

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).
- Spindle Speed – 36/12 RPM.
- Motor – 1 1/2 HP, single-phase, 60 Hz or 50 Hz, induction type.
- 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.

Standard Equipment

- 26132 – Diehead, 711 SO Univ L/Dies.
- 26152 – Diehead, 714 SO Recd L/Dies.
- 26192 – Dies. 1224 2-1/2"-4NPT HS.
- 26212 – 1/4"-4" Wheel-Type Cutter.
- 26217 – 1/4"-4" Blade-Type Reamer.
- 33125 – Wheel, Cutter F229.
- 46030 – Key, Hex 3/16.
 - Key, Hex 7/32.
 - Key, Hex 1/4.
- 47795 – Dies, Univ 1/2-3/4 NPT.
- 47750 – Dies, Univ 1-2 NPT.
- 70835 – Nu-Clear.
 - Wrench, 3/4 COMB.
 - Tool Box.

Catalog No.	Model No.	RPM	Capacity	Dies Used	Voltage	Frequency Hz	Weight	
			in.		V		lb.	kg
26092	1224	36/12	1/2 - 4	NPT	120	60	509.0	231.0
26097	1224	36/12	1/2 - 4	NPT	240	60	509.0	231.0
26127	1224	36/12	1/2 - 4	BSPT	120	60	509.0	231.0
26112	1224	36/12	1/2 - 4	BSPT	115	50	463.0	231.0
26122	1224	36/12	1/2 - 4	BSPT	240	60	509.0	231.0
26107	1224	36/12	1/2 - 4	BSPT	220	50	463.0	210.0
31442	1224	36/12	1/2 - 4	NPT	220	50	463.0	210.0





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	74.50

Die Heads

Catalog No.	Model No.	Description	Capacity		Weight	
			in.	mm	lb.	kg
26132	711	Universal Self-Opening R.H.. NPT	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 - 50.8	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	Receding Self-Opening R.H.. NPT	2 1/2 - 4	64 - 102	30.0	13.6
26157	914	Receding Self-Opening R.H.. BSPT	2 1/2 - 4	64 - 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	64 - 102	30.0	13.6
55452	766	Blade Type Cutter	3/4 - 4	64 - 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	-	-	-	-

Note: Die Heads do not include dies. All Die Heads are through-head oiling
*Not for use with stainless steel

Pipe Dies

Catalog No.	Description	Capacity		Weight	
		in.	mm	lb.	kg
26192	1224 H.S. Dies NPT	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	1/2 - 2	12 - 50	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



See page 4.12