

## Model 1224 Threading Machine



Model 1224

### Capacities

- Pipe: ¼ - 4" (8 - 100 mm) 4 - 6" (100 - 150 mm) with 161 Geared Threader.
- Bolt: ¼ - 2" (6 - 52 mm).

### Features

- Threads ¼ - 2" pipe at 36 RPM and 2½ - 4" at 12 RPM.
- 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 insures sound levels well within the limits set by the regulating authorities.
- A special capacitor-start / capacitor-run motor allows the Model 1224 to thread a full range of material where voltage drop is experienced.
- ¼ - 2" Universal Die Head; 2½ - 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.

### Technical Specifications

- Motor: 1,1 kW, single-phase, 50 Hz induction type.
- Switches: Reverse / Off / Forward, heavy-duty, rotary-type and integral foot switch.
- Spindle Speed: 36/12 RPM.
- Gear Box: Two-speed gear box 3:1 ratio.
- Chuck: Hammer-type with replaceable rocker-action jaw inserts.
- Rear Centering Device: Cam action.
- Cutter: Model 764 full-floating, self-centering ¼ - 4" with F-229 cutter wheel.
- Reamer: Model 744, ¼ - 4" blade-type.
- Oiling: Through die head.
- Pump: Self-priming, gerotor-type, automatic-reversing, constant-flow.

Catalog No.	Model No.	Motor	Capacity (BSPT)	Speed RPM	Die Head		Weight	
			in.		Self Opening 911	Self Opening 914	lb.	kg
26107	1224	230 V, 50 Hz Induction (BSPT)	¼ - 4	36/12	•	•	463	210
26112	1224	115 V, 50 Hz Induction (BSPT)	¼ - 4	36/12	•	•	463	210
29858	1224	230 V, 50 Hz Induction (NPT)	¼ - 4	36/12	711 Die Head	714 Die Head	463	210

### Model 1224 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	164	74,5
22563	-	Steel Cabinet	42	19,3

### Standard Equipment

Model 1224 threading machine with foot switch:

- One Model 714 (914) 2½ - 4" receding self-opening die head.
- One Model 711 (911) ¼ - 2" universal self-opening die head.
- One set ½ - ¾" universal alloy dies.
- One set 1 - 2" universal alloy dies.
- One set 2½ - 4" 1224 high-speed dies.
- One Model 764 cutter.
- One Model 744 reamer.
- One spare F-229 cutter wheel.
- Oil: 5 Litres thread cutting fluid.
- Three (3) hex keys.
- Tools and equipment: 4 Hex keys, heavy-duty F-229 cutter wheel, ¾" combination wrench, tool box.





Model 541  
Model 542



Model 713  
Model 913



Model 714 (914) Style Receding Die Head.

### Die Heads for Model 1224

Catalog No.	Model No.	Description	Capacity		Weight	
			in.	lb.	kg	
26132	711	Universal Self-Opening R.H., NPT	¼ - 2	12¼	5,6	
26152	714	Receding Self-Opening R.H., NPT	2½ - 4	30	13,6	
26137	911	Universal Self-Opening R.H., BSPT	¼ - 2	12¼	5,6	
26157	914	Receding Self-Opening R.H., BSPT	2½ - 4	30	13,6	
26162	541	Quick-Opening Bolt L.H./R.H.	¼ - 1	7½	3,4	
26167	542	Quick-Opening Bolt L.H./R.H.	1½ - 2	9¼	4,2	
55447	725	Cut-Grooving Die Head (does not include dies)	2½ - 4	30	13,6	
57497	-	2½ - 3½" Grooving Die Set	2½ - 3½	2¼	1,0	
57507	-	2½ - 3½" Grooving Bit only	-	-	-	
57492	-	4" Grooving Die Set	4	2¼	1,0	
57502	-	4" Grooving Bit only	-	-	-	
55452	766	Blade Type Cutter	¾ - 4	21	9,5	

Note: Die Heads do not include dies. All Die Heads are through-head oiling.

### Pipe Dies 2½" - 4" (for ¼" - 2" see pages 4.30 - 4.31)

Catalog No.	Description	Capacity		Weight	
		in.	lb.	kg	
26192	1224 H.S. Dies NPT	2½ - 4	2¼	1,0	
33642	1224 H.S. Dies BSPT	2½ - 4	2¼	1,0	
31827	1224 H.S. NPT Dies for Plastic-Coated Pipe	2½ - 4	2¼	1,0	
31832	1224 H.S. BSPT Dies for Plastic-Coated Pipe	2½ - 4	2¼	1,0	
32237	1224 H.S. Dies NPT for PVC	2½ - 4	2	1,0	
32242	1224 H.S. Dies BSPT for PVC	2½ - 4	2	1,0	
33057	1224 H.S. Dies NPT for Stainless Steel	2½ - 4	2	1,0	
33072	1224 45° Beveling Dies	2½ - 4	2	1,0	
33077	1224 37½° Beveling Dies	2½ - 4	2	1,0	
44992	1224 Bevel Guide Set	2½ - 4	2	1,0	
44997	1224 37½° Bevel Bit Only	-	-	-	
45002	1224 45° Bevel Bit Only	-	-	-	

Note: NPSM/BSPP threads are made with NPT/BSPT by adjusting the die head. See manual for details.

### Accessories

Catalog No.	Model No.	Description	Capacity		Weight	
			in.	lb.	kg	
26212	764	¼" - 4" Wheel-Type Cutter	-	19	8,6	
26217	744	¼" - 4" Blade-Type Reamer	-	13	5,9	
34577	-	¼" - 4" Reamer Blade	-	½	0,2	
26187	-	Jaw Insert and Roll Set for PE-Coated Pipe	-	¼	0,1	
51005	819	Nipple Chuck 2½ - 2" NPT (See page 4.33)	½ - 2	10½	4,8	
34157	419	Nipple Chuck 2½" NPT	-	5½	2,5	
34162	419	Nipple Chuck 3" NPT	-	5½	2,5	
34167	419	Nipple Chuck 4" NPT	-	5½	2,5	
34172	419	Nipple Chuck 2½" BSPT	-	5½	2,5	
34177	419	Nipple Chuck 3" BSPT	-	5½	2,5	
34182	419	Nipple Chuck 4" BSPT	-	5½	2,5	
61122	840A	Universal Drive Shaft	-	31	14,1	
26707	-	Gear Grease (1224 & 1822)	-	1	0,5	



See page 4.12