

# PIPE & BOLT THREADING MACHINES (Product & Services Guide)

THE OSTER MANUFACTURING COMPANY, OWOSSO, MICHIGAN, USA

[WWW.OSTERMFG.COM](http://WWW.OSTERMFG.COM)



The Oster Manufacturing company was born out of a one room work shop in 1893. Founded in a period of economic depression by Herman W. Oster and a small group of friends the company got off to a slow start. Over the next few decades through the hard work of Herman W. Oster and company president Russel B. Tewksbury the company expanded to a level of world wide recognition.

Together the two men established a firm policy of high quality manufacturing based on pride in good work. Throughout their long association together this was the motivating spirit of The Oster Manufacturing Co. The company grew and prospered under the leadership provided by these two men who combined engineering, financial and administrative talents.

Oster's healthy growth and prosperity continued under the leadership of Russel Tewksbury's son, Roger, throughout the war effort and into the economic boom of 50's and 60's. In 1968 the company was acquired by Teledyne Incorporated and became Teledyne Oster. Through the Seventies and Eighties Oster had reached the height of its growth and fell upon hard times as part of a corporate entity. In 1988 the Oster facilities were closed and all sales & manufacturing was moved to Landis Threading Systems in Waynesboro, PA.

In 1997 Superior Threading Inc. purchased the Machine and Die Head divisions of The Oster Manufacturing Company from Landis Threading Systems. All fixtures, Blueprints and Patterns were moved to Owosso, Michigan. The current owner is a former Oster employee and has been affiliated with the Oster company since 1983. Oster parts and products are the only items we manufacture. Our mission is to restore the focus and spirit of high quality manufacturing based upon pride in good work and to carry on the tradition that was created by Herman W. Oster himself.

Oster machines truly last for generations! No matter how old your Oster is, chances are we can help you keep it threading. The new plastic machines of today are no match for the rugged Oster models that are still available!

# THE OSTER MANUFACTURING COMPANY

## Owosso, Michigan USA

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### Glossary of Terms Found Within

ACME	Acme	MA - SI	Metric - Standard International, Series A (Coarse)
API	American Petroleum Institute	MB - Fine	Metric - Standard International, Series B (Fine)
BEC	British Electric Conduit	MET. CON.	Metric Conduit
BEV	Beveling	NPSM	National Pipe Straight Mechanical (Conduit)
BSF	British Standard Fine	NPT	National Pipe Taper (American)
BSPP	British Standard Pipe Parallell (Straight)	NPTF	National Pipe Taper Fluid (Dryseal)
BSPT	British Standard Pipe Taper	NS	Non-Standard - National Special
BSW	British Standard Whitworth	PVC	Ground for Plastic
BUTT	Buttress	R. BRAS.	Ground for Red Brass (or Copper)
CI	Ground for Cast Iron	SS	Ground for Stainless Steel (also Inconel)
COND	Conduit	TUBE	Tubing
CONT	Contour Tylag	UNC	Unified National Coarse (American)
DB. THR.	Double Throat (Rhebar)	UNF	Unified National Fine (American)
GROV	Grooving	UPS	Upset
ISO	International Standards Organization	Y. BRAS	Ground for Yellow Brass
LH	Left Hand		







# **“RAPIDUCTION”**

## **NEW 700LX - SERIES**

### **PRODUCTION CALIBER**

### **PIPE & BOLT THREADING MACHINES**

The Oster 700LX series is the latest improvement in our on going quest to provide the highest quality in production threading machines. The Oster 700LX line of threaders has been completely overhauled to be more energy efficient, easier to use and most importantly produce high quality threads to the specifications you demand. The new LX model threader features:

- Improved Coolant Pump to ensure maximum oil flow to die head
- Improved Rotating Die-Head to last even longer
- Improved Quad II Die-Head
- New Energy Efficient code compliant motors that run cooler and quieter
- Improved Bed Design
- Updated, more advanced, Infinitely Variable Frequency Drive

No matter what your application there is a 700LX series threader for you. Whether it is the Oster 792ALX with the X-1 Rotating Die-Head, the Oster 792LX with slide-in tools and optional blade-type cut off or the Oster 794LX equipped with Swing-Over tools and carriage for easy pipe threading, reaming and cut-off. There is an LX series threader that belongs on your shop floor.

Each LX series threader is a heavy-duty production caliber machine. The LX series is capable of producing class 2A threads from 1/4" Bolt thread up to 2" NC Bolt and 2" NPT Pipe in a single pass. Production speed bolt threading and threading bent material is no problem for the 792ALX because the material stays stationary and the 792ALX features Standard, Long and Extra Long Bed models for additional length.

With the 794LX pipe threading is quick, easy, and efficient due to the Swing-Over tool setup featuring an automatically opening die head. The 792LX with slide in tools is a versatile one stop threading & maintenance department. Each model has an infinitely variable frequency drive capable of RPM between 0-200.

Oster Dies are available in a Wide range of thread forms, many of which are not available from our competitors. Oster supports a full range of NC, NF, NS, NPT, NPTF(Dryseal), NPSM, ACME, BSPT, BSPP, as well as a full line of Metric dies. All of these are available for left hand thread as well.

Best of all the Oster 700LX series is easy to use. Anyone in your shop can run an Oster machine without any formal training. With no complicated CNC controls and suggested threading speeds provided for each size you won't need a CNC operator or an expert machinist to produce high quality threads fast.

**THE OSTER MANUFACTURING COMPANY**  
**OWOSSO, MICHIGAN**

# "RAPIDUCTION"

## 792LX All Purpose & 794LX Pipe Master

### Oster Quad II Die-Head

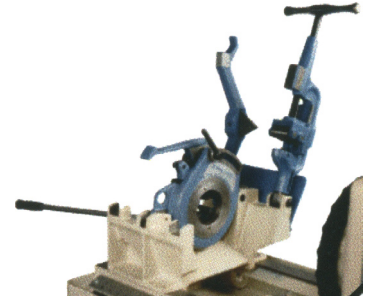
The Oster 792 and 794 come furnished with the Oster Quad II style Die-head.

Also available is the Oster 300 style die-head which allows for left handed threads. (300 style for 792 Only)

### 794LX Auto-Open Die-Head

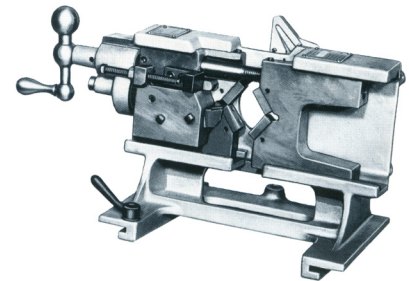
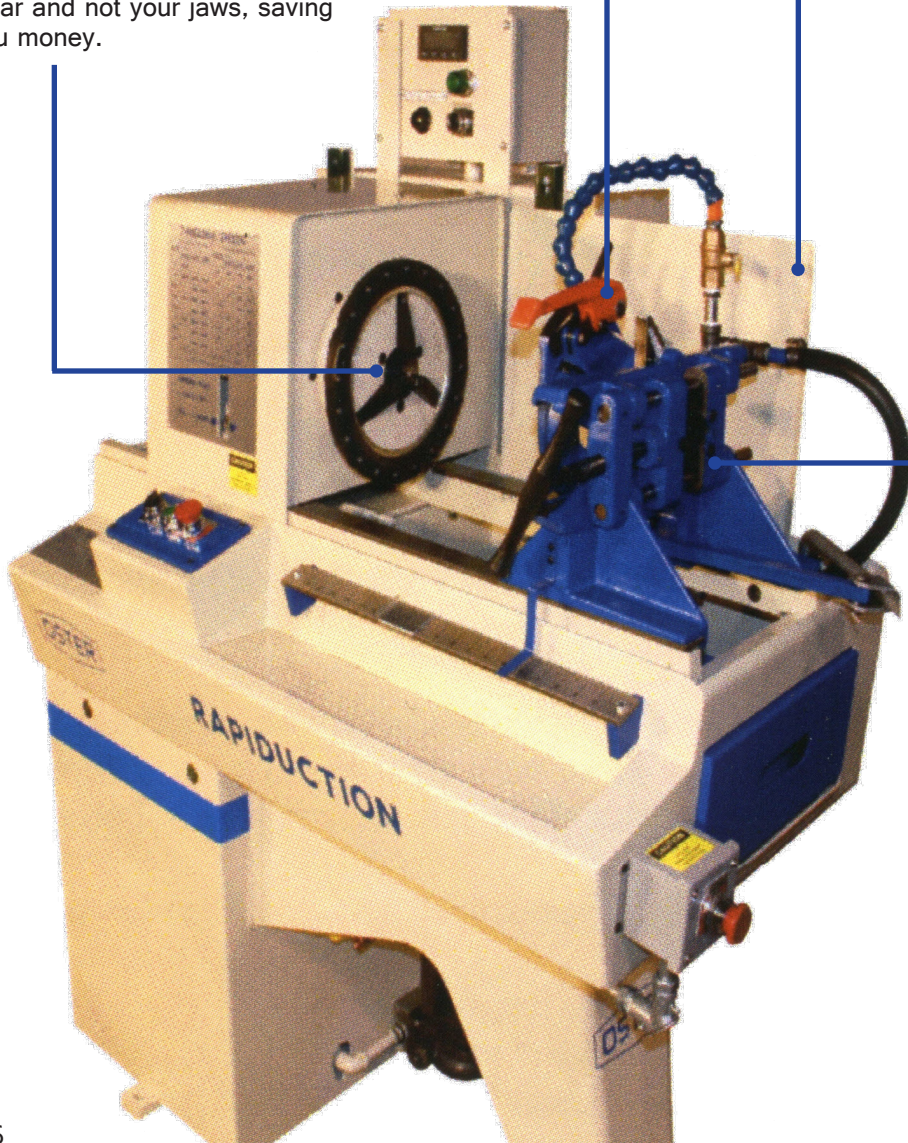
The Oster 794LX is equipped with special Swing-Over tools for convenient Pipe Threading Operations.

The Oster Quad II Swing-Over features an automatic opening system which guarantees the proper length for NPT threads. Also features through die-head oiling.



### Inserted Chuck Jaws

Oster Chuck jaws use patented insert technology so the inserts wear and not your jaws, saving you money.



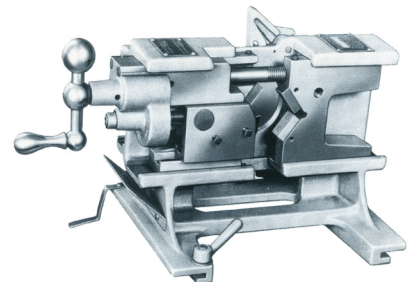
### Cut-Off Unit

Left: Standard roller type cut off furnished with machine

Top: Optional Blade-Type cut-off unit No. 02394

Bottom: Optional Blade-Type cut-off for Victaulic type Grooving No. 02539.

(792 Only)





# "RAPIDUCTION" 792ALX - Bolt Master

## Stock Stop

Automatic Stock-Stop guarantees repeatable thread lengths and automatically moves out of the way to begin threading.

## Rotating X-1 Die-Head

Rotating style Die-head keeps material still and handlers safe. Stationary material also allows for threading of bent pipe, rod and conduit.

## Readout & Controls

Readout displays current RPM of machine. Features an independent coolant on/off with indicator light. Potentiometer switch for easy adjustment of RPM.

## Vise Carriage

Quick-acting, open type vise with hardened steel insert gripping jaws and auxiliary jaws for diameters under  $\frac{1}{2}$ " (cut-off not available).

## Two Emergency Stops

Second Emergency Stop located at operator station to prevent reaching over machine and provide extra Safe conditions.

## Removable Chip Tray

Allows for the collection of chips to keep the sump clean and pump in order. Easily removed for convenient chip disposal.

## Coolant Pump

Electrically driven pump, independent from motor. Pumps regardless of spindle direction.

## Adjustable Die-Head Stop

Easy to change adjustable stop automatically opens the die-head at the desired thread length for Pipe & Bolt.



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# “RAPIDUCTION”

## Production Estimates for 700LX Series

### Pipe Threading

	Pipe Size	½" x 6" lg.	½" x 2' lg.	½" x 10' lg.
Production in Pieces per Hour	792LX	122	98	76
	792ALX	211	211	163

	Pipe Size	1" x 6" lg.	1" x 2' lg.	1" x 10' lg.
Production in Pieces per Hour	792LX	110	88	67
	792ALX	175	180	124

	Pipe Size	2" x 6" lg.	2" x 2' lg.	2" x 10' lg.
Production in Pieces per Hour	792LX	80	74	58
	792ALX	138	138	91

### Bolt Threading

Bolts or Studs of screw stock with one inch of National Coarse thread cut on one end. Head turning at recommended speed

Bolt Dia.	¼"	⅜"	½"	⅝"	¾"	⅞"	1"	1⅝"	1¼"	1⅜"	1½"
792ALX	220	250	215	180	187	150	157	150	150	145	130

### Various Lengths

Bolt Dia./Length	½" x 1¾" lg.	⅝" x 1¾" lg.	¾" x 2" lg.
792ALX	175	180	124



# “RAPIDUCTION”

## Specifications for 700LX Series

### Standard Equipment 792/794

**Motor** - 5 H.P., 3 phase, 240, 480 or 575 Volt.

**Motor Control** - Variable frequency type with forward and reverse and potentiometer for speed control.

**Carriage** - Slide type with Feed Lever.

**Die Head** - ONE, QUADVERSAL Die-Head - capacity  $\frac{1}{8}$ " thru 2" pipe,  $\frac{1}{4}$ " - 2" bolt - 792LX QUICK-OPEN, Slide-In type, 794LX AUTOMATIC-OPEN Swing-Over type.

**Dies** - TWO sets High Speed Steel Pipe Dies(Symbol Quad) Right-Hand, 1 set ( $\frac{1}{2}$ " and  $\frac{3}{4}$ "), 1 set (1" thru 2").

**Reamer** - 792LX - Detachable Blade Type; 794LX - Swing Over Detachable Blade.

**Cutter** - 792LX - Roller type, self-centering. (Blade type available at extra cost.) 794LX - Swing over roller type.

**Front Chuck** - Fast, Positive! Grips in both right and left hand direction. Equipped with patented self actuated replaceable jaw inserts.

**Rear Centering Chuck** - Rotating Type - scroll actuates 3 guides simultaneously

**Gage** - Graduated scale bar and thread length gage.

**Oil Pump** - 115 Volt Gusher Pump internally relieved, with status light

**Oil** - Thread cutting, FIVE gallons - Oster "BESTOIL".

### Standard Equipment 792A

**Motor** - 5 H.P., 3 phase, 240, 480 or 575 Volt.

**Motor Control** - Variable frequency type with forward and reverse and potentiometer for speed control.

**Die Head** - One, REVOLVING, semi-automatic, LESS ALL DIES. (Order only Symbol X1 Dies, 1 set per size required.) RIGHT- or LEFT-HAND available.

**Die-Head Control** - Semi-automatic tripping and resetting device with emergency hand trip.

**Vise** - Quick-acting, open type, with hardened steel insert gripping jaws and auxiliary jaws for diameters under  $\frac{1}{2}$ ". (Cut-off cannot be furnished.)

**Stock-Stop** - Automatic, adjustable.

**Gage** - Drum type, mounted on carriage handwheel

**Oil Pump** - 115 Volt Gusher Pump internally relieved, with status light

**Oil** - Thread cutting, FIVE gallons - Oster "BESTOIL".



	Pipe Capacity	Bolt Capacity	Spindle Speed	Max Thd Length*	Net Weight	Ship Weight
792LX	$\frac{1}{8}$ " to 2"	$\frac{1}{4}$ " to 2"	0-200 RPM	12 $\frac{1}{2}$ "	900 lbs.	1040 lbs.
794LX	$\frac{1}{8}$ " to 2"	$\frac{1}{4}$ " to 2"	0-200 RPM	12 $\frac{1}{2}$ "	900 lbs.	1040 lbs.
792ALX	$\frac{1}{8}$ " to 2"	$\frac{1}{4}$ " to 2"	0-200 RPM	7 $\frac{3}{4}$ "*	1240 lbs.	1375 lbs.

\*Maximum thread length specified is maximum thread length without re-gripping. The 792ALX is available in 3 Bed sizes, the long bed has a maximum thread length of 15" and the extra long bed has a maximum thread length of 25". With Oster 792ALX Models, subtract  $\frac{3}{4}$ " from maximum thread length for all sizes under  $1\frac{1}{2}$ ".

# OSTER EXTRA and/or REPLACEMENT DIES For Oster Pipe, Conduit and Bolt Machines

**INSTRUCTIONS:** All tables for the same symbol Oster dies are grouped together. Check the proper table, ie. Pipe, Bolt, etc., of the symbol you require. Select the correct thread form - NPT, NC, etc. and follow that line across to the desired size and read the five digit part number.

\*Not all available dies are listed here, we offer a full range of metric, special and ACME dies for Oster machines. While we have a large inventory of dies available and try to keep most common sizes on the shelf we can not guarantee stock on all dies listed. For inquiries on unlisted dies, pricing, and availability of dies call 888-416-7837 or visit our website at [www.ostermfg.com](http://www.ostermfg.com) for more information on how to contact Oster.

## Symbol — Quad

### Pipe Dies — High Speed Steel

Threadform	1/8"	1/4" - 3/8"	1/2" - 3/4"	1" - 2"
NPT	11000	11003	11006	11009
NPSM	11001	11004	11007	11010
BSPT	11100	11101	11102	11103
NPT - Stainless	11002	11005	11008	11011
NPT - PVC	11019	11020	11017	11013
NPT - Brass		11039	11041	11032

### Beveling Dies — High Speed Steel

	1/2" - 3/4"	1" - 2"
37 1/2° Bevel	11050	11052
45° Bevel	11051	11053
Grooving	*	11054

### Bolt Dies(Imperial) — High Speed Steel

Threadform	1/4"	5/16"	3/8"	7/16"	1/2"	9/16"	5/8"	3/4"	7/8"	1"	1 1/8"	1 1/4"	1 3/8"	1 1/2"	1 3/4"	2"
NC	11200	11201	11202	11203	11204	11205	11206	11207	11208	11209	11210	11211	11212	11213	11214	11215
NF	11300	11301	11302	11303	11304	11305	11306	11307	11308	11310	11311	11312	11313	11314	*	*
ACME	*	*	*	*	11400	*	11401	*	11404	11405	11406	11407	11408	11409	11410	*
NS	*	*	*	*	11542	*	11500	11499	11504	11506	11507	11510	11513	11516	11535	11533

### Bolt Dies(Metric) — High Speed Steel

Metric	6	7	8	9	10	11	12	14	15	16	17	18	20	22	24	25
MA - SI	11800	11801	11802	11803	11804	11805	11806	11807	*	11808	*	11809	11810	11811	11812	*
MB - Fine	11900	11901	11902	11903	11904	11905	11906	11907	11908	11909	11931	11910	11911	11912	11913	11914

Metric	26	27	28	30	32	33	35	36	38	39	40	42	45	48	50	52
MA - SI	11828	11813	*	11814	*	11815	*	11816	11829	11817	*	11818	11819	11820	*	11821
MB - Fine	11915	11916	11917	11918	11919	11920	11921	11922	11923	11924	11925	11926	11927	11928	11929	11930

## Symbol — 300

### Pipe Dies — High Speed Steel

Threadform	1/8"	1/4" - 3/8"	1/2" - 3/4"	1" - 1 1/4"	1 1/2" - 2"
NPT	12000	12004	12009	12015	12020
NPT - LH	12003	12008	12013	12019	12024
NPSM	12001	12005	12010	12016	12026
NPSM - LH	*	*	12014	12027	12026
BSPT	12100	12103	12106	12109	12112
BSPP	12101	12104	12107	12110	12113
BSPT - LH	12102	12105	12108	12111	12114

### Beveling Dies — High Speed Steel

	1/2" - 3/4"	1" - 1 1/4"	1 1/2" - 2"
37 1/2° Bevel	12050	12052	12054
45° Bevel	12051	12053	12055
Grooving	*	12056	12057



# OSTER EXTRA and/or REPLACEMENT DIES For Oster Pipe, Conduit and Bolt Machines

## Symbol — 300 (cont.)

### Bolt Dies(Imperial) — High Speed Steel

Threadform	1/4"	5/16"	3/8"	7/16"	1/2"	9/16"	5/8"	3/4"	7/8"	1"	1 1/8"	1 1/4"	1 3/8"	1 1/2"	1 3/4"	2"
NC	12200	12201	12202	12203	12204	12205	12206	12207	12208	12209	12210	12211	12212	12213	12214	12215
NC - LH	12300	12318	12302	12301	12303	12314	12304	12305	12306	12307	12308	12309	12310	12311	12312	12313
NF	12400	12401	12402	12403	12404	12405	12406	12407	12408	12410	12411	12412	12413	12414	*	*
NF - LH	12500	12499	12502	12501	12503	12513	12504	12505	12506	12508	12509	12510	12511	12512	*	*

### Bolt Dies(Metric) — High Speed Steel

Metric	6	7	8	9	10	11	12	14	15	16	17	18	20	22	24	25
MA - SI	12900	12901	12902	12903	12904	12905	12906	12907	12908	12909	12910	12911	12912	12913	12914	12915
Metric	26	27	28	30	32	33	35	36	38	39	40	42	45	48	50	52
MA - SI	12916	12917	12918	12919	12920	12921	12922	12923	12924	12925	12926	12927	12928	12929	12930	12931

(Also available for cutting left hand threads.)

## Symbol — X1

### Pipe Dies — High Speed Steel

Threadform	1/8"	1/4"	3/8"	1/2"	3/4"	1"	1 1/4"	1 1/2"	2"
NPT	13000	13003	13006	13009	13012	13015	13018	13021	13024
NPT - Stainless	13002	13005	13008	13011	13014	13017	13020	13023	13026
NPSM	13001	13004	13007	13010	13013	13016	13019	13022	13025
BSPT	*	13100	13101	13102	13103	13104	13105	13106	13107
NPTF	*	*	13043	13027	13028	13029	13032	13039	13030

### Bolt Dies(Imperial) — High Speed Steel

Threadform	1/4"	5/16"	3/8"	7/16"	1/2"	9/16"	5/8"	3/4"	7/8"	1"	1 1/8"	1 1/4"	1 3/8"	1 1/2"	1 3/4"	2"
NC	13200	13202	13204	13206	13208	13210	13212	13214	13216	13218	13220	13222	13224	13226	13228	13230
NC - Stain.	13201	13203	13205	13207	13209	13211	13213	13215	13217	13219	13221	13223	13225	13227	13229	13231
NC - LH	13300	13301	13302	13303	13304	13305	13306	13307	13308	13309	13310	13311	13312	13313	13314	13315
NF	13400	13402	13404	13406	13408	13410	13412	13414	13416	13419	13421	13423	13425	13427	*	*
NF - Stain.	13401	13403	13405	13407	13409	13411	13413	13415	13417	13420	13422	13424	13426	13428	*	*
NF - LH	13500	13501	13502	13503	13504	13505	13506	13507	13508	13510	13511	13512	*	13513	*	*

### Bolt Dies(Metric) — High Speed Steel

Metric	6	7	8	9	10	11	12	14	15	16	17	18	20	22	24	25
MA - SI	13800	13801	13802	13803	13804	13805	11806	11807	*	13808	*	13809	13810	13811	13812	*
MB - Fine	13900	13901	13902	13903	13904	13905	13906	13907	13908	13910	13911	13912	13913	13914	13915	13916
Metric	26	27	28	30	32	33	35	36	38	39	40	42	45	48	50	52
MA - SI	*	13813	*	13814	*	13815	*	13816	*	13817	*	13818	13819	13820	*	*
MB - Fine	13917	13918	13919	13920	13921	13922	13923	13924	13925	13926	13927	13928	13929	13930	13931	13932

(Also available for cutting left hand threads)

# OSTER EXTRA and/or REPLACEMENT DIES For Oster Pipe, Conduit and Bolt Machines

## Symbol — 3D

### Pipe Dies — High Speed Steel

Threadform	$\frac{1}{8}$ "	$\frac{1}{4}$ " - $\frac{3}{8}$ "	$\frac{1}{2}$ " - $\frac{3}{4}$ "	1" - $1\frac{1}{4}$ "	$1\frac{1}{2}$ " - 2"
NPT	*	14002	14006	14010	14014
BSPT	*	14051	14052	14053	14054

### Bolt Dies(Imperial) — High Speed Steel

Threadform	$\frac{1}{4}$ "	$\frac{5}{16}$ "	$\frac{3}{8}$ "	$\frac{7}{16}$ "	$\frac{1}{2}$ "	$\frac{9}{16}$ "	$\frac{5}{8}$ "	$\frac{3}{4}$ "	$\frac{7}{8}$ "	1"	$1\frac{1}{8}$ "	$1\frac{1}{4}$ "	$1\frac{3}{8}$ "	$1\frac{1}{2}$ "	$1\frac{3}{4}$ "	2"
NC	14100	14101	14102	14103	14104	14105	14106	14107	14108	14109	14110	14111	14112	14113	14114	14115
NC - LH	14150	14151	14152	14153	14154	14155	14156	14157	14158	14159	14160	14161	14162	14163	14164	14165
NF	14200	14201	14202	14203	14204	14205	14207	14208	14209	14211	14213	14214	14215	14216	*	*

## Symbol — 77

### Pipe Dies — High Speed Steel

Threadform	$2\frac{1}{2}$ " - 3"	$3\frac{1}{2}$ " - 4"
NPT	14800	14801
NPT - Stainless	14813	14814
NPSM	14809	14810

### Bolt Dies — High Speed Steel

Threadform	$2\frac{1}{4}$ "	$2\frac{1}{2}$ "	$2\frac{3}{4}$ "	3"
NC	14811	14802	14803	14804
8 TPI	*	14848	*	*

### Beveling Dies — High Speed Steel

	$2\frac{1}{2}$ " - 3"	$3\frac{1}{2}$ " - 4"
$37\frac{1}{2}$ ° Bevel	14827	14828
45° Bevel	14829	14830

## Symbol — 784

### Pipe Dies — High Speed Steel

Threadform	$2\frac{1}{2}$ "	3"	$3\frac{1}{2}$ "	4"
NPT	16000	16003	16006	16009

### Bolt Dies — High Speed Steel

Threadform	$2\frac{1}{4}$ "	$2\frac{1}{2}$ "	$2\frac{3}{4}$ "	3"
NC	16100	16101	16102	16103

## Symbol — 74

### Pipe Dies — High Speed Steel

Threadform	$2\frac{1}{2}$ " - 4"
NPT	14600
NPT - Stainless	14601
NPSM	14602

### Bolt Dies — High Speed Steel

Threadform	$2\frac{1}{4}$ "	$2\frac{1}{2}$ "	$2\frac{3}{4}$ "	3"
NC	14700	14701	14702	14703

## Symbol — 44

### Pipe Dies — High Speed Steel

Threadform	$2\frac{1}{2}$ "	3"	$3\frac{1}{2}$ "	4"
NPT	10301	10302	10303	10304
NPSM	10305	10306	10307	10308

## Symbol — 304

### Bolt Dies — High Speed Steel

Threadform	$\frac{1}{2}$ " - $\frac{3}{4}$ "	1" - $1\frac{1}{4}$ "	$1\frac{1}{2}$ " - 2"	$2\frac{1}{2}$ " - 3"	$3\frac{1}{2}$ " - 4"
NPT	10401	10403	10405	10407	10409
NPSM	10402	10404	10406	10408	10410

## Symbol — 704-6

### Pipe Dies — High Speed Steel

Threadform	1" - 2"	$2\frac{1}{2}$ " - 6"
NPT	17000	17002
NPT - Stainless	17005	17003
NPSM	17001	17004

# OSTER EXTRA and/or REPLACEMENT DIES For Oster Pipe, Conduit and Bolt Machines

## Symbol — 704-6 (cont.)

### Bolt Dies(Imperial) — High Speed Steel

Threadform	1"	1 $\frac{1}{8}$ "	1 $\frac{1}{4}$ "	1 $\frac{3}{8}$ "	1 $\frac{1}{2}$ "	1 $\frac{3}{4}$ "	2"	2 $\frac{1}{4}$ "	2 $\frac{1}{2}$ "	2 $\frac{3}{4}$ "	3"	3 $\frac{1}{4}$ "	3 $\frac{1}{2}$ "	3 $\frac{3}{4}$ "	4"
NC	17100	17101	17102	17103	17104	17105	17106	17107	17108	17109	17110	17111	17112	17113	17114
8 TPI	*	*	17201	17202	17203	17206	17209	17211	17212	*	17213	17235	17232	17233	17234

## Symbol — 6A

### Pipe Dies — High Speed Steel

Threadform	1" - 2"	2 $\frac{1}{2}$ " - 6"
NPT	14400	14401
NPT - Stainless	*	14404
NPSM	*	14402

## Symbol — 8T

### Pipe Dies — High Speed Steel

Threadform	2 $\frac{1}{2}$ " - 8"
NPT	14561

## Symbol — 8R

### Pipe Dies — High Speed Steel

Threadform	2 $\frac{1}{2}$ " - 8"
NPT	14425
NPT - Stainless	14426
NPSM	14427

## Symbol — 12R

### Pipe Dies — High Speed Steel

Threadform	3 $\frac{1}{2}$ " - 12"
NPT	14450
NPSM	14455

## API

## (American Petroleum Institute) Dies

### High Speed Steel

Threadform	1" - 2"	2 $\frac{3}{8}$ "	2 $\frac{7}{8}$ " - 8 $\frac{5}{8}$ "	3 $\frac{1}{2}$ " - 12"
Quad - 10 Round 3/4T		*	*	*
8R - 8 Round 3/4T	*	*	14429	8
8R - 10 Round 3/4T	*	*	14430	8
8T - 8 Round 3/4T	*	14564	14560	8
8T - 10 Round 3/4T	*	14565	14562	8
8T - 11 $\frac{1}{2}$ Vee 3/4T	*	14566	14563	8
12R - 8 Round 3/4T	*	*	*	8

### SPECIAL DIES — AVAILABILITY/PRICES/POLICY

Oster will manufacture special dies (sizes and thread forms) not listed herein for use in Oster machines; and/or will grind dies for special materials such as stainless steel, red brass, copper, yellow brass, PVC, cast iron, etc.

To order special dies that are not listed in these pages, advise Oster of the size desired, thread form, thread pitch, the symbol and machine model number if available. We manufacture most out of stock dies in 2 to 4 weeks, some special dies may require a significant lead time — possibly 4 to 6 weeks.

Dies made special order cannot be cancelled or returned for credit. Price and availability will be provided upon request.



# OSTER THREADER REFABRICATION

## For Currently Supported Oster Models

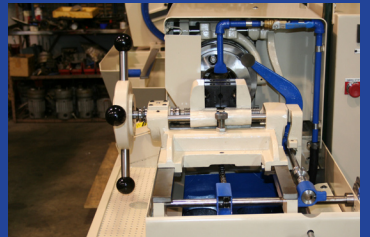
### What it means to be OSTER Factory Rebuilt

- Whether we rebuild your machine or one we have here at the factory, the first thing we do is completely disassemble the machine including the headstock and transmission.
- As the OEM manufacturer of Oster machines we have access to all original machine blueprints and assembly drawings. This allows us to check worn parts against the original specifications and return your machine to it's original quality with precision. If a part needs to be replaced with a new one, we can replace it with the same part as when it was new, both geometrically and with material and heat treat specifications.
- All painted parts and machine bed are sand blasted and powdercoated to produce a tremendously durable and long lasting finish.
- When the machine returns from powdercoat the reassembly process begins:
  - **Headstock** - The spindle is checked for wear and run out and replaced if necessary. All worn broken or chipped gears are replaced as well as the bearings. Installation of all new gaskets and seals.
  - **Die Head** - Threading machines with a capacity of 4" and under will receive brand new die-heads manufactured in the same facility where your machine is being rebuilt. On larger capacity machines the die head is completely disassembled and inspected. Worn parts are re-machined to original specifications or replaced. Any die-holders are inspected and re-machined or replaced. All rebuilt Oster machines come supplied with dies to cover the standard range of pipe for the machine.
  - **Self-centering vise carriage or Die Head style carriage** - Carriage is inspected for bottom wear and re-machined or replaced as needed. Vise screw and vise jaw holders are replaced as needed. All vise carriage machines will receive new vise studs and vise jaws. Carriages with cut-off are inspected and components are replaced as necessary and equipped with new cutters.
  - **Coolant Pump and Piping** - A new coolant pump is installed along with new sump screens and all piping is replaced with new.
  - **Bed** - Machine sump is tested for leaks and new bed ways are installed and aligned. Using special factory equipment a precise carriage and die head alignment is performed. New sheet metal guards and doors are repaired and replaced as needed.
  - **Motor** - A new energy efficient motor is installed.
  - **Electrical** - All wiring, conduit and junction boxes are installed new. All switches and contactors are installed new. All electrical enclosures are installed new. On available models a new top quality frequency drive is installed, eliminating the old style transmission.
- Upon completion of reassembly the machine then undergoes a rigorous testing process. We run your rebuilt machine for several days to ensure it is running in top condition. Our threading specialists then run sample threads on all standard material sizes with the dies that will ship with the machine and any cut-off, ream and chamfer tools are tested as well. Samples are then shipped with the rebuilt machine so you can be sure it's cutting high quality threads.
- After the testing process is complete we hand-build a rugged shipping crate for every machine. Your machine is bolted to the crate along with the required supply of threading oil and any dies or accessories. The entire package is then shrink wrapped and ready for safe transport to your facility.

Before we get started - A used Oster 792A Rapiduction 2" Threading Machine



After we finish - A Refabricated Oster 792A Rapiduction 2" Threading Machine



Before we get started - Thoroughly Used Oster 784 4" Threading Machines



After we finish - A Refabricated Oster 784 With New Oster Die-Heads



# OSTER THREADER REFABRICATION

## List Of Currently Supported Models



### Oster 582/584

Pipe Threading Capacity:  $\frac{1}{8}$ " to 2"  
Bolt Threading Capacity:  $\frac{1}{4}$ " to 2"  
Standard Die-Head: Quadversal Slide-In and/or Universal Slide-In  
Die Symbols Used: Quad and/or 300

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### Oster 582A

Pipe Threading Capacity:  $\frac{1}{8}$ " to 2"  
Bolt Threading Capacity:  $\frac{1}{4}$ " to 2"  
Standard Die-Head: Rotating Die-Head  
Die Symbols Used: X-1

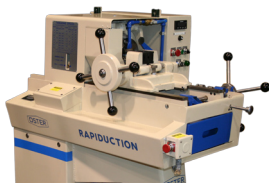
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### Oster 792/794 LE - "Rapiduction Series"

Pipe Threading Capacity:  $\frac{1}{8}$ " to 2"  
Bolt Threading Capacity:  $\frac{1}{4}$ " to 2"  
Standard Die-Head: Quadversal Slide-In and/or Universal Slide-In  
Die Symbols Used: Quad and/or 300

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### Oster 792A LE - "Rapiduction Series"

Pipe Threading Capacity:  $\frac{1}{8}$ " to 2"  
Bolt Threading Capacity:  $\frac{1}{4}$ " to 2"  
Standard Die-Head: Rotating Die-Head  
Die Symbols Used: X-1

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### Oster 784

Pipe Threading Capacity:  $\frac{1}{2}$ " to 4"  
Bolt Threading Capacity:  $\frac{3}{8}$ " to 3"  
Standard Die-Head: Quadversal, 784, 74, Universal  
Die Symbols Used: Quad, 784, 74, 300

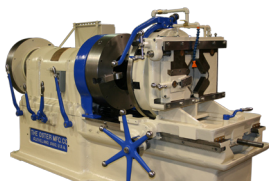
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### Oster 716

Pipe Threading Capacity: 1" to 6"  
Bolt Threading Capacity: 1" to 4"  
Standard Die-Head: One, adjustable to handle all sizes in standard range.  
Die Symbols Used: 704-6

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### Oster 8R - "Rapiduction Series"

Pipe Threading Capacity:  $2\frac{1}{2}$ " to 8"  
Bolt Threading Capacity: 2" to 6"  
Standard Die-Head: One, adjustable to handle all sizes in standard range.  
Die Symbols Used: 8R



# OSTER FACTORY REGRIND SERVICE

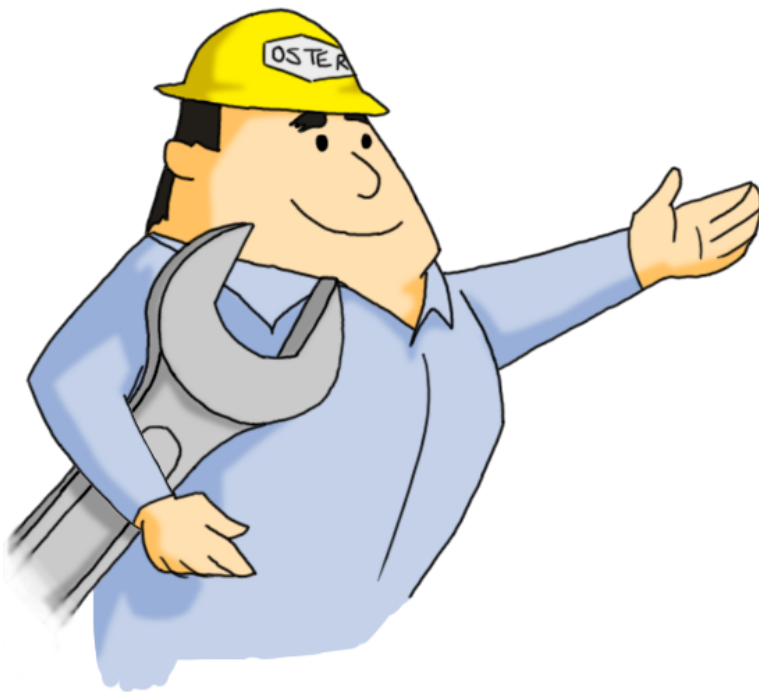
## For All Symbols of Oster Dies

That's right! Your Oster dies can be resharpened. One of the major differences between Oster dies and those of some competitors is not only can our dies be resharpened, we encourage it! A new set of Oster dies when sent for sharpening at the proper time can typically be resharpened 8 times and sometimes even more. By resharpening your Oster dies at the first sign of poor threads you can ensure maximum tool life for maximum return.

When you use the Oster factory regrind service we guarantee that you will receive the best quality of resharpening available for Oster dies. When a set of dies comes in for resharpening they are first inspected by one of our factory threading specialists. If the dies pass this inspection and are able to be resharpened they are sent to one of our die technicians. The technician then thoroughly cleans the dies and removes any badly chipped or broken teeth before sharpening.

After the teeth are removed the dies are taken to our grinding area where they are reground with the proper angle to match whichever material you are threading. After they have been sharpened in the grinding area the dies go through a special stress relief process to eliminate any potential weaknesses. The stress relieved dies are then stoned to eliminate any burrs or edges that are too sharp and returned to the shipping department for return to the customer.

Oster factory regrind service typically has less than a 24 hour turn around time. We realize that when resharpening dies time is of the essence; if your machine isn't cutting threads it isn't making any money. In most cases we will ship your dies to be returned to you on the same day we receive them or the next day at the latest.



### Special Grinds Available for:

- Stainless Steel
- Red Brass
- Yellow Brass
- P.V.C
- Cast Iron (Specify)
- Double Throat (Rhebar)
- Electrolizing
- Aluminum
- Copper
- Bronze
- Nickel
- Monel
- Inconel

# PREMIUM CUSTOMER SERVICE

## Technical Assistance for Oster Machines

At Oster we regard premium quality products and customer service above all else. We have skilled technicians on hand to assist you with any technical issues or questions about your machine AT NO CHARGE! We are more than happy to walk you through any process related to our machines and help you solve any technical issues that you may be having. Our job is to make the threading process as easy as possible for you and to keep your Oster threader running in top condition to ensure the best quality threads.



Need a manual for your machine? Simply visit our website and use our manual request form or give us a call and we'll be happy to e-mail or fax a manual for your machine AT NO CHARGE! Why charge for manuals? We don't believe in putting any barriers between you and a properly functioning machine.

Is the pump on your machine acting funny? Thread quality diminishing and your die-head seems sloppy? Send them back to the factory for a technical evaluation AT NO CHARGE! We will have one of our technicians examine your components for wear and broken parts and present you with a quote for the needed replacement parts. We do not charge a labor fee of any sort for this service.

Our technical experts are available for you from 8 AM to 5 PM every week day by phone or by e-mail. Whether you need help identifying a part number, finding replacement dies, advice on threading a specific material or any form of technical assistance we're here to help make your threading experience as easy as possible.

### Get in touch with us!

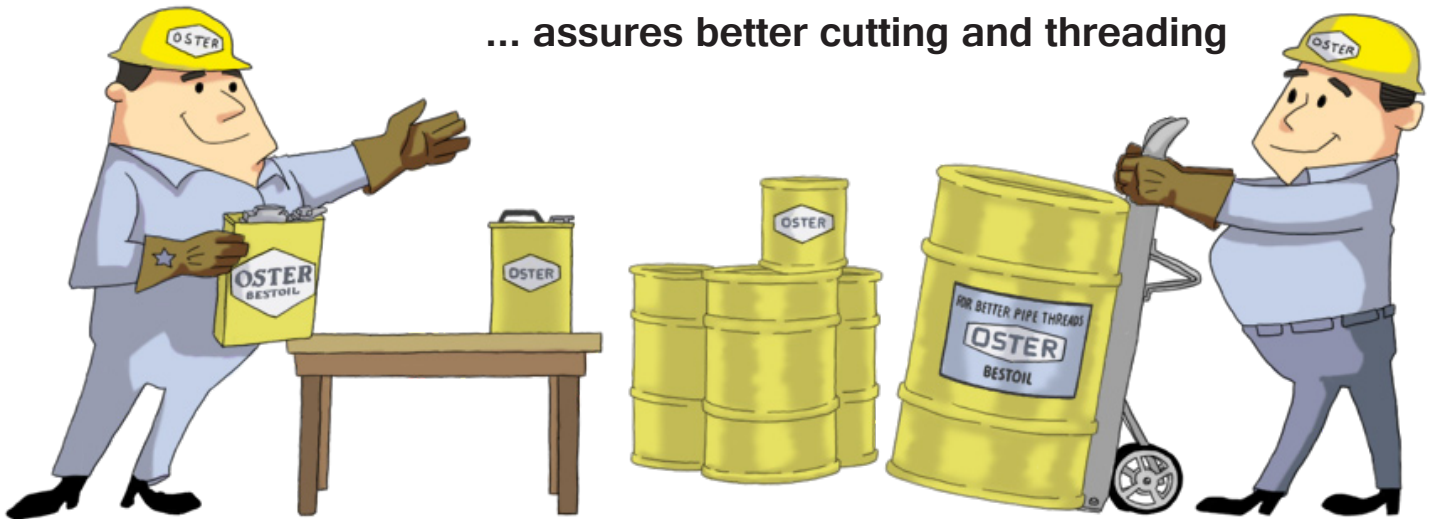
Phone : 989 - 729 - 1160  
Toll Free : 888 - 416 - 7837  
Fax : 989 - 729 - 1159  
Toll Free Fax : 888 - 716 - 7837  
E-Mail : [sales@ostermfg.com](mailto:sales@ostermfg.com)  
Website : [www.ostermfg.com](http://www.ostermfg.com)



# BESTOIL

Saves dies, cutters and power

... assures better cutting and threading



## So outstanding it is often copied but never duplicated!

... INCREASES DIE LIFE. By enabling you to use your threading dies longer, with fewer grinds, it puts money in your pocket.

... INSURES PERFECT THREADS. You get sharp, clean-cut threads—the leakproof kind, every time, when you use “Bestoil.”

... MAKES THREADING EASIER. Actual tests show that less effort is required to cut a thread when Oster “Bestoil” is used.

... IS FULLY ENDORSED to give complete satisfaction by OSTER, threading specialists for more than 117 years!

### The Purpose of Cutting Oil

The purpose of a good cutting oil is two fold: (1) To carry away the heat generated by the friction caused by cutting a thread or machining metal and (2) to penetrate the pores of the pipe or metal and cool the cutting teeth of the dies or cutting edge of the tool while they are embedded in the work.

Oster “Bestoil” accomplishes both in the most efficient manner. It is a carefully compounded oil containing sulphur held in permanent suspension. As sulphur is one of the best known cooling agents, “Bestoil” will absorb heat very readily and throw it off more quickly

than oils with animal, fish or vegetable oil bases. The sulphur content of Oster “Bestoil” never varies because it is held in perfect chemical combination.

- Oster “BESTOIL” can be used on stainless steel.
- Oster “BESTOIL” is also highly recommended for drilling, tapping, cutting and many other machining operations.
- Oster “BESTOIL” contains NO carcinogenic agents.

### Don't Be Fooled By Inferior Products!

Many products claim to be the ultimate in cutting fluids but don't be fooled. Radial thread-cutting is not your run of the mill operation. Because our machines are so simple to operate it's sometimes easy to forget about the complex forces involved in radial thread-cutting. Water soluble cutting solutions will not work and neither will those funky new clear “oils” you might see on the shelf at Home Depot. A heavy-duty operation requires a heavy-duty cutting fluid. For quality threads and longer die life always use Oster “BESTOIL.”





The equipment described herein is a part of a very complete line of power operated pipe and bolt threading machines made by us. In addition to our new and factory refabricated machines we have a full inventory of replacement parts for older and obsolete models. If you are interested in other types and sizes, either portable or stationary, or are looking for information on a machine not mentioned within please call 989-729-1160 or visit us online at [www.ostermfg.com](http://www.ostermfg.com).