

# 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