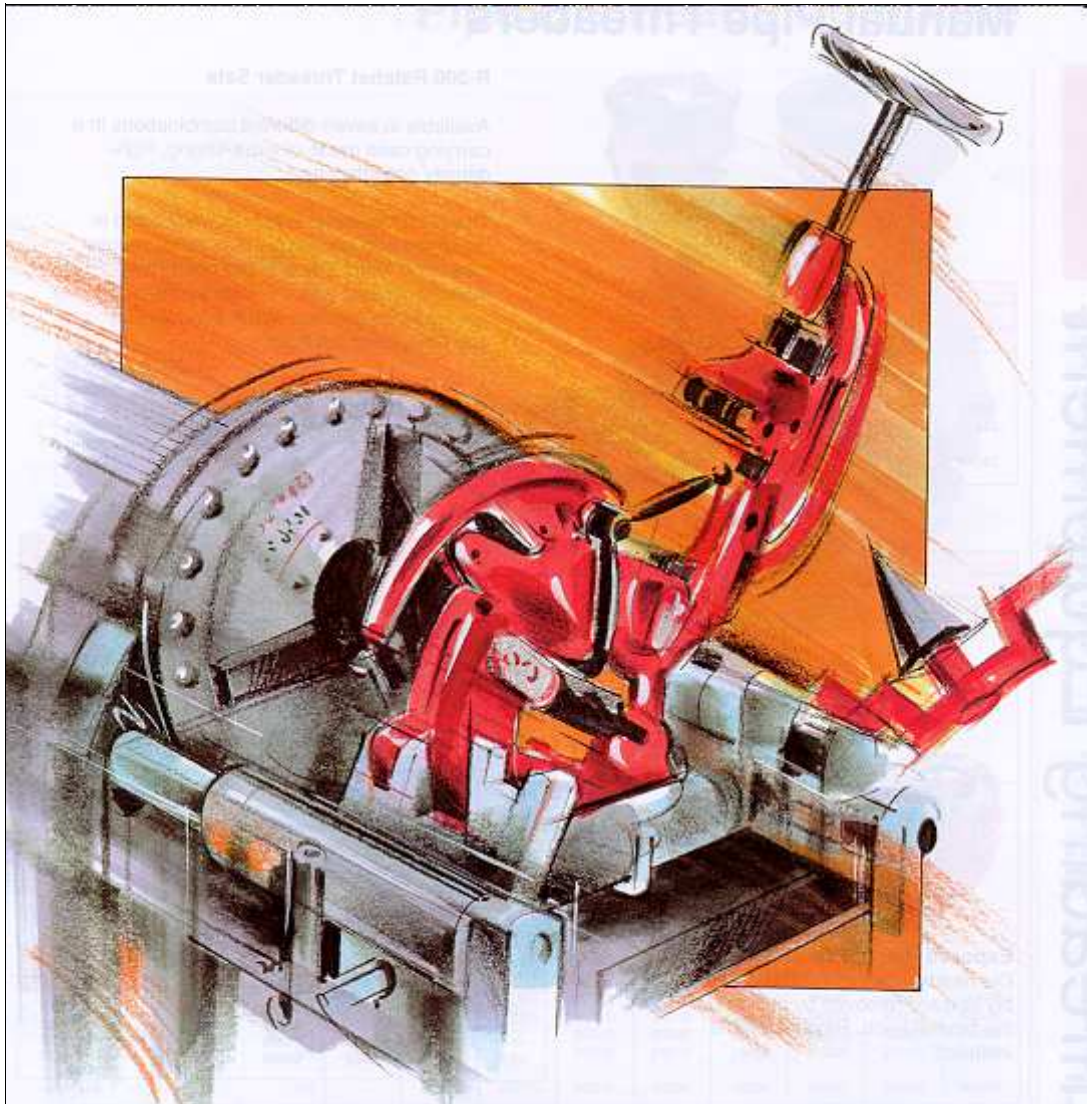


# THREADING EQUIPMENT



**SEDRA MARINE**

FRANCE

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# THREADING EQUIPMENT

## Manual pipe threaders



### R-200 Ratchet Threader Sets

Available in seven different combinations in a carrying case made of extra-strong, high density polyethylene.

The R-200 threader is light in weight and is equipped with low-torque dies which require less effort to cut threads. Die heads are interchangeable with 11-R series threaders and can also be used with the model 600 and 690 power threader.

Model No.	Capacity		Catalog No.		Weight kg
	in.	mm	RH BSPT	RH - LH BSPT Alloy	
R-200	3/8 - 1	10-25	37662	-	5,7
R-200	3/8 1 1/4	10-32	37667	37677*	6,4
R-200	3/8 - 2	10-50	37672	37682*	8,7
R-200	1/2 - 1	12-25	37642	-	5,3
R-200	1/2 - 1 1/4	12-32	37647	-	6,0
R-200	1/2 - 2	12-50	37652	-	8,3
R-200	1-2	25-50	37627	-	7,3
R-200	Carrying case		37782	-	1,4

\* Right and left hand die heads in metal carrying case

### Exposed Ratchet Threaders

Die heads lock into ratchet assembly and are removed by pulling out the ratchet knob. Ratchet handle included.



Model No.	Capacity		Catalog No.			Weight kg
	in.	mm	BSPT	NPT	NPSM	
12-R	1/2 - 1 1/4	12-32	65260	36480	-	10,8
12-R	3/4 - 2	20-50	65280	36500	-	14,0
12-R	1/2 - 2	12-50	65255	36475	36510	15,8
12-R	1/8 - 2	3-50	65285	36505	-	20,7

### 3-Way Pipe Threaders

Each model cuts three thread sizes. Die sets are locked in place.



Model No.	Capacity		RH	LH	RH	RH for high	Weight kg
	in.	mm	Alloy	Alloy	High Speed	speed for stainless steel	
30-A BSPT	3/8, 1/2, 3/4	10, 12, 20	65290	65295	65300	-	3,8
30-A NPT	3/8, 1/2, 3/4	10, 12, 20	36515	36520	36525	-	3,8
31-A BSPT	1/2, 3/4, 1	12, 20, 25	65320	65325	-	-	4,6
31-A NPT	1/2, 3/4, 1	12, 20, 25	36540	36545	36550	36555	4,6

# THREADING EQUIPMENT

Pipe heads complete



British and international standards

		Catalog Nos									
		Nominal Pipe Size									
		1/8"	1/4"	3/8"	1/2"	3/4"	1"	1 1/4"	1 1/2"	2"	
<b>Model No. R-200</b>											
<b>(BSPT)</b>											
Alloy	RH	37257	37262	37267	37272	37277	37282	37287	37292	37297	
Alloy	LH	37302	37307	37312	37317	37322	37327	37332	37337	37342	
<b>(NPT)</b>		See model 11-R, on the following page									
Alloy	RH								37037	37042	

R-200 Threaders take R-200 Dies only. Not 12-R Dies. Hex Keys : 1/8"-3/4" Cat. No 46000, 1"-2" Cat. No 46015

		Catalog Nos								
		Nominal Pipe Size								
		1/8"	1/4"	3/8"	1/2"	3/4"	1"	1 1/4"	1 1/2"	2"
<b>Model No. 00-R</b>										
<b>(BSPT)</b>										
Alloy	RH	65705	65710	65715	65720	65725	65730	-	-	-
Alloy	LH	65735	65740	65745	65750	65755	65760	-	-	-
High-Speed	RH	65765	65770	65775	65780	65785	65790	-	-	-
<b>(BSPP)</b>										
Alloy	RH	-	65795	65800	65805	65810	65815	-	-	-
<b>Model No. 11R</b>										
<b>(BSPT)</b>										
Alloy	RH	65550	65555	65560	65565	65570	65575	65580	-	-
Alloy	LH	65585	65590	65595	65600	65605	65610	65615	-	-
High-Speed	RH	-	-	65620*	65625*	65630*	65635*	65640*	-	-
<b>(BSPP)</b>										
Alloy	RH	-	-	65680*	65685*	65690*	65695*	65700*	-	-
<b>Model No. 12-R</b>										
<b>(BSPT)</b>										
Alloy	RH	65950	65955	65960	65965	65970	65975	65980	65985	65990
Alloy	LH	65995	66000	66005	66010	66015	66020	66025	66030	66035
High-Speed	RH	-	-	-	66040	66045	66050	66055	66060	66065
Plastic coated	RH	-	-	-	25026	24016	24026	24036	24046	24056
<b>(BSPP)</b>										
Alloy	RH	-	66070	66075	66080	66085	66090	66095	66100	66105



		Catalog Nos.				
		Nominal Size				
<b>Model No. 11R</b>		16 mm	20 mm	25 mm	32 mm	40 mm
<b>(ISO)</b>						
Alloy	RH	75000	75005	75010	75015	75020

		Model No.			
		R-200	00-R	11-R	12-R
<b>Ratchet and handle complete</b>					
<b>Catalog No.</b>		37777	38540	37777	38555

**SEDRA MARINE**

# THREADING EQUIPMENT

Pipe heads complete

## North American Standards

			Catalog Nos										
			Nominal Pipe Size										
			1/8"	1/4"	3/8"	1/2"	3/4"	1"	1 1/4"	1 1/2"	2"		
<b>Model No. 00-R</b>													
<b>(NPT)</b>													
Alloy	RH		36875	36880	36885	36890	36895	36900	-	-	-		
Alloy	LH		36905	36910	36915	36920	36925	36930	-	-	-		
High-Speed	RH		36935	36940	36945	36950	36955	36960	-	-	-		
High-Speed for stainless steel	RH		36965	36970	36975	36980	36985	36990	-	-	-		
<b>(NPSM)</b>													
Alloy	RH		36995	37000	37005	37010	37015	37020	-	-	-		
<b>Model No. 11R</b>													
<b>(NPT)</b>													
Alloy	RH		37025	37030	37035	37040	37045	37050	37055	-	-		
Alloy	LH		37060*	37065*	37070*	37075*	37080*	37085*	37090*	-	-		
High-Speed	RH		37095*	37100*	37105*	37110*	37115*	37120*	37125*	-	-		
High-Speed for stainless steel	RH		37130*	37135*	37140*	37145*	37150*	37155*	37160*	-	-		
<b>(NPSM)</b>													
Alloy	RH		37165*	37170*	37175*	37180*	37185*	37190*	37195*	-	-		
<b>Model No. 12-R</b>													
<b>(NPT)</b>													
Alloy	RH		37375	37380	37385	37390	37395	37400	37405	37410	37415		
Alloy	LH		37420	37425	37430	37435	37440	37445	37450	37455	37460		
High-Speed	RH		37465	37470	37475	37480	37485	37490	37495	37500	37505		
High-Speed for stainless steel	RH		37510	37515	37520	37525	37530	37535	37540	37545	37550		
High-Speed for PVC	RH		-	83450	83455	83460	83465	83470	83475	83480	83485		
Alloy for IMC	RH		-	-	-	92690	92695	92700	92705	92710	92715		
<b>(NPSM)</b>													
Alloy	RH		37555	37560	37565	37570	37575	37580	37585	37590	37595		
Alloy for plastic coated	RH		-	-	-	51857	51862	51867	51872	51877	51882		

\* Die Head furnished as Die Head Complete less Dies and appropriate Die Set (2 separate items)



### Receding threaders

#### No. 65R-TC

- Threads 1"-2" pipe
- True centering work-holder
- Jam-proof
- Right-hand only

Catalog No.	Model No.	Description	Capacity		Weight
			Nominal Pipe Size		
			in.	mm	kg
65345	65R-TC	BSPT with 1 Set High-Speed Dies	1-2	25-50	12,3
36570	65R-TC	NPT with 1 Set High-Speed Dies	1-2	25-50	12,3
36585	65R-TC	NPT with 1 Set High-Speed for stainless steel	1-2	25-50	12,3

### Receding Threader pipe dies for 65R-C & 65 R-TC ratchet threaders

Die material or type			Catalog numbers			
			(BSPT) British Std. Pipe Taper		(NPT) National Pipe Taper	
			1" Thru 2" - 11 TPI		1" Thru 2" - 11 1/2 TPI	
High-Speed	RH	66450		38100		
H.S. For Stainless Steel	RH	66455		38105		
H.S. For Cast Iron	RH	-		38110		
Carbide-Tip For Chemtite	RH	-		38115		

# THREADING EQUIPMENT

## Drop head threader dies



### Pipe Dies for R-200 Ratchet Threaders

		Catalog numbers									
Die material or type		Nominal Pipe Size-Threads Per Inch									
(BSPT) British Std. Pipe Taper		1/8"-28	1/4"-19	3/8"-19	1/2"-14	3/4"-14	1"-11	1 1/4"-11	1 1/2"-11	2"-11	
Alloy	RH	38677	38682	38687	38692	38697	38702	38707	38712	38717	
Alloy	LH	39577	38722	38727	38732	38737	38742	38747	38752	38757	
(NPT)		See 12-R Dies for Model 11-R									
Alloy	RH								38337	38342	

### Pipe Dies for 00-R, 111-R, 12-R, 0-R, 11-R Ratchet Threaders or 30A, 31A 3-Way Pipe Threaders

		Catalog numbers								
Die material or type		Nominal Pipe Size-Threads Per Inch								
(BSPT) British Std. Pipe Taper		1/8"-28	1/4"-19	3/8"-19	1/2"-14	3/4"-14	1"-11	1 1/4"-11	1 1/2"-11	2"-11
Alloy	RH	66110	66115	66120	66125	66130	66135	66140	66145	66150
Alloy	LH	66235	66240	66245	66250	66255	66260	66265	66270	66275
High Speed	RH	66310	66315	66320	66325	66330	66335	66340	66345	66350
High Speed	LH	66405	66410	66415	66420	66425	66430	66435	66440	66445
High Speed Reversible*	RH	-	-	56337	56342	56347	56352	56357	56362	56367
High Speed for Plastic Coated	RH	-	-	-	15261	15271	15281	15291	15301	15311
(BSPP) British Std. Pipe Parallel		1/8"-28	1/4"-19	3/8"-19	1/2"-14	3/4"-14	1"-11	1 1/4"-11	1 1/2"-11	2"-11
Alloy	RH	66190	66195	66200	66205	66210	66215	66220	66225	66230
Alloy	LH	-	66280	66285	66290	66295	66300	66305	-	-
H.S. for Stainless Steel	RH	-	-	-	66400	-	-	-	-	-

Nominal Conduit Size in mm - Thread Pitch in mm						
(ISO) International Standards organization	16-1.5	20-1.5	25-1.5	32-1.5	40-1.5	
Alloy	RH	76295	85830	76305	85835	76315

Die material or type		Nominal Pipe Size-Threads Per Inch								
(BSPT) British Std. Pipe Taper		1/8"-27	1/4"-18	3/8"-18	1/2"-14	3/4"-14	1"-11 1/2	1 1/4"-11 1/2	1 1/2"-11 1/2	2"-11 1/2
Alloy	RH	37810	37815	37820	37825	37830	37835	37840	37845	37850
Alloy	LH	38000	38005	38010	38015	38020	38025	38030	38035	38040
High Speed	RH	37855	37860	37865	37870	37875	37880	37885	37890	37895
High Speed	LH	38045	38050	38055	38060	38065	38070	38075	38080	38085
H.S. for Stainless Steel	RH	37900	37905	37910	37915	37920	37925	37930	37935	37940
H.S. for Cast Iron	RH	-	-	-	38090	38095	-	-	-	-
H.S. for PVC	RH	-	70680	70685	70690	70695	70700	70705	70710	70715
High Speed Reversible*	RH	-	-	-	49707	49712	49717	49722	49727	49732
(NPSM) National Pipe Straight Mechanical		1/8"-27	1/4"-18	3/8"-18	1/2"-14	3/4"-14	1"-11 1/2	1 1/4"-11 1/2	1 1/2"-11 1/2	2"-11 1/2
Alloy	RH	37945	37950	37955	37960	37965	37970	37975	37980	37985
Alloy	LH	-	-	-	-	-	37990	-	37995	-

\* Dies can be reversed in die head for threading or restoring damaged threads close to wall.



# THREADING EQUIPMENT

## Power threading / Model 1233



### Model 1233 Threading Machine

Pipe capacity : 1/8"-3"

Bolt capacity : 3/8"-2"

#### Standard Equipment :

*Die heads* : Model 815A 1/8"-2", BSPT self-opening  
Model 928 2 1/2"-3", BSPT self-opening receding

*Dies* : 1/2"-3/4" BSPT Euro  
1"-2" BSPT Euro  
2 1/2"-3" BSPT high speed

*Cutter* : Model 763, 1/4"-3", self-centering, with E-1032 cutter wheel

*Reamer* : Model 743, 1/4"-3", 5-fluted

*Oil* : 5 litres thread cutting fluid

The model 1233 1/8"-3" machine weights only 56 kilograms - the lightest and fastest 3" threading machine in the world. A newly designed receding die head features quick and simple adjustments for thread length and depth.

A powerful 1,7kW motor allows the 1233 to operate efficiently, even in low voltage environments.

#### Technical Specifications :

*Motor* : 1,7 kW Universal 50-60 Hz

*Motor control* : Reverse/Off/Forward, heavy duty, rotary-type plus integral footswitch

*Spindle speed* : 36 RPM

*Chuck* : Hammer-type with replaceable, rocker-action jaw inserts.

*Rear centering device* : Cam action

*Oiling system* : Adjustable flow ; through the head, with an integral oil reservoir. Self-priming, constant-flow, geroter pump.

Catalog No.	Model No.	Description	Weight kg
20215	1233	1/2"-3" BSPT, 230V, 50-60 Hz	56
20220	1233	1/2"-3" BSPT, 115V, 50-60 Hz	56
55212	1233	1/2"-2" BSPT, 230V, 50-60 Hz	54

#### Die heads

Catalog No.	Model No.	Description	Weight kg
97080	815A	1/8"-2" BSPT, Self-Opening, RH	5,9
97070	811A	1/8"-2" BSPT, Quick-Opening, RH	5,7
50327	928	2 1/2"-3" BSPT, Self-Opening	8,2
54437	728	2 1/2"-3" NPT, Self-Opening	8,2
97045	531	1/4"-1" Bolt, Quick-Opening, RH/LH	3,4
97050	532	1 1/4"-2" Bolt, Quick-Opening, RH/LH	4,1

#### Dies

Catalog No.	Description	Weight kg
47227	1/2"-3/4" BSPT EURO RH	0,6
47232	1"-2" BSPT EURO RH	0,6
51377	2 1/2"-3" BSPT High Speed RH	0,6
54452	2 1/2"-3" NPT High-Speed RH	0,6

#### Accessories

Catalog No.	Model No.	Description	Weight kg
68160	819	Nipple Chuck, 1/2"-2" BSPT	4,5
34172	419	Nipple Chuck, 2 1/2" BSPT	2,5
34177	419	Nipple Chuck, 3" BSPT	2,5
54587	343	Mounting Kit for 141	5,0

# THREADING EQUIPMENT

## Power threading / Model 1224



### Model 1224 Threading Machine

Pipe capacity : 1/4"-4"  
 4"-6" with 161 geared threader  
 Bolt capacity : 1/4"-2" (6mm-50mm)  
 up to 30 Rockwell C

#### Standard Equipment :

*Tools and Equipment* : 4 Hex keys, heavy-duty F-229 cutter wheel, 3/4" combination wrench, tool box

*Die heads* : 1 Model 911 (711) 1/4"-2"  
 1 Model 914 (714) 2 1/2"-4"

*Dies* : 1 set each 1/2"-3/4", 1"-2" Euro dies  
 and 2 1/2"-4" HS dies

*Oil* : 5 litres thread cutting fluid

The ultimate in 4" threading technology. Powered by a quiet , 2-speed induction motor. A special capacitor-start/capacitor-run motor allows the 1224 to thread a full range of material where voltage drop is experienced. Supplied with a 2 1/2"-4" receding die head allowing cutting of tapered or straight BSPT/BSPP (or NPT/NPSM) threads with no change of die head.

#### Technical specifications :

*Motor* : 1,1 kW, single-phase, 50 Hz induction type

*Motor control* : 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 1/4"-4" with F-229 cutter wheel

*Reamer* : Model 744, 1/4"-4" blade type

*Oiling* : Through-die head

*Pump* : Self-priming , geroter-type, automatic-reversing, constant-flow

Catalog No.	Model No.	Description	Weight kg
26112	1224	1/2"-4" BSPT, 115V, 50 Hz	220
26107	1224	1/2"-4" BSPT, 230V, 50 Hz	220

#### Die Heads

Catalog No.	Model No.	Description	Weight kg
26137	911	1/4"-2" Universal Self-Opening, RH, BSPT	5,6
26147	913	1/4"-2" Universal Quick-Opening, LH, BSPT	5,6
26157	914	2 1/2"-4" Receding Self-Opening, RH, BSPT	13,6
26132	711	1/4"-2" Universal Self-Opening, RH, NPT	5,6
26142	713	1/4"-2" Universal Quick-Opening, LH, NPT	5,6
26152	714	2 1/2"-4" Receding Self-Opening, RH, NPT	13,6
26162	541	1/4"-1" Quick-Opening Bolt, LH/RH	3,4
26167	542	1 1/8"-2" Quick-Opening bolt, LH/RH	4,2

#### Die 2 1/2"-4"

Catalog No.	Description	Weight kg
33642	1224 HS Dies BSPT	1,0
26192	1224 HS Dies NPT	1,0
31832	1224 HS BSPT Dies for Plastic-Coated Pipe	1,0
31827	1224 HS NPT Dies for Plastic-Coated Pipe	1,0
32242	1224 HS Dies BSPT for PVC	1,0
32237	1224 HS Dies NPT for PVC	1,0
33057	1224 HS Dies NPT for Stainless Steel	1,0
33072	1224 45° Beveling Dies	1,0
33077	1224 37 1/2° Beveling Dies	1,0
44992	1224 Bevel Guide Set	1,0
44997	1224 37 1/2° Bevel Bit Only	1,0
45002	1224 45° Bevel Bit Only	1,0