

# ROUND DIES

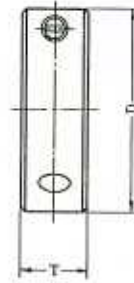
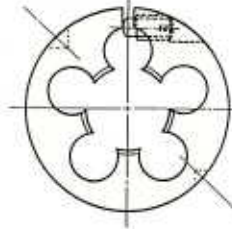
RUNDE SCHNEIDEISEN  
HILERAS DE ROSCAR REDONDAS  
FILIERES

**METRIC**

ART NO.822

## Round Adjustable Dies

Metric sizes



**High Speed Steel  
Tungsten Steel  
ALLOY Steel**

Nominal Diameter (mm)	Coarse Pitch (mm)	Fine-1 Pitch (mm)	Fine-2 Pitch (mm)	Fine-3 Pitch (mm)	Fine-4 Pitch (mm)	Outside Diameter and Thickness														
						13/16(20) × 1/4	1(25) × 3/8	1 5/16(33) × 7/16	1 1/2(38) × 1/2	2(50) × 5/8	2 1/4(57) × 3/4	2 1/2(63) × 3/4	2 3/4(70) × 1	3(75) × 1	4(100) × 1 1/4	5(127) × 1 1/2				
1	0.25	0.2				13/16	1													
1.2	0.25	0.2				13/16	1													
1.4	0.3	0.2				13/16	1													
1.7	0.35	0.25	0.2			13/16	1													
2	0.4	0.25				13/16	1	1 5/16	1 1/2											
2.3	0.4	0.25				13/16	1	1 5/16	1 1/2											
2.6	0.45	0.35				13/16	1	1 5/16	1 1/2											
3	0.6	0.35				13/16	1	1 5/16	1 1/2											
3	0.5					13/16	1	1 5/16	1 1/2											
3.5	0.6	0.35				13/16	1	1 5/16	1 1/2											
4	0.75	0.5				13/16	1	1 5/16	1 1/2											
4	0.7					13/16	1	1 5/16	1 1/2											
4.5	0.75	0.5				13/16	1	1 5/16	1 1/2											
5	0.9	0.5				13/16	1	1 5/16	1 1/2											
5	0.8					13/16	1	1 5/16	1 1/2	2										
5.5	0.9	0.5				13/16	1	1 5/16	1 1/2	2										
6	1	0.75	0.5			13/16	1	1 5/16	1 1/2	2										
7	1	0.75	0.5			13/16	1	1 5/16	1 1/2	2										
8	1.25	1	0.75	0.5		13/16	1	1 5/16	1 1/2	2										
9	1.25	1	0.75	0.5		13/16	1	1 5/16	1 1/2	2										
10	1.5	1.25	1.0	0.75			1	1 5/16	1 1/2	2										
11	1.5	1.25	1.0	0.75			1	1 5/16	1 1/2	2										
12	1.75	1.5	1.25	1.0	0.5		1	1 5/16	1 1/2	2										
13	1.75	1.5	0.5					1 5/16	1 1/2	2										
14	2	1.5	1.25	1.0	0.5				1 1/2	2										
15	2	1.5	1.0	0.5					1 1/2	2	2 1/4	2 1/2								
16	2	1.5	1.0	0.5					1 1/2	2	2 1/4	2 1/2								
17	2	1.5	1.0	0.5					1 1/2	2	2 1/4	2 1/2								
18	2.5	2	1.5	1.0	0.5				1 1/2	2	2 1/4	2 1/2								
20	2.5	2	1.5	1.0	0.5				1 1/2	2	2 1/4	2 1/2								
22	2.5	2	1.5	1.0	0.5					2	2 1/4	2 1/2								
24	3	2	1.5	1.0	0.5					2	2 1/4	2 1/2								
25	3	2	1.5	1.0	0.5					2	2 1/4	2 1/2								
26	3	2	1.5	1.0	0.5					2	2 1/4	2 1/2							3	
27	3	2	1.5	1.0	0.5					2	2 1/4	2 1/2							3	
28	3	2	1.5	1.0	0.5					2	2 1/4	2 1/2	2 3/4	3					3	
30	3.5	2	1.5	1.0	0.5					2	2 1/4	2 1/2	2 3/4	3					3	
32	3.5	2	1.5	1.0	0.5					2	2 1/4	2 1/2	2 3/4	3					3	
33	3.5	2	1.5	1.0	0.5					2	2 1/4	2 1/2	2 3/4	3					3	
34	3.5	2	1.5	1.0	0.5					2	2 1/4	2 1/2	2 3/4	3					3	
36	4	2	1.5	1.0	0.5							2 1/2	2 3/4	3					3	
38	4	2	1.5	1.0	0.5							2 1/2	2 3/4	3					3	
39	4	2	1.5	1.0	0.5							2 1/2	2 3/4	3					3	
40	4	2	1.5	1.0	0.5							2 1/2	2 3/4	3					3	
42	4.5	3	1.5	1.0	0.5							2 1/2	2 3/4	3					3	
45	4.5	3	1.5	1.0	0.5							2 1/2	2 3/4	3					3	
48	5	3	1.5	1.0	0.5							2 1/2	2 3/4	3					3	
50	5	3	1.5	1.0	0.5							2 1/2	2 3/4	3					3	
52	5	3	1.5	1.0	0.5							2 1/2	2 3/4	3					3	
55	5	3	1.5	1.0	0.5							2 1/2	2 3/4	3					3	
56	5.5	3	1.5	1.0	0.5							2 1/2	2 3/4	3					3	
58	5.5	3	1.5	1.0	0.5							2 1/2	2 3/4	3					3	
60	5.5	3	1.5	1.0	0.5							2 1/2	2 3/4	3					3	
62	6.0	3	1.5	1.0	0.5							2 1/2	2 3/4	3					3	
64	6	3	1.5	1.0	0.5							2 1/2	2 3/4	3					3	
65	6	3	1.5	1.0	0.5							2 1/2	2 3/4	3					3	
68	6	3	1.5	1.0	0.5							2 1/2	2 3/4	3					3	

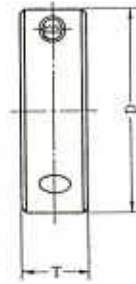
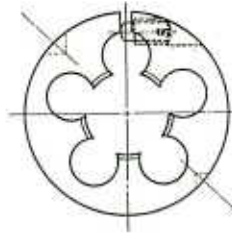
Angle of Thread 60° 12(g) 25(g) 80(g) 90(g) 180(g) 250(g) 330(g) 400(g) 600(g) 950(g) 1850(g)

# ROUND DIES

RUNDE SCHNEIDEISEN  
HILERAS DE ROSCAR REDONDAS  
FILIERES

ART NO.820

## Gas Pipe Round Adjustable Dies BSPT BSPP NPT NPS



**High Speed Steel**  
**Tungsten Steel**  
**ALLOY Steel**

Cutting Size Per inch	Thread To in BSPT BSPPS	Thread To in NPT NPS	Outside Diameter and Thickness										
			1 × 3/8	1 1/2 × 1/2	2 × 5/8	2 1/4 × 3/4	2 1/2 × 3/4	3 × 1	4 × 1 3/16	5 × 1 3/8			
1/16	28	27	1	1 1/2									
1/8	28	27	1	1 1/2									
1/4	19	18		1 1/2									
3/8	19	18		1 1/2	2								
1/2	14	14		1 1/2	2	2 1/4							
5/8	14	14			2	2 1/4							
3/4	14	14			2	2 1/4	2 1/2						
7/8	14	11 1/2				2 1/4	2 1/2	3					
1	11	11 1/2				2 1/4	2 1/2	3	4				
1 1/8	11	11 1/2					2 1/2	3	4				
1 1/4	11	11 1/2						3	4	5			
1 3/8	11	11 1/2						3	4	5			
1 1/2	11	11 1/2						3	4	5			
1 5/8	11	11 1/2						3	4	5			
1 3/4	11	11 1/2							4	5			
2	11	11 1/2								5			
2 1/4	11	11 1/2								5			
2 1/2	11	8								5			
2 3/4	11	8											
3	11	8											
3 1/4	11	8											
3 1/2	11	8											
3 3/4	11	8											
4	11	8											

## British Standard Brass Dies

Size inch	Thread per inch	Outside Diameter inch		
1/4	26	1	1 1/2	
5/16	26	1	1 1/2	
3/8	26	1	1 1/2	
7/16	26	1	1 1/2	
1/2	26	1	1 1/2	2
5/8	26	1	1 1/2	2
3/4	26		1 1/2	2
7/8	26			2
1	26			2

## British Standard Conduit Dies

Size inch	Thread per inch	Outside Diameter inch		
5/8	18	1 3/8	2 1/4	
3/4	16	1 5/8	2 1/4	
1	16	1 5/8	2 1/4	
1 1/4	16		2 1/4	
1 1/2	14			3 3/16
2	14			3 3/16

## Metric Conduit Dies

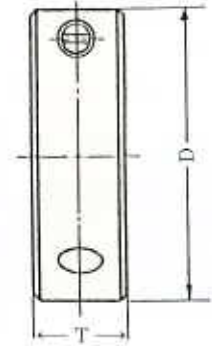
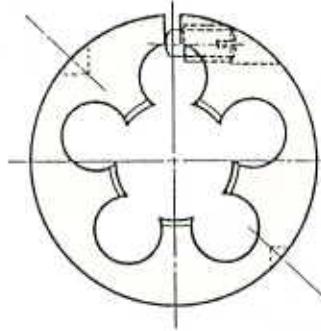
Size mm	Pitch mm	Outside Diameter inch		
16	1.5	1 1/8	2 1/4	
20	1.5	1 3/8	2 1/4	
25	1.5	1 3/8	2 1/4	
32	1.5		2 1/4	
40	1.5		2 1/4	3 3/16
50	1.5		2 1/4	3 3/16

# ROUND DIES

RUNDE SCHNEIDEISEN  
HILERAS DE ROSCAR REDONDAS  
FILIERES

ART NO.819

## Round Adjustable Dies Inch Sizes NC NF NS BSW BSF



**High Speed Steel  
Tungsten Steel  
ALLOY Steel**

Nominal Diameter inch	Thread per inch					Outside Diameter and Thickness									
						$\frac{13}{16}$ (20) × $\frac{1}{4}$	1"(25) × $\frac{1}{8}$	$1\frac{5}{16}$ (33) × $\frac{1}{16}$	$1\frac{1}{2}$ (38) × $\frac{1}{2}$	2"(50) × $\frac{3}{4}$	$2\frac{1}{4}$ (57) × $\frac{3}{4}$	$2\frac{1}{2}$ (63) × $\frac{3}{4}$	$2\frac{3}{4}$ (70) × 1	3"(75) × 1	4"(100) × $1\frac{3}{16}$
	(u)NC	(u)NF	(u)NS	BSW	BSF										
$\frac{1}{16}$	60	64	64.72	60		$\frac{13}{16}$	1								
$\frac{3}{32}$	48	56	56	48		$\frac{13}{16}$	1								
$\frac{1}{8}$	40	44	40.44	40	44	$\frac{13}{16}$	1	$1\frac{5}{16}$	$1\frac{1}{2}$						
$\frac{5}{32}$	32	36	32.36	32	36	$\frac{13}{16}$	1	$1\frac{5}{16}$	$1\frac{1}{2}$						
$\frac{3}{16}$	24	32	24.32	24	32	$\frac{13}{16}$	1	$1\frac{5}{16}$	$1\frac{1}{2}$						
$\frac{7}{32}$	24	32	24.32	24		$\frac{13}{16}$	1	$1\frac{5}{16}$	$1\frac{1}{2}$						
$\frac{1}{4}$	20	28	24.32	20	26	$\frac{13}{16}$	1	$1\frac{5}{16}$	$1\frac{1}{2}$	2	$2\frac{1}{4}$				
$\frac{9}{32}$	20		28.32	20			1	$1\frac{5}{16}$	$1\frac{1}{2}$	2	$2\frac{1}{4}$				
$\frac{5}{16}$	18	24	32	18	22		1	$1\frac{5}{16}$	$1\frac{1}{2}$	2	$2\frac{1}{4}$				
$\frac{3}{8}$	16	24	32	16	20		1	$1\frac{5}{16}$	$1\frac{1}{2}$	2	$2\frac{1}{4}$				
$\frac{7}{16}$	14	20	28	14	18		1	$1\frac{5}{16}$	$1\frac{1}{2}$	2	$2\frac{1}{4}$				
$\frac{1}{2}$	13	20	28.32	12	16		1	$1\frac{5}{16}$	$1\frac{1}{2}$	2	$2\frac{1}{4}$	$2\frac{1}{2}$			
$\frac{9}{16}$	12	18	27	12	16				$1\frac{1}{2}$	2	$2\frac{1}{4}$	$2\frac{1}{2}$			
$\frac{5}{8}$	11	18	32	11	14				$1\frac{1}{2}$	2	$2\frac{1}{4}$	$2\frac{1}{2}$			
$\frac{11}{16}$	11	16	11.16	11	14				$1\frac{1}{2}$	2	$2\frac{1}{4}$	$2\frac{1}{2}$			
$\frac{3}{4}$	10	16	32	10	12				$1\frac{1}{2}$	2	$2\frac{1}{4}$	$2\frac{1}{2}$	$2\frac{3}{4}$		
$\frac{7}{8}$	9	14	12.18	9	11					2	$2\frac{1}{4}$	$2\frac{1}{2}$	$2\frac{3}{4}$	3	
1	8	12	14.20	8	10					2	$2\frac{1}{4}$	$2\frac{1}{2}$	$2\frac{3}{4}$	3	4
$1\frac{1}{8}$	7	12	18	7	9						$2\frac{1}{4}$	$2\frac{1}{2}$	$2\frac{3}{4}$	3	4
$1\frac{1}{4}$	7	12	18	7	9						$2\frac{1}{4}$	$2\frac{1}{2}$	$2\frac{3}{4}$	3	4
$1\frac{3}{8}$	6	12	18	6	8							$2\frac{1}{2}$	$2\frac{3}{4}$	3	4
$1\frac{1}{2}$	6	12	18	6	8							$2\frac{1}{2}$	$2\frac{3}{4}$	3	4
$1\frac{5}{8}$	5			5	8								$2\frac{3}{4}$	3	4
$1\frac{3}{4}$	5			5	7									3	4
$1\frac{7}{8}$	$4\frac{1}{2}$			$4\frac{1}{2}$	7									3	4
2	$4\frac{1}{2}$			$4\frac{1}{2}$	7									3	4
$2\frac{1}{4}$	$4\frac{1}{2}$			4	6										4
$2\frac{1}{2}$	4			4	6										
$2\frac{3}{4}$	4			$3\frac{1}{2}$	6										
3	4			$3\frac{1}{2}$	5										
Angle of Thread	60°	60°	60°	55°	55°	12(g)	25(g)	80(g)	90(g)	180(g)	320(g)	330(g)	400(g)	600(g)	950(g)

# ROUND DIES

RUNDE SCHNEIDEISEN  
HILERAS DE ROSCAR REDONDAS  
FILIERES

ART NO.821

## Round Adjustable Dies

Outside Diameter

$\frac{13}{16}$  inch

Thickness

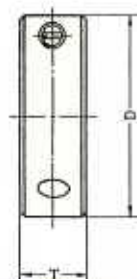
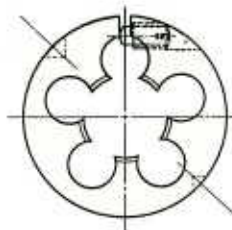
$\frac{1}{4}$  inch

Machine Screw sizes

Metric sizes

BA sizes

Sewing Machine sizes



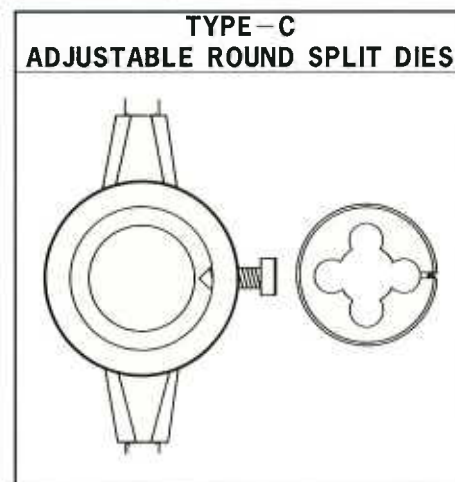
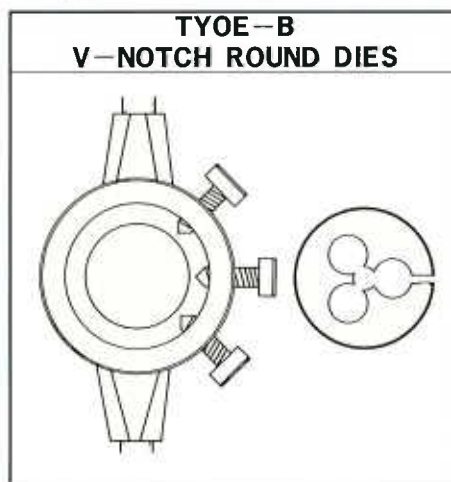
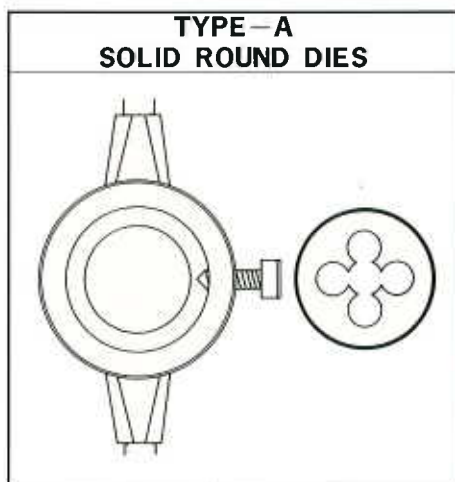
**High Speed Steel**  
**Tungsten Steel**  
**ALLOY Steel**

Size No.	Machine Screw Sizes		
	(u)NC	Thread per inch (u)NF	(u)NS
0		80	
1	64	72	56
2	56	64	
3	48	56	
4	40	48	32·36
5	40	44	
6	32	40	36
8	32	36	40
10	24	32	30
12	24	28	32
14	20	24	

Size	Metric sizes	
	pitch Coarse	Pitch Fine
1.0	0.25	0.2
1.1	0.25	0.2
1.2	0.25	0.2
1.4	0.3	0.2
1.6	0.35	0.2
1.7	0.35	0.2
1.8	0.35	0.2
2.0	0.4	0.25
2.2	0.4/0.45	0.25
2.3	0.4	0.25
2.5	0.45	0.25
2.6	0.45	0.25
3.0	0.5	0.35
3.5	0.6	0.35
4.0	0.7	0.50

BA Sizes
BA NO. 14
BA NO. 13
BA NO. 12
BA NO. 11
BA NO. 10
BA NO. 9
BA NO. 8
BA NO. 7
BA NO. 6
BA NO. 5
BA NO. 4
BA NO. 3
BA NO. 2
BA NO. 1
BA NO. 0

Sewing Machine Sizes	
Nominal Diameter inch	Thread per inch
SM $\frac{1}{16}$	80
SM $\frac{5}{64}$	64
SM $\frac{3}{32}$	100
SM $\frac{3}{32}$	56
SM $\frac{1}{8}$	48
SM $\frac{1}{8}$	44
SM $\frac{9}{64}$	40
SM $\frac{11}{64}$	40
SM $\frac{11}{64}$	40
SM $\frac{11}{64}$	32
SM $\frac{3}{16}$	40
SM $\frac{3}{16}$	32
SM $\frac{7}{16}$	28
SM $\frac{7}{16}$	24
SM $\frac{13}{64}$	32
SM $\frac{7}{32}$	32
SM $\frac{15}{64}$	28
SM $\frac{1}{4}$	40
SM $\frac{1}{4}$	28
SM $\frac{1}{4}$	24



## INGREDIENT SPECIFICATION

Type of Steel	Chemical Composition											
	C	Si	Mn	P	S	Cu	Ni	Cr	Mo	W	V	
Elements	%×100	%×100	%×100	%×1000	%×1000	%×100	%×100	%×100	%×100	%×100	%×100	
SKH2	70~85	MAX 40	MAX 40	MAX 30	MAX 30			380~450		1700~1900	80~120	
SKH9	80~90	MAX 40	MAX 40	MAX 30	MAX 30			380~450	450~550	550~670	160~220	
SKS11	120~130	MAX 35	MAX 50	MAX 30	MAX 30			20~50		300~400	10~30	
SKS2	100~110	MAX 35	MAX 80	MAX 30	MAX 30			50~100		100~150		
GSS2	97	MAX 18	MAX 97	MAX 24	MAX 17	9		48	21			
ALLOY	095~1.10	MAX 35	MAX 90	MAX 27	MAX 20			13~165				

JIS(Japanese Industrial Standard)	SKH2	SKH9	SKS11	SKS2	SK3
ASTM(American Society for Testing and Material)	T <sub>1</sub>	M <sub>2</sub>	F <sub>2</sub>		W1-10
AISI(American Iron and Steel Institute)					
BS(British Standard)	BT <sub>1</sub>	BM <sub>1</sub>			BW1B
DIN(Deutsche Industrie Normen)					
VDEh(Verein Deutscher Eisenhüttenleute)		S6-5-2		105WCr6	C105W1

# DIES SPECIAL THREAD

High Speed Steel

ALLOY STEEL

ART NO. 840



## Fractional Sizes Round Dies

Machine Screw Size	Threads per inch	Outside Diameter	Size	Threads per inch	Outside Diameter	Size	Threads per inch	Outside Diameter	Size	Threads per inch	Outside Diameter	Size	Threads per inch	Outside Diameter	Size						
0	96	13/16	1/16	64	13/16	1	3/8	36	1	1 1/2	2	11/16	18	2	2 1/2	1	36	2	2 1/2	3	
1	56	13/16	3/22	48	13/16	1	3/8	40	1	1 1/2	2	11/16	20	2	2 1/2	1	40	2	2 1/2	3	
1	80	13/16	1/8	40	13/16	1	3/8	48	1	1 1/2	2	11/16	24	2	2 1/2	1	48	2	2 1/2	3	
2	72	13/16	1/8	48	13/16	1	3/8	56	1	1 1/2	2	11/16	27	2	2 1/2	1	56	2	2 1/2	3	
2	80	13/16	9/64	40	13/16	1	3/8	64	1	1 1/2	2	11/16	28	2	2 1/2	1 1/16	10		2 1/2	3	4
3	64	13/16	5/32	32	13/16	1	3/8	72	1	1 1/2	2	11/16	32	2	2 1/2	1 1/16	12		2 1/2	3	4
3	72	13/16	5/32	36	13/16	1	3/8	80	1	1 1/2	2	11/16	36	2	2 1/2	1 1/16	14		2 1/2	3	4
3	80	13/16	5/32	40	13/16	1	13/32	32		1 1/2	2	11/16	40	2	2 1/2	1 1/16	16		2 1/2	3	4
4	32	13/16	3/16	24	13/16	1	7/16	16		1 1/2	2	3/4	14	2	2 1/2	1 1/16	18		2 1/2	3	4
4	56	13/16	3/16	32	13/16	1	7/16	18		1 1/2	2	3/4	18	2	2 1/2	1 1/16	20		2 1/2	3	4
4	64	13/16	3/16	40	13/16	1	7/16	24		1 1/2	2	3/4	20	2	2 1/2	1 1/16	24		2 1/2	3	4
4	72	13/16	3/16	48	13/16	1	7/16	27		1 1/2	2	3/4	20	2	2 1/2	1 1/16	27		2 1/2	3	4
4	80	13/16	7/32	24	13/16	1	7/16	28		1 1/2	2	3/4	24	2	2 1/2	1 1/16	32		2 1/2	3	4
5	32	13/16	7/32	28	13/16	1	7/16	30		1 1/2	2	3/4	27	2	2 1/2	1 1/8	8		2 1/2	3	4
5	36	13/16	7/32	32	13/16	1	7/16	32		1 1/2	2	3/4	27	2	2 1/2	1 1/8	10		2 1/2	3	4
5	48	13/16	7/32	36	13/16	1	7/16	36		1 1/2	2	3/4	28	2	2 1/2	1 1/8	14		2 1/2	3	4
5	56	13/16	7/32	40	13/16	1	7/16	40		1 1/2	2	3/4	30	2	2 1/2	1 1/8	16		2 1/2	3	4
5	60	13/16	1/4	16		1	1 1/2	48		1 1/2	2	3/4	32	2	2 1/2	1 1/8	18		2 1/2	3	4
5	64	13/16	1/4	18		1	1 1/2	56		1 1/2	2	3/4	32	2	2 1/2	1 1/8	20		2 1/2	3	4
5	72	13/16	1/4	24		1	1 1/2	64		1 1/2	2	3/4	40	2	2 1/2	1 1/8	24		2 1/2	3	4
5	80	13/16	1/4	24		1	1 1/2	48		1 1/2	2	3/4	48	2	2 1/2	1 1/8	27		2 1/2	3	4
6	30	13/16	1	24		1	1 1/2	32		1 1/2	2	3/4	56	2	2 1/2	1 1/8	32		2 1/2	3	4
6	36	13/16	1	27		1	1 1/2	40		1 1/2	2	3/4	64	2	2 1/2	1 3/16	12		2 1/2	3	4
6	48	13/16	1	30		1	1 1/2	12		1 1/2	2	13/16	10	2	2 1/2	1 3/16	16		2 1/2	3	4
6	56	13/16	1	32		1	1 1/2	14		1 1/2	2	13/16	12	2	2 1/2	1 3/16	18		2 1/2	3	4
6	60	13/16	1	32		1	1 1/2	16		1 1/2	2	13/16	14	2	2 1/2	1 3/16	20		2 1/2	3	4
6	64	13/16	1	32		1	1 1/2	18		1 1/2	2	13/16	16	2	2 1/2	1 3/16	24		2 1/2	3	4
6	72	13/16	1	36		1	1 1/2	24		1 1/2	2	13/16	18	2	2 1/2	1 3/16	32		2 1/2	3	4
6	80	13/16	1	40		1	1 1/2	26		1 1/2	2	13/16	20	2	2 1/2	1 1/4	8		2 1/2	3	4
7	32	13/16	1	48		1	1 1/2	27		1 1/2	2	13/16	24	2	2 1/2	1 1/4	10		2 1/2	3	4
7	36	13/16	1	56		1	1 1/2	28		1 1/2	2	13/16	27	2	2 1/2	1 1/4	14		2 1/2	3	4
7	40	13/16	1	60		1	1 1/2	30		1 1/2	2	13/16	28	2	2 1/2	1 1/4	16		2 1/2	3	4
7	48	13/16	1	64		1	1 1/2	32		1 1/2	2	13/16	32	2	2 1/2	1 1/4	18		2 1/2	3	4
7	64	13/16	1	72		1	1 1/2	36		1 1/2	2	7/8	10	2	2 1/2	1 1/4	20		2 1/2	3	4
8	24	13/16	1	80		1	1 1/2	40		1 1/2	2	7/8	12	2	2 1/2	1 1/4	24		2 1/2	3	4
8	30	13/16	1	24		1	1 1/2	48		1 1/2	2	7/8	16	2	2 1/2	1 1/4	27		2 1/2	3	4
8	40	13/16	1	32		1	1 1/2	56		1 1/2	2	7/8	16	2	2 1/2	1 1/4	32		2 1/2	3	4
8	48	13/16	1	40		1	1 1/2	64		1 1/2	2	7/8	18	2	2 1/2	1 5/16	8		2 1/2	3	4
8	56	13/16	1	16		1	1 1/2	72		1 1/2	2	7/8	18	2	2 1/2	1 5/16	10		2 1/2	3	4
8	60	13/16	1	20		1	1 1/2	80		1 1/2	2	7/8	20	2	2 1/2	1 5/16	12		2 1/2	3	4
8	64	13/16	1	27		1	1 1/2	16		1 1/2	2	7/8	24	2	2 1/2	1 5/16	14		2 1/2	3	4
8	72	13/16	1	28		1	1 1/2	20		1 1/2	2	7/8	27	2	2 1/2	1 5/16	16		2 1/2	3	4
8	80	13/16	1	32		1	1 1/2	24		1 1/2	2	7/8	28	2	2 1/2	1 5/16	18		2 1/2	3	4
9	32	13/16	1	32		1	1 1/2	27		1 1/2	2	7/8	32	2	2 1/2	1 5/16	20		2 1/2	3	4
9	36	13/16	1	36		1	1 1/2	28		1 1/2	2	7/8	36	2	2 1/2	1 5/16	24		2 1/2	3	4
9	40	13/16	1	40		1	1 1/2	32		1 1/2	2	7/8	40	2	2 1/2	1 5/16	32		2 1/2	3	4
10	28	13/16	1	48		1	1 1/2	36		1 1/2	2	7/8	48	2	2 1/2	1 3/8	8		2 1/2	3	4
10	30	13/16	1	56		1	1 1/2	40		1 1/2	2	15/16	9	2	2 1/2	1 3/8	10		2 1/2	3	4
10	36	13/16	1	64		1	1 1/2	48		1 1/2	2	15/16	10	2	2 1/2	1 3/8	14		2 1/2	3	4
10	40	13/16	1	72		1	1 1/2	10		1 1/2	2	15/16	12	2	2 1/2	1 3/8	16		2 1/2	3	4
10	48	13/16	1	80		1	1 1/2	12		1 1/2	2	15/16	16	2	2 1/2	1 3/8	18		2 1/2	3	4
10	56	13/16	1	24		1	1 1/2	14		1 1/2	2	15/16	18	2	2 1/2	1 3/8	20		2 1/2	3	4
10	60	13/16	1	27		1	1 1/2	16		1 1/2	2	15/16	20	2	2 1/2	1 3/8	24		2 1/2	3	4
10	64	13/16	1	28		1	1 1/2	20		1 1/2	2	15/16	24	2	2 1/2	1 3/8	32		2 1/2	3	4
10	80	13/16	1	32		1	1 1/2	24		1 1/2	2	15/16	27	2	2 1/2	1 7/16	12		2 1/2	3	4
12	30	13/16	1	40		1	1 1/2	27		1 1/2	2	15/16	32	2	2 1/2	1 7/16	14		2 1/2	3	4
12	32	13/16	1	48		1	1 1/2	28		1 1/2	2	1	10	2	2 1/2	1 7/16	16		2 1/2	3	4
12	36	13/16	1	18		1	1 1/2	32		1 1/2	2	1	16	2	2 1/2	1 7/16	18		2 1/2	3	4
12	40	13/16	1	20		1	1 1/2	36		1 1/2	2	1	18	2	2 1/2	1 7/16	20		2 1/2	3	4
12	48	13/16	1	27		1	1 1/2	40		1 1/2	2	1	20	2	2 1/2	1 7/16	24		2 1/2	3	4
12	56	13/16	1	28		1	1 1/2	48		1 1/2	2	1	24	2	2 1/2	1 7/16	32		2 1/2	3	4
12	64	13/16	1	30		1	1 1/2	56		1 1/2	2	1	27	2	2 1/2	1 1/2	8		2 1/2	3	4
			3/8	32		1	1 1/2	64		1 1/2	2	1	28	2	2 1/2	1 1/2	10		2 1/2	3	4
			3/8	32		1	1 1/2	12		1 1/2	2	1	32	2	2 1/2				2 1/2	3	4

# DIES SPECIAL THREAD

High Speed Steel

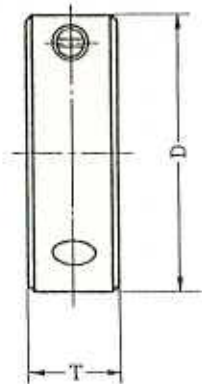
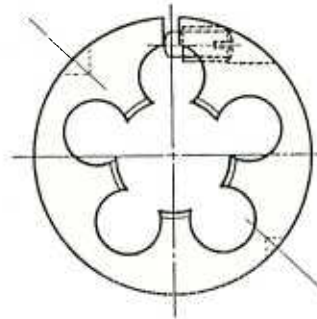
ALLOY STEEL

ART NO.840



## Fractional Sizes Round Dies

Size	Threads per inch	Outside Diameter		Size	Threads per inch	Outside Diameter	
1 1/2	14	3	4	2	24	3	4
1 1/2	16	3	4	2	32	3	4
1 1/2	18	3	4	2 1/16	12		4
1 1/2	20	3	4	2 1/16	14		4
1 1/2	24	3	4	2 1/8	8		4
1 1/2	27	3	4	2 1/8	10		4
1 1/2	32	3	4	2 1/8	12		4
1 9/16	12	3	4	2 1/8	14		4
1 9/16	18	3	4	2 1/8	16		4
1 9/16	20	3	4	2 1/8	18		4
1 9/16	24	3	4	2 3/16	12		4
1 5/8	8	3	4	2 3/16	14		4
1 5/8	10	3	4	2 1/4	4 1/2		5
1 5/8	12	3	4	2 1/4	8		5
1 5/8	14	3	4	2 1/4	10		5
1 5/8	16	3	4	2 1/4	12		5
1 5/8	18	3	4	2 1/4	16		5
1 5/8	20	3	4	2 1/4	18		5
1 5/8	24	3	4	2 5/16	14		5
1 11/16	6	3	4	2 5/16	16		5
1 11/16	12	3	4	2 3/8	8		5
1 11/16	14	3	4	2 3/8	10		5
1 11/16	16	3	4	2 3/8	12		5
1 11/16	18	3	4	2 3/8	14		5
1 3/4	5	3	4	2 3/8	16		5
1 3/4	8	3	4	2 3/8	18		5
1 3/4	10	3	4	2 1/2	4		5
1 3/4	12	3	4	2 1/2	8		5
1 3/4	14	3	4	2 1/2	10		5
1 3/4	16	3	4	2 1/2	12		5
1 3/4	18	3	4	2 1/2	14		5
1 3/4	20	3	4	2 1/2	16		5
1 3/4	24	3	4	2 1/2	20		5
1 3/4	32	3	4	2 5/8	8		5
1 13/16	12	3	4	2 5/8	10		5
1 13/16	16	3	4	2 3/4	8		5
1 13/16	20	3	4	2 3/4	10		5
1 7/8	8	3	4	2 3/4	14		5
1 7/8	10	3	4	2 7/8	8		5
1 7/8	12	3	4	2 7/8	10		5
1 7/8	14	3	4	2 7/8	12		5
1 7/8	16	3	4	2 7/8	14		5
1 7/8	18	3	4	2 7/8	16		5
1 7/8	20	3	4	3	4		5
1 7/8	24	3	4	3	8		5
1 15/16	18	3	4	3	12		5
2	4 1/2	3	4	3	16		5
2	8	3	4				
2	10	3	4				
2	12	3	4				
2	14	3	4				
2	16	3	4				
2	18	3	4				
2	20	3	4				



## Millimeter Sizes Round Dies

mm Size	mm Pitch	Outside Diameter		mm Size	mm Pitch	Outside Diameter	
1.0	.20	13/16		5.5	.90	1	
1.0	.25	13/16		6.0	.50	1	1 1/2
1.2	.20	13/16		6.0	.75	1	1 1/2
1.2	.25	13/16		6.0	1.00	1	1 1/2
1.4	.20	13/16		6.0	1.25	1	1 1/2
1.4	.30	13/16		7.0	.50	1	1 1/2
1.5	.30	13/16		7.0	.75	1	1 1/2
1.5	.35	13/16		7.0	1.00	1	1 1/2
1.6	.35	13/16		7.0	1.25	1	1 1/2
1.7	.20	13/16		8.0	.75	1	1 1/2
1.7	.35	13/16		8.0	1.00	1	1 1/2
1.8	.35	13/16		8.0	1.25	1	1 1/2
2.0	.25	13/16		9.0	.75	1	1 1/2
2.0	.40	13/16		9.0	1.00	1	1 1/2
2.0	.45	13/16		9.0	1.25	1	1 1/2
2.0	.50	13/16		10.0	.75	1	1 1/2
2.2	.45	13/16		10.0	1.00	1	1 1/2
2.3	.25	13/16		10.0	1.25	1	1 1/2
2.3	.40	13/16		10.0	1.50	1	1 1/2
2.5	.45	13/16		11.0	1.50		2
2.6	.35	13/16		12.0	1.00		2
2.6	.45	13/16		12.0	1.25		2
3.0	.35	13/16	1	12.0	1.50		2
3.0	.50	13/16	1	12.0	1.75		2
3.0	.60	13/16	1	13.0	1.50		2
3.0	.75	13/16	1	14.0	1.25		2
3.5	.35	13/16	1	14.0	1.50		2
3.5	.60	13/16	1	14.0	1.75		2
4.0	.50	13/16	1	14.0	2.00		2
4.0	.70	13/16	1	16.0	1.25		2
4.0	.75	13/16	1	16.0	1.50		2
4.5	.50	13/16	1	16.0	2.00		2
4.5	.75	13/16	1	18.0	1.50		2
5.0	.50		1	18.0	2.00		2
5.0	.75		1	18.0	2.50		2
5.0	.80		1	20.0	1.50		2
5.0	.90		1	20.0	2.50		2
5.0	1.00		1	24.0	2.00		2
5.5	.70		1				

# HEXAGON DIES

ACROSS FLATS 1" 1<sup>7</sup>/<sub>16</sub> & STANDARD

ART NO.839

## Most Economical Sizes

Metric Sizes		Inch Sizes		Metric Sizes		Inch Sizes		Metric Sizes		Inch Sizes	
3M0.6	4-36-NS	1/8-40-W	3M0.5	1/8-40W	4-36-NS	6M1.0	1/4-20-NC	1/4-20-W	6M1.0	1/4-20-NC	1/4-20-W
3M0.5	4-40-NC	1/8-44-NF	3M0.60	1/8-44NF	4-40-NC	6M0.75	1/4-28-NF	5/16-18-W	6M0.75	1/4-28-NF	5/16-18-W
4M0.75	5-40-NC	1/8-40-NC	4M0.70	1/8-40NC	4-48-NF	7M1.0	5/16-18-NC	3/8-16-W	7M1.0	5/16-18-NC	3/8-16-W
4M0.7	6-32-NC	5/32-32-W	4M0.75	5/32-32W	5-40-NC	7M0.75	5/16-24-NF	7/16-14-W	7M0.75	5/16-24-NF	7/16-14-W
5M0.9	8-32-NC	5/32-36-NF	5M0.80	5/32-36NF	5-44-NF	8M1.00	3/8-16-NC	1/2-12-W	8M1.00	3/8-16-NC	1/2-12-W
5M0.8	10-24-NC	5/32-32-NC	5M0.90	5/32-32NC	6-32-NC	8M1.25	3/8-24-NF	9/16-12-W	8M1.25	3/8-24-NF	9/16-12-W
6M0.75	10-32-NF	3/16-24-W	6M1.00	3/16-24W	6-36-NS	9M1.00	7/16-14-NC	5/8-11-W	9M1.00	7/16-14-NC	5/8-11-W
6M1.0	12-24-NC	3/16-32-NF	6M0.75	3/16-32NF	6-40-NS	9M1.25	7/16-20-NF	3/4-10-W	9M1.25	7/16-20-NF	3/4-10-W
	14-20-NS	3/16-24-NC	7M1.00	3/16-24NC	6-48-NS	10M1.00	1/2-13-NC	1/8-28-BSPT	10M1.00	1/2-13-NC	7/8-9-W
	3/16-24-NS	7/32-24-W	7M0.75	7/32-24W	8-32-NC	10M1.25	1/2-20-NF	1/4-19-BSPT	10M1.25	1/2-20-NF	1-8-W
	3/16-32-NS	7/32-32-NF	8M1.00	7/32-32NF	8-36-NF	10M1.50	1/2-24-NS	3/8-19-BSPT	10M1.50	1/2-24-NS	1/8-28-BSPT
	1/4-20-NC	7/32-24-NC	8M1.25	7/32-24NC	8-40-NS	11M1.50	9/16-12-NC	1/2-14-BSPT	11M1.50	9/16-12-NC	1/4-19-BSPT
	1/4-25-NF	1/4-20-W	9M0.75	1/4-20W	10-24-NC	12M1.25	3/16-18-NF		12M1.25	3/16-18-NF	3/8-19-BSPT
			9M1.00	5/16-18W	10-32-NF	12M1.50	5/8-11-NC		12M1.50	5/8-11-NC	1/2-14-BSPT
			9M1.25	3/8-16W	12-24-NC	12M1.75	5/8-18-NF		12M1.75	5/8-18-NF	3/4-14-BSPT
			10M1.00	7/16-14W	12-28-NF	14M1.25	11/16-11-NS		14M1.25	11/16-11-NS	
			10M1.25	1/2-12W	14-20-NS	14M1.50	11/16-16-NS		14M1.50	11/16-16-NS	
			10M1.50	1/8-28BSP	1/8-40-NS	14M2.00	3/4-10-NC		14M2.00	3/4-10-NC	
			11M1.50	1/8-28BSPT	3/16-24-NS	16M1.50	3/4-16-NF		16M1.50	3/4-16-NF	
			12M1.25	1/4-19BSP	3/16-32-NS	16M2.00	1/8-27-NPT		16M2.00	7/8-9-NC	
			12M1.50	1/4-19BSPT	1/4-20-NC	18M1.00	1/4-18-NPT		18M1.00	7/8-14-NF	
			12M1.75		1/4-24-NS	18M1.50	3/8-18-NPT		18M1.50	1-8-NC	
					1/4-28-NF	18M2.50	1/2-14-NPT		18M2.50	1-12-NF	
					1/4-32-NEF				20M2.50	1-14-NS	
					1/4-40-NS				22M1.50	1/8-27-NPT	
					5/16-18-NC				24M3.00	1/4-18-NPT	
					5/16-24-NF				24M1.50	3/8-18-NPT	
					5/16-32-NEF					1/2-14-NPT	
					3/8-16-NC					3/4-14-NPT	
					3/8-24-NF						
					7/16-14-NC						
					7/16-20-NF						
					1/2-13-NC						
					1/2-20-NF						
					1/2-24-NS						
					1/8-27-NPT						
					1/4-18-NPT						
10g			30g			80g			200g		

# HEXAGON RE-THREADING. DIES

ART NO.839

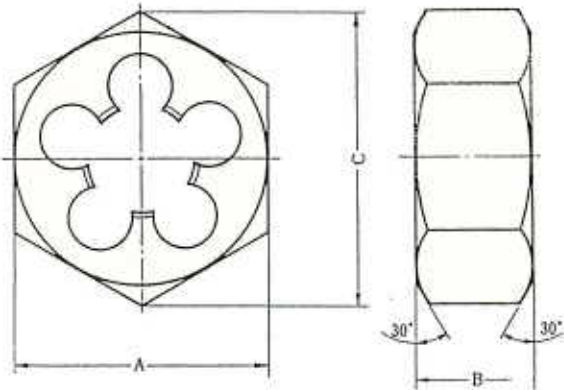
$\frac{19}{32}$ " THRU 7 ACROSS HEX FLATS

Sizes are available

INCH Sizes  $\frac{3}{16}$ "~5inch

METRIC Sizes 6~50mm

please state standard such as BSW.UNF.UNC.METRIC.GAS



Pipe HEXAGON DIES	Metric SIZES	INCH SIZES	Across Flats	Thickness B	WEIGHT
NPT NPS	6mm	$\frac{1}{4}$ -20NC $\frac{1}{4}$ -28NF	$\frac{19}{32}$ $\frac{19}{32}$	$\frac{1}{4}$ $\frac{1}{4}$	8 g
BSPT BSPS	7~ 8mm	$\frac{5}{16}$ -18NC $\frac{5}{16}$ -24NF	$\frac{11}{16}$ $\frac{11}{16}$	$\frac{5}{16}$ $\frac{5}{16}$	12
$\frac{1}{8}$	9~ 10mm	$\frac{3}{8}$ -16NC $\frac{3}{8}$ -24NF	$\frac{25}{32}$ $\frac{25}{32}$	$\frac{3}{8}$ $\frac{3}{8}$	16
	11mm	$\frac{7}{16}$ -14NC $\frac{7}{16}$ -20NF	$\frac{7}{8}$ $\frac{7}{8}$	$\frac{7}{16}$ $\frac{7}{16}$	25
$\frac{1}{4}$	12~ 13mm	$\frac{1}{2}$ -13NC $\frac{1}{2}$ -20NF	$1\frac{1}{16}$ $1\frac{1}{16}$	$\frac{1}{2}$ $\frac{1}{2}$	50
	14mm	$\frac{5}{16}$ -12NC $\frac{9}{16}$ -18NF	$1\frac{1}{16}$ $1\frac{1}{16}$	$\frac{1}{2}$ $\frac{1}{2}$	55
$\frac{3}{8}$	15~ 16mm	$\frac{5}{8}$ -11NC $\frac{5}{8}$ -18NF	$1\frac{1}{4}$ $1\frac{1}{4}$	$\frac{5}{8}$ $\frac{5}{8}$	75
		$\frac{11}{16}$ -11NS $\frac{11}{16}$ -16NS	$1\frac{7}{16}$ $1\frac{7}{16}$	$\frac{11}{16}$ $\frac{11}{16}$	100
$\frac{1}{2}$	17~ 20mm	$\frac{3}{4}$ -10NC $\frac{3}{4}$ -16NF	$1\frac{7}{16}$ $1\frac{7}{16}$	$\frac{3}{4}$ $\frac{3}{4}$	115
	21~ 23mm	$\frac{7}{8}$ - 9NC $\frac{7}{8}$ -14NF	$1\frac{5}{8}$ $1\frac{5}{8}$	$\frac{7}{8}$ $\frac{7}{8}$	125
$\frac{3}{4}$	24~ 26mm	1- 8NC 1-12NF 1-14NS	$1\frac{13}{16}$ $1\frac{13}{16}$ $1\frac{13}{16}$	1 1 1	200
	27~ 30mm	$1\frac{1}{8}$ - 7NC $1\frac{1}{8}$ -12NF	2 2	1 1	280
1"	31~ 33mm	$1\frac{1}{4}$ - 7NC $1\frac{1}{4}$ -12NF	$2\frac{3}{16}$ $2\frac{3}{16}$	1 1	320
	34~ 35mm	$1\frac{3}{8}$ - 6NC $1\frac{3}{8}$ -12NF	$2\frac{3}{8}$ $2\frac{3}{8}$	1 1	380
$1\frac{1}{4}$	36~ 40mm	$1\frac{1}{2}$ - 6NC $1\frac{1}{2}$ -12NF	$2\frac{9}{16}$ $2\frac{9}{16}$	1 1	420
	41~ 42mm	NC& NF $1\frac{5}{8}$	$3\frac{1}{8}$	1"	450
$1\frac{1}{2}$	43~ 45mm	$1\frac{3}{4}$	$3\frac{1}{8}$	1"	540
	46~ 48mm	$1\frac{7}{8}$	$3\frac{1}{8}$	$1\frac{1}{4}$	690
$1\frac{3}{4}$	50~ 52mm	2	$3\frac{1}{2}$	$1\frac{1}{4}$	740
	53~ 57mm	$2\frac{1}{4}$	$3\frac{1}{2}$	$1\frac{1}{4}$	1000
$2$ "	58~ 60mm	$2\frac{3}{8}$	$4\frac{1}{2}$	$1\frac{1}{2}$	1250
	63~ 65mm	$2\frac{1}{2}$	$4\frac{1}{2}$	$1\frac{1}{2}$	1500
	65~ 68mm	$2\frac{5}{8}$	$4\frac{1}{2}$	$1\frac{5}{8}$	2000
	69~ 70mm	$2\frac{3}{4}$	$4\frac{1}{2}$	$1\frac{5}{8}$	2000
	70~ 72mm	$2\frac{7}{8}$	5	$1\frac{3}{4}$	2500
$2\frac{1}{2}$ "	75~ 88mm	3 ~ $3\frac{1}{2}$	5	2	3000
3"	90~ 98mm	$3\frac{5}{8}$ ~ $3\frac{7}{8}$	6	$2\frac{1}{4}$ ~ $2\frac{3}{8}$	4000
	100~112mm	4 ~ $4\frac{1}{2}$	7	$2\frac{3}{8}$	5000
	115~127mm	$4\frac{5}{8}$ ~5	7	$2\frac{1}{2}$	8800