	34.5
92462	150A	Universal Wheel & Tray Stand	103	46.7
92467	200A	Universal Wheel & Cabinet Stand	104	47.2
67657	250	Folding Stand F/NA	45	21
22563	-	Steel Cabinet	42	19.3



No. 150A



No. 200A with Steel Cabinet



See page 4.12





## OPTIONAL DIE HEADS

- Quick-Opening (QO) – Manual release for user-specified thread lengths.
- Self-Opening (SO) – Automatic release for repeatable number of threads.
- Semi-Automatic (SA) – Can be quickly adjusted from size to size with manual release.
- Mono – Dedicated to a specific size of thread.
- Bolt – Specially for bolt threader.



No. 811A Quick-Opening Die Head



No. 815A Self-Opening Die head



No. 816/817 Semi-Automatic



Mono Die Head



No. 532 Bolt Die Head

## Machine NPT Die Heads

Catalog No.	Model No.	Description	How Opened	Thread Direction	Oil Thru Head	Dies Used	Pipe Capacity	Pipe Capacity	Bolt Capacity	Bolt Capacity	Weight	
							in.	mm	in.	mm	lb.	kg
97065	811A	NPT Die Head Quick-Open R.H.	Q.O	RH	Yes	Univ.	1/8 - 2	3 - 50	1/4 - 2	6 - 50	13	5.7
97075	815A	815A 1/8" - 2" NPT Die Head, Self-Opening, RH	S.O	RH	Yes	Univ.	1/8 - 2	3 - 50	1/4 - 2	6 - 50		5.9
84537	816	1/8" - 3/4" Semi-Automatic Die Head	S.A	RH	Yes	Univ.	1/8 - 3/4	-	-	-		5.9
84532	817	1" - 2" Semi-Automatic Die Head	S.A	RH	Yes	Univ.	1 - 2	-	-	-	-	-
23282	842	Universal Die Head	Q.O	LH	Yes	Univ.	1/8 - 2	-	-	-	12 1/2	5.7

## Machine BSPT Die Heads

Catalog No.	Model No.	Description	How Opened	Thread Direction	Oil Thru Head	Dies Used	Pipe Capacity	Pipe Capacity	Bolt Capacity	Bolt Capacity	Weight	
							in.	mm	in.	mm	lb.	kg
97070	811A	811A 1/8" - 2" BSPT Die Head, Self-Opening, RH	Q.O	RH	Yes	Univ.	1/8 - 2	3 - 50	1/4 - 2	6 - 2	12 1/2	5.7
97080	815A	815A 1/8" - 2" BSPT Self-Opening Die Head	S.O	RH	Yes	Univ.	1/8 - 2	3 - 50	1/4 - 2	6 - 50	13	5.9
23297	856	British Universal	S.O	LH	Yes	Univ.	1/8 - 2	3 - 50	-	-	12 1/2	5.7

## Machine Bolt Die Heads

Catalog No.	Model No.	Description	How Opened	Thread Direction	Oil Thru Head	Dies Used	Pipe Capacity	Pipe Capacity	Bolt Capacity	Bolt Capacity	Weight	
							in.	mm	in.	mm	lb.	kg
97045	531	Bolt Die Head Quick-Open R.H./L.H. 1/4"-1"	Q.O	RH/LH	Yes	500B	-	-	1/4 - 1	3 - 25	7 1/2	3.4
97050	532	Bolt Die Head Quick-Open R.H./L.H. 1 1/8"-2"	Q.O	RH/LH	Yes	500B	-	-	1 1/8 - 2	29 - 51	9	4.1

## Machine NPT Die Heads

Catalog No.	Model No.	Description	How Opened	Thread Direction	Oil Thru Head	Dies Used	Pipe Capacity	Pipe Capacity	Bolt Capacity	Bolt Capacity	Weight	
							in.	mm	in.	mm	lb.	kg
42047	500A	Mono	Q.O	RH	Yes	Mono	1/8	3	-	-	6 3/4	3.1
42052			Q.O	RH	Yes	Mono	1/4	6	-	-	7	3.2
42057			Q.O	RH	Yes	Mono	3/8	10	-	-	-	-
42062			Q.O	RH	Yes	Mono	1/2	13	-	-	7 1/4	3.3
42067			Q.O	RH	Yes	Mono	3/4	19	-	-	-	-
42072			Q.O	RH	Yes	Mono	1	25	-	-	8	3.6
42077			Q.O	RH	Yes	Mono	1 1/4	29	-	-	-	-
42082			Q.O	RH	Yes	Mono	1 1/2	38	-	-	8 1/2	3.9
42087			Q.O	RH	Yes	Mono	2	51	-	-	-	-

Used On: 1215, 1233, 535, 535A, 1822 Machines and 300, 300 Compact and 300-A w/carriage.

No. 811A Die Head replaces No. 811 and No. 841 Die Heads.

No. 815A Die Head replaces No. 815 and No. 845 Die Heads.

No. 500A Die Head replaces No. 500 Mono Die Heads.

No. 555 Die Head replaces No. 515.

Note: British Die Heads use British Dies only.

Note: 531 and 532 Die Heads replace 500B Die Head.

Individual Machine Die Heads do not include Dies.

## Die Head Racks for All Machine Die Heads

Catalog No.	Model No.	Description	Weight	
			lb.	kg
42485	4U	4 Heads	8 1/2	3.9
42490	6U	6 Heads	12 1/2	5.7



See page 4.12

# Power Threading Machines



Stand not included

## 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 with a 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	Frequency	Phase	Motor Type	Amp Draw	Power	Weight	
					V	Hz			A	Power	lb.	kg
26092	1224	1/4" - 4" NPT Hammer Chuck Machine	711/714	36/12	120	60	1	Induction	151	1 1/2 HP	509	231
26097			711/714	36/12	230	60	1	Induction	8	1 1/2 HP		
26127			911/914	36/12	120	60	1	Induction	151	1 1/2 HP		
26112		1/4" - 4" BSPT Hammer Chuck Machine	911/914	36/12	115	50	1	Induction	151	1700 W	463	210
26122			911/914	36/12	230	60	1	Induction	8	1700 W	509	231
29858*			711/714	36/12	230	50 - 60	1	Induction	8	1700 W	463	210

\* Threading oil not included.

## Standard Equipment

Catalog No. Model No.	Description	26092 1224	26097 1224	26127 1224	26112 1224	26122 1224	29858 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						
26217	1/4"-4" Blade-Type Reamer						
33125	Wheel, Cutter F229 3 & 4 HD						

Catalog No. Model No.	Description	26092 1224	26097 1224	26127 1224	26112 1224	26122 1224	29858 1224
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						

See page 4.12





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	19.3
92457	100A	Universal Leg & Tray Stand	75	34.5
92462	150A	Universal Wheel & Tray Stand	103	46.7
92467	200A	Universal Wheel & Cabinet Stand	104	47.2

## Die Heads

Catalog No.	Model No.	Description	Capacity	Capacity	Weight	
			in.	mm	lb.	kg
26132	711	Diehead, 711, SO Univ. L/Dies	¼ - 2	6.4 - 50.8	12.2	5.6
26137	911	Diehead, 911 SO BSPT L/Dies	¼ - 2	6.4 - 50.8		
26142	713	Universal Quick-Opening L.H., NPT	¼ - 2	64.0 - 102.0		
26147	913	Diehead, 913 QO BSPT L/Dies	¼ - 2	6.4 - 50.8		
26152	714	Diehead, 714 SO Recd L/Dies	2 ½ - 4	6.4 - 50.8	30	13.6
26157	914	Receding Self-Opening R.H., BSPT	2 ½ - 4	64.0 - 102.0		
26162	541	Quick-Opening Bolt L.H./R.H.	¼ - 1	6.4 - 25.4	7.5	3.4
26167	542		1 ⅞ - 2	29.0 - 50.8	9.2	4.2
55447	725	Cut-Grooving Die Head	2 ½ - 4	64.0 - 102.0	30	13.6
55452	766	Blade Type Cutter	¾ - 4	64.0 - 88.9	21	9.5
57492	-	4" Grooving Die Set	-	-	2.2	1
57497		2 ½"-3 ½" Grooving Die Set	2 ½ - 3 ½	102		
57502		4" Grooving Bit only	-	-		
57507	-	2 ½"-3 ½" Grooving Bit only	-	19.0 - 102.0	-	-
58712	-	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	Capacity	Weight	
		in.	mm	lb.	kg
26192	Dies. 1224 2 - ½" - 4 NPT HS	2 ½ - 4	62.0 - 100.0	2.2	1
33642	1224 H.S. Dies BSPT	2 ½ - 4	62.0 - 100.0		
31827	1224 H.S. NPT Dies for Plastic-Coated Pipe	2 ½ - 4	62.0 - 100.0		
31832	1224 H.S. BSPT Dies for Plastic-Coated Pipe	2 ½ - 4	62.0 - 100.0		
32237	1224 H.S. Dies NPT for PVC	2 ½ - 4	62.0 - 100.0	2	1
32242	1224 H.S. Dies BSPT for PVC	2 ½ - 4	62.0 - 100.0		
33057	1224 H.S. Dies NPT for Stainless Steel	2 ½ - 4	62.0 - 100.0		
33072	1224 45° Beveling Dies	2 ½ - 4	62.0 - 100.0		
33077	1224 37 ½° Beveling Dies	2 ½ - 4	62.0 - 100.0		
44992	1224 Bevel Guide Set	2 ½ - 4	62.0 - 100.0		
44997	1224 37 ½° 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	Capacity	Weight	
			in.	mm	lb.	kg
51005	819	Nipple Chuck Complete, ½" - 2" NPT	0.5 - 2.0	6.0 - 50.0	10.5	4.8
61122	840A	Universal Drive Shaft	-	-	31	14.1
26187	-	Jaw Insert and Roll Set for PE-Coated Pipe	-	-	0.2	0.1
26212	764	¼"-4" Wheel-Type Cutter	-	-	19	8.6
26217	744	¼"-4" Blade-Type Reamer	-	-	13	5.9
26707	-	Transmission Grease, 1 Lb.	-	-	1	0.5
34157	419	Nipple Chuck 2 ½" NPT	-	-	5.5	2.5
34162		Nipple Chuck 3" NPT	-	-		
34167		Nipple Chuck 4" NPT	-	-		
34172		Nipple Chuck 2½" BSPT	-	-		
34177		Nipple Chuck 3" BSPT	-	-		
34182		Nipple Chuck 4" BSPT	-	-		
34577	-	Reamer Blade ¼" - 4"	-	-	0.5	0.2



See page 4.12

# 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			
	½"-27	¼"-¾"-18	½"-¾"-14	1"-2"-11 ½	½"-27	¼"-¾"-18	½"-¾"-14	1"-2"-11 ½
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			
	½"-28	¼"-¾"-19	½"-¾"-14	1"-2"-11	½"-28	¼"-¾"-19	½"-¾"-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	½"-¾"-18	¾"-1 ¼"-16	1 ½"-2 ½"-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)								
	½"-27	¼"-18	¾"-18	½"-14	¾"-14	1"-11 ½	1¼"-11 ½	1 ½"-11 ½	2"-11 ½
<b>(NPT)</b>									
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
<b>(NPSM)</b>									
High-Speed RH	-	-	-	50895	50900	50905	50910	50915	50920

## Pipe Dies for ¼"-¾" Dual Die Heads

Die Material or Type	(NPT) Nominal Pipe-Threads Per Inch
	¼"-¾"-18 TPI
High-Speed RH	47940

## Pipe Dies for Models 514 (LH), 515 (RH), 555 (RH), and ½"-¾" Dual Die Heads

Die Material or Type	(NPT)			(BSPT)	
	Nominal Pipe Size-Threads Per Inch			Nominal Pipe Size-Threads Per Inch	
	½"-27	¼"-¾"-18	½"-¾"-14	¼"-¾"-19	½"-¾"-14
Alloy RH	-	-	47880	66955	66880
High-Speed RH	47885	47890	47895	66905	23297
H.S. For Stainless Steel RH	47900	47905	47910	-	66920

Alloy dies thread aluminum and black pipe.  
 High-speed dies thread galvanized pipe.  
 Stainless steel dies thread red brass pipe.  
 PVC dies thread yellow brass pipe.

See page 4.12



# 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	2 1/2"-4"x8 TPI	2 1/2"-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
1/4" - 20	48215	1/4" - 28	48295	1/4" - 20	*67880
5/16" - 18	48220	–	–	5/16" - 18	*67885
3/8" - 16	48225	3/8" - 24	48305	3/8" - 16	*67890
7/16" - 14	48230	7/16" - 20	48310	7/16" - 14	–
1/2" - 13	48235	1/2" - 20	48315	1/2" - 12	*67900
9/16" - 12	48240	9/16" - 18	48320	9/16" - 12	*67905
5/8" - 11	48245	5/8" - 18	48325	5/8" - 11	*67910
3/4" - 10	48250	3/4" - 16	48330	3/4" - 10	*67915
7/8" - 9	48255	7/8" - 14	48335	7/8" - 9	67920
1" - 8	48260	1" - 14NS	48340	1" - 8	*67925
1 1/8" - 7	48265	1" - 12	48375	1 1/8" - 7	–
1 1/4" - 7	48270	1 1/8" - 12	48345	1 1/4" - 7	*67935
1 3/8" - 6	48275	1 1/4" - 12	48350	1 3/8" - 6	–
1 1/2" - 6	48280	1 3/8" - 12	48355	1 1/2" - 6	*67945
1 3/4" - 5	48285	1 1/2" - 12	48360	1 3/4" - 5	–
2" - 4 1/2	48290	–	–	2" - 4 1/2	67955

\* Requires British model die head.

## 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	37 1/2° Bevel Die Set	1/2-3/4	12-20	Universal	1	0.5
50960	37 1/2° Bevel Die Set	1-2	25-50	Universal	1	0.5
52202	45° Bevel Die Set	1/2-3/4	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	1/2-3/4	12-20	Universal	1	0.5
50985	Grooving Die Set	1-2	25-50	Universal	1	0.5

Note: 2 1/2 - 4 Beveling Dies are available for the Model 1224 threading Machine.  
See accessories for Model 1224.  
Note: Universal Dies fit all Universal Die Heads.

## 1210 Dies

NPT	
1/2" - 3/4"	1"
67807	67812



See page 4.12

## Bolt Dies for Models 500B, 532 and 542 Die Heads

(8 UN)	
Rod Size – TPI	RH High-Speed
1 1/8" - 8	49215
1 1/4" - 8	49220
1 3/8" - 8	49225
1 1/2" - 8	49230
1 3/4" - 8	49240
1 7/8" - 8	49245
2" - 8	49250
	<b>(12 UN)</b>
2" - 12	49345

## 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
⅜"-18	48610	48915	⅜"-24	48695
½"-16	48615	48920	½"-24	48700
⅞"-14	48620	48925	⅞"-20	48705
1"-13	48625	48930	1"-20	48710
1 ¼"-12	48630	48935	1 ¼"-18	48715
1 ½"-11	48635	48940	1 ½"-18	48720
1 ¾"-10	48640	48945	1 ¾"-16	48725
2"-9	48645	48950	2"-14	48730
2 ¼"-8	48650	48955	2 ¼"-12	48735
2 ½"-7	48655	48960	2 ½"-14NS	49305
2 ¾"-7	48660	48965	2 ¾"-12	48740
3"-6	48665	48970	3"-12	48745
3 ½"-6	48670	48975	3 ½"-12	–
4"-5	48675	–	4"-12	48755
4 ½"-4 ½	48680	48985	–	–



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

For use with Models 532, 542 and 500B 1 ½"-2" Die Heads

(BSW)	
Rod Size - TPI	RH High-Speed
¼"-20	–
⅜"-18	–
½"-16	67615
⅞"-14	67620
1"-12	67625
1 ¼"-12	–
1 ½"-11	67635
1 ¾"-10	67640
2"-9	67645
2 ¼"-8	67650
2 ½"-7	67655
2 ¾"-7	67660
3"-6	67665
3 ½"-6	–
4"-5	67675
4 ½"-5	–
5"-4 ½	67685
5 ½"-4 ½	–

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

For use with Models 532, 542 and 500B 1 ½"-2" Die Heads

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

Cat No.			
(UNC)		(UNF)	
RH High-Speed	Rebar Size– TPI	RH High-Speed	Rebar Size– TPI
34077	⅜"-16	85850	1"-8
34082	½"-13	79120	1 ½"-7
34087	⅝"-11	85855	1 ¾"-6
34092	¾"-10	–	–

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

For use with Models 532, 542 and 500B 1 ½"-2" Die Heads

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	–	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 ¾"-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 metric high-speed rebar dies, Series B, ISO, see price list.

# Nipple Chucks / Adapters



## 819 NIPPLE CHUCK KIT

- Holds short or close nipples for threading.
- For use with 300 Power Drive, 300 Compact, 535 and 1822 (with adapter kit) and 1224 Threading Machines.
- Body is 2", no adapter necessary.

Catalog No.	Model No.	Description	Weight	
			lb.	kg
51005	819	Nipple Chuck Complete, 1/2" - 2" NPT	10 1/2	4.8
68160		Nipple Chuck 1/2"-2" BSPT		
35867	839	Adapter Kit for Model 1822/535A Machine	16 1/2	7.5
51020	D-380-X	Nipple Chuck Wrench	1/4	-
62457	1219	Nipple Chuck, NPT For 1215	5 3/4	-

## Standard Equipment

Catalog No. Model No.	Description	51005 819
51020	Nipple Chuck Wrench	I
51035	Insert, nipple chuck	I
51055	Adaptor, 1/2 NPT	I
51060	Adaptor, Stud 3/4 NPT	I
51065	Adaptor Stud 1" NPT	I
51070	Adaptor, Stud 1-1/4 NPT	I
51075	Adaptor, Stud 1-1/2 NPT	I

## Pipe Adapters

Catalog No.	Model No.	Thread Type	Sizes		Weight	
			in.	mm	lb.	kg
51040	E-729	NPT	1/8	-	1/2	0.23
51045	E-730		1/4	-		
51050	E-731		3/8	-		
51055	E-732		1/2	-		
51060	E-733		3/4	-		
51065	E-734		1	-		
51070	E-735		1 1/4	-		
51075	E-736		1 1/2	-		

For use with Model 819 Nipple Chuck to allow close nipple threading of all sizes of pipe smaller than 2 inches.



See page 4.12