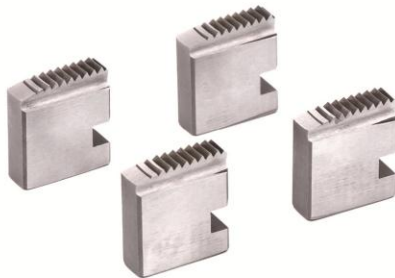


THREADING AND GROOVING

Threading Dies



Product Description

- The proven quality dies with precise cutting geometry ensure an excellent start-cutting performance, easy threading and ensure clean threads.
- Dies in a high-quality special-grade steel, fully tempered and hardened, for long life usage.
- Teeth milling process: To further improve threading performance, dies will undergo teeth milling process with special milling tool. It will improve the teeth geometry and surface.

Dies interchangeable with RIDGID type, fits ratchet threader, portable threader

Description	Size / Catalog number					
	1/2"	3/4"	1"	1 1/4"	1 1/2"	2"
NPT HSS	21820301	21820401	21820501	21820601	21820701	21820801
NPT Alloy	21820302	21820402	21820502	21820602	21820702	21820802
BSPT HSS	21810301	21810401	21810501	21810601	21810701	21810801
BSPT Alloy	21810302	21810402	21810502	21810602	21810702	21810802

Dies interchangeable with RIDGID type, fits threading machine

Description	Size / Catalog number				
	1/4"-3/8"	1/2"-3/4"	1"-2"	2 1/2"-3"	2 1/2"-4"
NPT HSS	---	21120101	21120201	---	---
NPT HS	21120604	21120104	21120204	---	21120404
NPT CS	21120602	21120102	21120202	---	---
BSPT HSS	---	21110101	21110201	---	---
BSPT HS	21110604	21110104	21110204	21110304	21110404
BSPT CS	21110602	21110102	21110202	21110302	---
BSPP HS	---	22130101	22130201	---	---

**THREADING AND GROOVING**



For 141 die head

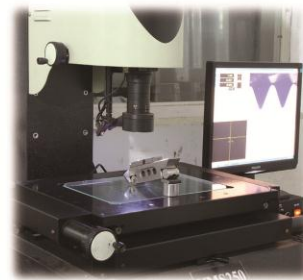
Description	Size / Catalog number
	2 1/2"-4"
NPT HS	21720401

Metric Dies interchangeable with RIDGID type, fits threading machine

Description	Size / Catalog number						
	M12	M14-16	M18-22	M24-27	M30-33	M36-39	M42-45
Metric Alloy	22150701	22150801	22150901	22151001	22151101	22151201	22151301

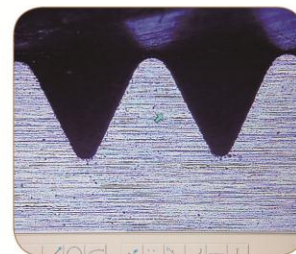
Dies interchangeable with REX type, fits threading machine

Description	Size / Catalog number			
	1/2"-3/4"	1"-2"	2 1/2"-3"	2 1/2"-4"
NPT HS	21220104	21220204	---	21220404
NPT CS	21220102	21220202	---	21220402
BSPT HS	21210104	21210204	21210304	21210404
BSPT CS	21210102	21210202	21210302	21210402



F4 type dies fits Threading Machine: SQ50C, SQ100D

Description	Size / Catalog number	
	1/2"-3/4"	1"-2"
NPT HS	---	---
NPT Alloy	21520102	21520202
BSPT HS	21510103	21510203
BSPT Alloy	21510102	21510202



Teeth projection (BSPT)

**THREADING AND GROOVING**

**100 type dies fits Threading Machine: SQ50B1, SQ80D1, SQ100D1**

Description	Size / Catalog number				
	1/4"-3/8"	1/2"-3/4"	1"-2"	2 1/2"-3"	2 1/2"-4"
NPT HS	---	21320103	21320203	---	21220404
NPT CS	---	21320102	21320202	21320302	21220402
BSPT HS	---	21310103	21310203	21310303	21210404
BSPT CS	---	21310102	21310202	21310302	21210402

- CS standard: high quality alloy, teeth milling, special heat treatment
- HS standard: high quality high speed steel, teeth milling, special heat treatment
- HSS standard: super quality high speed steel, teeth milling

Dies level	Detailed Characteristics			
	Material	Teeth milling	Precise machining	Special heat treatment
Alloy	High quality alloy		●	
CS	High quality alloy	●	●	●
HS	High quality HSS	●	●	●
HSS	Premier quality HSS	●	●	●

THREADING AND GROOVING

Threading Machine

**SQ40**



**Capacity**

- Pipe: ¼"-1½" (8mm-40mm)
- Bolt: 12mm-33mm

**Features**

- Compact, light weight design.
- Powerful motor and transmission.
- Through die head oiling.

**Technical Specifications**

- Motor: 1500W universal, 50/60Hz
- Switch: ON/OFF heavy duty switch, foot switch and FOR/OFF/REV switch optional
- Spindle Speed: 56 RPM
- Front Chuck: Hammer type with replaceable rocker action jaw inserts.
- Rear Centering Device: Cam action.
- Oiling: Through die head.
- Oil Pump: Self-priming constant flow.

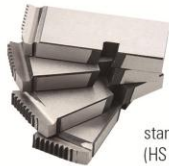
**Standard dies**

- ¼"-3/8" universal CS dies set.
- ½"-¾" universal CS dies set.
- 1"-2" universal CS dies set.

**Ordering Information**

Catalog No.	Model No.	Description	Spindle Speed RPM	Pipe Threading Capacity		Rod Threading Capacity	N.W (kg)
				in.	mm.	metric	
301503	SQ40	110V, 50/60Hz	38	¼-1½	8-40	M12-M33	38
302502	SQ40	220V, 50/60Hz	38	¼-1½	8-40	M12-M33	38

\* Die head and dies, order separately.



standard dies (HS standard)



425 die head



reinforced cutting wheel

**Accessories**

Catalog No.	Model No.	Description	N.W(kg)
	425	Die head, Quick-open (standard)	5.3
	424	Die head, Self-open (optional)	5.8
40601009		reinforced cutting wheel	

THREADING AND GROOVING

Power Drive

**SQ50D**



**Features**

- Speed Chuck
- Reversible 1500W universal motor.
- Recessed On/Off/Reverse switch.
- Approval by CSA and CE standards.
- Ideal for use with roll groover attachment and threading attachment.

**Specifications**

- **Motor:** 1500W Universal, reversible motor, single-phase, 110V or 220V, 50/60Hz.
- **Switch:** Heavy-duty FOR/OFF/REV and Integral Foot Switch.
- **Chuck:** Speed chuck with replaceable rocker-action jaws.
- **Spindle Speed:** 38 RPM (57 RPM available)
- **Rear Centering Device:** Cam-action turns with chuck.
- **Support Bar:** Heavy-duty

**Ordering Information**

Catalog No.	Model No.	Description	Spindle Speed RPM	N.W(kg)
302306	SQ50D PD	110V, 50/60Hz	38	55
302307	SQ50D PD	110V, 50/60Hz	57	55
302305	SQ50D PD	220V, 50/60Hz	38	55



With GC02 Groover



With YG12A Groover



With Threading Attachment



THREADING AND GROOVING

Threading Machine Complete



**SQ50D**

**Standard Equipment**

- Model SQ50D Power Drive with foot switch
- Quick-open die head, universal
- 1/2"-3/4" universal HS dies set.
- 1"-2" universal HS dies set.
- Cutter: Capacity: 1/8"-2"(6mm-50mm) pipe
- Reamer: Positive-locking, 5-flute cone, right-hand 1/8"-2" (6mm-50mm).
- Carriage with lever.
- TRIPOD support stand
- Oiler

**Ordering Information**

Catalog No.	Model No.	Description	Spindle Speed RPM	Pipe Threading Capacity		Rod Threading Capacity	N.W(kg)
				in.	mm.	metric	
302302	SQ50D complete	110V, 50/60Hz	38	1/4-2	6-50	M12-M45	80
302301	SQ50D complete	220V, 50/60Hz	38	1/4-2	6-50	M12-M45	80



standard dies (HS standard)



425 die head



reinforced cutting wheel



Model SQ50D with "T" Transporter (for optional)

THREADING AND GROOVING

Threading Machine



Capacity

- Pipe: ¼"-2"(8mm-50mm)
- Bolt: 12mm-45mm

**SQ50**

Features

- Compact, light weight design.
- Powerful motor and transmission.
- Through die head oiling.
- Approved by CSA and CE standards.

Technical Specifications

- Motor: 1500W universal, 50/60Hz
- Switch: ON/OFF heavy duty switch, foot switch and FOR/OFF/REV switch optional
- Spindle Speed: 38 RPM
- Front Chuck: Hammer type with replaceable rocker action jaw inserts.
- Rear Centering Device: Cam action.
- Oiling: Through die head.
- Oil Pump: Self-priming constant flow.



standard dies (HS standard)

Standard dies

- ½"-¾" universal HS dies set.
- 1"-2" universal HS dies set.

Ordering Information

Catalog No.	Model No.	Description	Spindle Speed RPM	Pipe Threading Capacity		Rod Threading Capacity	N.W(kg)
				in.	mm.	metric	
302502	SQ50	110V, 50/60Hz	38	¼-2	8-50	M12-M45	67
302501	SQ50	220V, 50/60Hz	38	¼-2	8-50	M12-M45	67

\* Die head and dies, order separately.



428 die head (standard)

Accessories

Catalog No.	Model No.	Description	N.W(kg)
	428	Die head, Quick-open (standard)	5.6
	425	Die head, Quick-open (optional)	5.3
	424	Die head, Self-open (optional)	5.8
40601009		reinforced cutting wheel	



reinforced cutting wheel

THREADING AND GROOVING

Threading Machine

**SQ50E**



**Capacity**

- Pipe: 1/4"-2"(8mm-50mm)
- Bolt: 12mm-45mm

**Features**

- Heavy-duty proven performance.
- Fast transport and set-up.
- Self-Contained Oil System with adjustable flow control.
- Approved by CE standards.

**Technical Specifications**

- Motor: 1500W universal, 50/60Hz
- Switch: ON/OFF heavy duty switch, foot switch and FOR/OFF/REV switch are optional
- Spindle Speed: 38 RPM.
- Front Chuck: Hammer type with replaceable rocker action jaw inserts.
- Rear Centering Device: Cam action.
- Oiling System: Through die head, with intergral oil reservoir.
- Pump: Self-priming adjustable flow, gerotor pump.



standard dies (HS standard)



424 die head (standard)



reinforced cutting wheel



651 stand (optional)

**Standard Dies**

- 1/2"-3/4" universal HS dies set.
- 1"-2" universal HS dies set.

**Ordering Information**

Catalog No.	Model No.	Description	Spindle Speed RPM	Pipe Threading Capacity		Rod Threading Capacity*	N.W (kg)
				in.	mm.	metric	
302312	SQ50E	110V, 50/60Hz	38	1/4-2	8-50	M12-M45	75
302311	SQ50E	220V, 50/60Hz	38	1/4-2	8-50	M12-M45	75

\* Die head and dies, order separately.

**Accessories**

Catalog No.	Model No.	Description	N.W(kg)
	425	Die head, Quick-open (optional)	5.3
	424	Die head, Self-open (standard)	5.8
11001004	651	Pneumatic Folding Wheel Stand (optional)	22
40601003		reinforced cutting wheel	



THREADING AND GROOVING

Threading Machine



**SQ50F**

**Capacity**

- Pipe: ¼"-2"(8mm-50mm)
- Bolt: 12mm-45mm

**Features**

- Heavy-duty proven performance.
- 1.5KW induction motor ensures quiet operation with high speed.
- Self-Contained Oil System constant flow.
- Approved by CSA and CE standards.

**Technical Specifications**

- Motor: 1500W induction, 50/60Hz
- Switch: ON/OFF heavy duty switch, foot switch and FOR/OFF/REV switch are optional
- Spindle Speed: 38 RPM.
- Front Chuck: Hammer type with replaceable rocker action jaw inserts.
- Rear Centering Device: Cam action.
- Oiling System: Through die head, with intergral oil reservoir.
- Pump: Self-priming constant flow

**Standard Dies**

- ½"-¾" universal HS dies set.
- 1"-2" universal HS dies set.



standard dies (HS standard)



425 die head



reinforced cutting wheel

**Ordering Information**

Catalog No.	Model No.	Description	Spindle Speed RPM	Pipe Threading Capacity		Rod Threading Capacity*	N.W (kg)
				in.	mm.	metric	
302317	SQ50F	110V, 50/60Hz	36	¼-2	8-50	M12-M45	77
302316	SQ50F	220V, 50/60Hz	36	¼-2	8-50	M12-M45	77

\* Die head and dies, order separately.

**Accessories**

Catalog No.	Model No.	Description	N.W(kg)
	425	Die head, Quick-open (optional)	5.3
	424	Die head, Self-open (optional)	5.8
40601003		reinforced cutting wheel	

THREADING AND GROOVING

Threading Machine



**SQ80C1**

**Capacity**

- Pipe: ¼"-3"(8mm-80mm)
- Bolt: 12mm-45mm

**Features**

- Heavy-duty proven performance.
- Fast transport and set-up.
- Self-Contained Oil System with adjustable flow control.
- Approved by CE standards.

**Technical Specifications**

- Motor: 1500W universal, 50/60Hz
- Switch: ON/OFF heavy duty switch, foot switch and FOR/OFF/REV switch are optional
- Spindle Speed: 32 RPM.
- Front Chuck: Hammer type with replaceable rocker action jaw inserts.
- Rear Centering Device: Cam action.
- Oiling System: Through die head, with intergral oil reservoir.
- Pump: Self-priming adjustable flow, gerotor pump.

**Standard Dies**

- ½"-¾" universal HS dies set.
- 1"-2" universal HS dies set.
- 2 1/2"-3" universal HS dies set.

**Ordering Information**

Catalog No.	Model No.	Description	Spindle Speed RPM	Pipe Threading Capacity		Rod Threading Capacity	N.W (kg)
				in.	mm.	metric	
303301	SQ80C1	110V, 60Hz	32	¼-3	8-80	M12-M45	74
303302	SQ80C1	220V, 50Hz	32	¼-3	8-80	M12-M45	74

\* Die head and dies, order separately.

**Accessories**

Catalog No.	Model No.	Description	N.W(kg)
	425	Die head, Quick-open (optional), ¼"-2"	5.3
	424	Die head, Self-open (standard), ¼"-2"	5.8
	432	Die head, Self-open 2½"-3"	6
11001004	651	Pneumatic Folding Wheel Stand (optional)	22
40601008		reinforced cutting wheel	



424 die head



THREADING AND GROOVING

Threading Machine

**SQ100F**



**Capacity**

- Pipe: ¼"-4" (8mm-100mm)
- Bolt: 12mm-45mm

**Features**

- Heavy-duty proven performance.
- Threads ¼"-¾" pipe at 36RPM, 1"-2" at 20RPM, 2½"-4" at 11RPM.
- An induction motor ensures sound levels well when using.
- A special capacitor-start / capacitor run motor allows the machine to thread where voltage drop is experienced.
- Approved by CSA and CE standards.

**Technical Specifications**

- Motor: 1500W induction, 50/60Hz, single phase.
- Switch: ON/OFF heavy duty switch, foot switch and FOR/OFF/REV switch is optional.
- Spindle Speed: 36/20/11 RPM.
- Front Chuck: Hammer type with replaceable rocker action jaw inserts.
- Rear Centering Device: Cam action.
- Oiling System: Through die head, with intergral oil reservoir.

**Standard Dies**

- ½"-¾" universal HS dies set.
- 1"-2" universal HS dies set.
- 2 1/2"-4" universal HS dies set.

**Ordering Information**

Catalog No.	Model No.	Description	Spindle Speed RPM	Pipe Threading Capacity		Rod Threading Capacity	N.W (kg)
				in.	mm.	metric	
304301	SQ100F	110V, 50/60Hz	36/20/11	¼-4	8-100	M12-M45	140
304302	SQ100F	220V, 50/60Hz	36/20/11	¼-4	8-100	M12-M45	140

\* Die head and dies, order separately.

**Accessories**

Catalog No.	Model No.	Description	N.W(kg)
	443	Die head, Self-open, ¼"-2"	6.2
	444	Die head, Self-open, 2½"-4"	14.4
4581011	819	Nipple Chuck (optional)	4.5
40601008		reinforced cutting wheel	



443 die head

444 die head



672A stand (optional)

THREADING AND GROOVING

Threading Machine

**SQ100F-L**



**Capacity**

- Pipe: ½"-4"(8mm-100mm)
- Bolt: 10mm-33mm

**Features**

- Heavy-duty proven performance.
- Threads ½"-¾" pipe at 36RPM, 1"-2" at 20RPM, 2½"-4" at 11RPM.
- An induction motor ensures sound levels well when using.
- A special capacitor-start / capacitor run motor allows the machine to thread where voltage drop is experienced.

**Technical Specifications**

- Motor: 1500W induction, 50/60Hz, single phase.
- Switch: ON/OFF heavy duty switch, foot switch and FOR/OFF/REV switch is optional.
- Spindle Speed: 36/20/11 RPM.
- Front Chuck: Hammer type with replaceable rocker action jaw inserts.
- Rear Centering Device: Cam action.
- Oiling System: Through die head, with intergral oil reservoir.

**Standard Dies**

- ½"-¾" universal HS dies set.
- 1"-2" universal HS dies set.
- 2 1/2"-4" universal HS dies set.

**Ordering Information**

Catalog No.	Model No.	Description	Spindle Speed RPM	Pipe Threading Capacity		Rod Threading Capacity	N.W (kg)
				in.	mm.	metric	
304306	SQ100F-L	110V, 50/60Hz	36/20/11	½-4	8-100	M10-M33	140
304307	SQ100F-L	220V, 50/60Hz	36/20/11	½-4	8-100	M10-M33	140

\* Die head and dies, order separately.

**Accessories**

Catalog No.	Model No.	Description	N.W(kg)
	428	Die head, Self-open, ½"-2"	5.6
	447	Die head, Self-open, 2½"-4"	9
4581011	819	Nipple Chuck (optional)	4.5
40601008		reinforced cutting wheel	



428 die head



447 die head



reinforced cutting wheel



672A stand (optional)



THREADING AND GROOVING

Threading Machine



Ordering Information

Catalog No.	Model No.	Description	Power Watts	Spindle Speed RPM	Pipe Threading Capacity		N.W (kg)
					in.	mm.	
302117	SQ50A	110V, 60Hz	1000	28	1/2-2	15-50	60
302101	SQ50A	220V, 50Hz	1000	28	1/2-2	15-50	60
303103	SQ80A	110V, 60Hz	1100	28/14	1/2-3	15-80	100
303101	SQ80A	220V, 50Hz	1100	28/14	1/2-3	15-80	100
304101	SQ100A	110V, 60Hz	1100	28/12	1/2-4	15-100	140
304111	SQ100A	220V, 50Hz	1100	28/12	1/2-4	15-100	140



THREADING AND GROOVING

Threading Machine

**SQ50B1**



**SQ100D1**



**SQ80D1**



Ordering Information

Catalog No.	Model No.	Description	Power Watts	Spindle Speed RPM	Pipe Threading Capacity		N.W (kg)
					in.	mm.	
302105	SQ50B1	110V, 60Hz	750	23	1/2-2	15-50	60
302106	SQ50B1	220V, 50Hz	750	23	1/2-2	15-50	60
303205	SQ80D1	110V, 60Hz	750	26/11	1/2-3	15-80	100
303206	SQ80D1	220V, 50Hz	750	26/11	1/2-3	15-80	100
304108	SQ100D1	110V, 60Hz	750	24/10	1/2-4	15-100	140
304107	SQ100D1	220V, 50Hz	750	24/10	1/2-4	15-100	140

THREADING AND GROOVING

Threading Machine











Ordering Information




Catalog No.	Model No.	Description	Power Watts	Spindle Speed RPM	Pipe Threading Capacity		N.W (kg)
					in.	mm.	
302118	SQ50C1	110V, 60Hz	900	23	1/2-2	15-50	60
302119	SQ50C1	220V, 50Hz	900	23	1/2-2	15-50	60
303301	SQ80D	110V, 60Hz	900	26/11	1/2-3	15-80	100
303302	SQ80D	220V, 50Hz	900	26/11	1/2-3	15-80	100
304108	SQ100D	110V, 60Hz	900	24/10	1/2-4	15-100	140
304107	SQ100D	220V, 50Hz	900	24/10	1/2-4	15-100	140

THREADING AND GROOVING

Threading Die Heads List

Image	Model No.	For Machines	How Open	Dies type	Capacity	Ref. No.	N.W(kg)
	420	SQ50B1	Receding Self-open	100 type	1/2"-2"	10601003	5.6
	424	SQ40/SQ50/ SQ50D/SQ50E/ SQ50F/SQ50A/ SQ50C1/SQ80C1	Self-open	RIDGID	1/8"-2"	BSPT: 10601012 NPT: 10601013	5.8
	425	SQ40/SQ50/ SQ50D/SQ50E/ SQ50F/SQ50A/ SQ50C1/SQ80C1	Quick-open	RIDGID	1/8"-2"	BSPT: 10601009 NPT: 10601010	5.3
	428	SQ50/SQ50A/SQ50C1/ SQ80C1/SQ80D/ SQ100F-L	Quick-open	REX	1/2"-2"	BSPT: 10602009 NPT: 10602010	5.6
	430	SQ80D1	Receding Self-open	100 type	1/2"-2"	10602001	5.9
	431	SQ80D1	Receding Self-open	100 type	2 1/2"-3"	10602002	7.4
	432	SQ80C1	Self-open	RIDGID	2 1/2"-3"	BSPT: 10602011 NPT: 10602012	6
	433B	SQ80C1/SQ80D/ SQ80A	Quick-open	REX	2 1/2"-3"	10602013	4.9

THREADING AND GROOVING

Image	Model No.	For Machines	How Open	Dies type	Capacity	Ref. No.	N.W(kg)
	440	SQ100D1	Receding Self-open	100 type	1/2"-2"	10603001	6.5
	441	SQ100D/SQ100D1	Receding Self-open	100 type / REX	2 1/2"-4"	10603002	8.8
	442A	SQ100D	Quick-open	REX	1/2"-2"	10603004	6.6
	443	SQ100F	Self-open	RIDGID	1/4"-2"	BSPT: 10603011 NPT: 10603010	6.2
	444	SQ100F	Receding Self-open	RIDGID	2 1/2"-4"	BSPT: 10603009 NPT: 10603008	14.4
	447	SQ100F-L	Quick-open	REX	2 1/2"-4"	10603007	9
	422	SQ50C1	Quick-open	F4		10601006	
	442	SQ100D	Quick-open	F4		10603003	

\* F4 type die heads, only offer as spare parts.