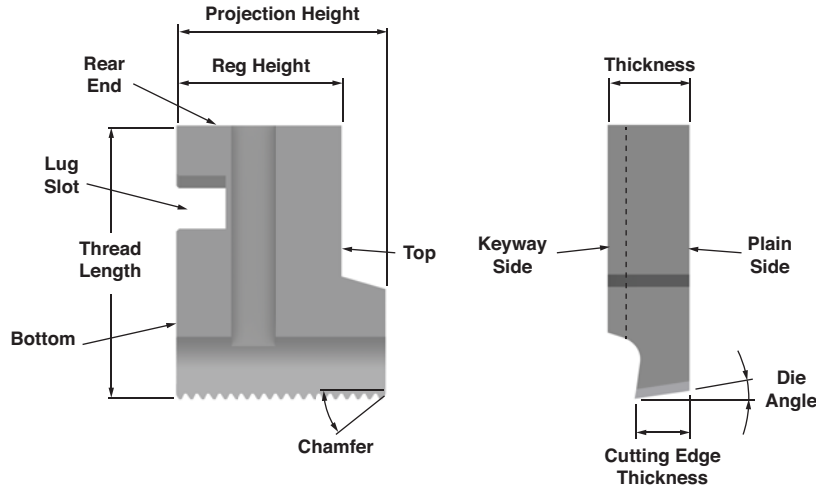
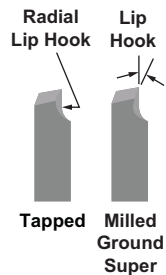
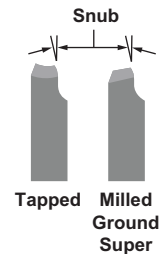
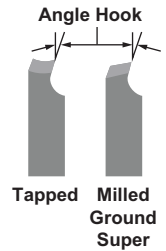
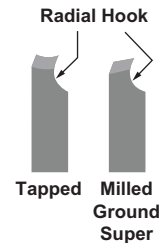
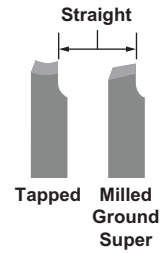


GEOMETRIC Chaser Specs & Terms

Geometric Chaser Parts



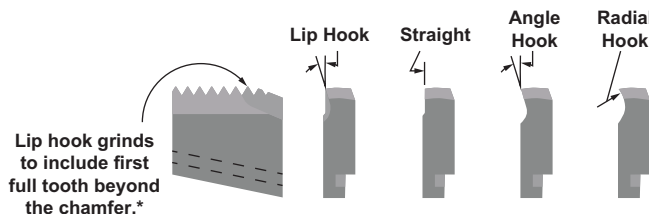
For Milled, Supermetric, Ground and Tapped Form



Geometric Chaser Grinding Chart

	Die Head Chasers		S-Tap Chasers	
	Milled-Thread	Ground-SUPER-Tapped	Ground	Taper Thread
Aluminum:				
Cast, Die, Cast, Rod, or Stamping	15° Radial hook	10° Radial Hook	20° Radial Hook	20° radial hook
Bakelite:	5° snub	5° snub	5° hook	5° hook
Brass:				
Bar	5° hook	straight	5° hook	5° hook
Cast	5° snub	5° hook	5° hook	5° hook
Forging, Stamping, Tubing, or Naval	10° hook	5° hook	10° hook	10° hook
Bronze:				
Bar, Cast, Aluminum, Manganese, Naval, Phosphor, Tubing	10° hook	5° hook	10° hook	10° hook
Cast	Straight	straight	10° hook	10° hook
Celluloid:	straight	straight	5° hook	5° hook
Copper:	15° radial lip hook	10° Radial Hook	20° lip hook	20° radial hook
Everdur:	10° hook	10° hook	10° hook	10° hook
Fibre:	5° snub	5° snub	5° hook	5° hook
Iron:				
Cast	straight	straight	5° hook	5° hook
Malleable, Wrought	10° hook	5° hook	10° hook	10° hook
Magnesium:	15° radial hook	20° radial hook	20° radial hook	20° radial hook
Monel Metal:	10° hook	5° hook	10° hook	10° hook
Nickel:	15° hook	10° hook	20° lip hook	15° radial hook
Rubber:	5° snub	5° snub	5° hook	5° hook
Silver:				
German	10° hook	5° hook	10° hook	10° hook
Steel:				
Bessmr, Scr. Stock, Cast, Carb.				
SAE 1010-1035, SAE 1112-X1340	10° hook	5° hook	10° hook	10° hook
Carb. SAE 1040-1095				
Mang. SAE T1330-T1350				
Chrome SAE 5120-52100				
Chrome Van SAE 6115-6195				
Molybdenum SAE 5130-4820				
Nickle SAE 2015-2515				
Nitalloy Ni-Chrome SAE 3115-3450				
Stainless, Tool, Forging	15° hook	10° hook	20° hook	15° radial hook
Stamping, Tubing	15° hook	5° hook	20° hook	15° radial hook
Semi-casting	straight	straight	5° hook	5° hook
Zinc:				
Die Casting	15° radial hook	10° Radial Hook	20° Radial Hook	20° radial hook

For Right and Left Hand Tap Chasers

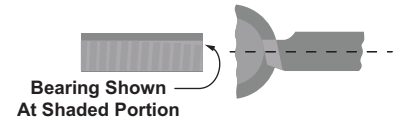


*Lip hook grinds not recommended for shoulder or bottoming work. Use the same angle but omit the lip.

Terms Related to Geometric Chasers

Bearing

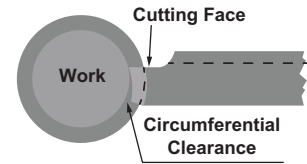
This is the surface in contact between the Chaser and the work when cutting the thread.



Circumferential Clearance

(Tapped Form and S Chasers)

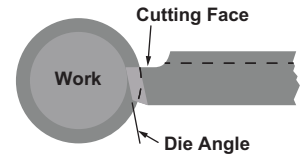
To provide relief circumferentially between chasers and work as shown so that the chasers will contact the work at the cutting face only.



Die Angle

(Milled, Ground thread, or Tapped Form Chasers)

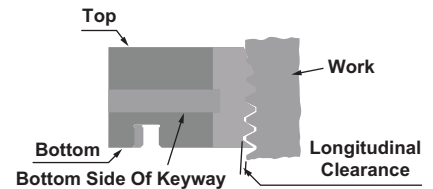
Relief between the chaser and the work is provided by the Die Angle, i.e., the angle at which the threads are milled.



Longitudinal Clearance

(Milled, Ground thread, or Tapped Form Chasers)

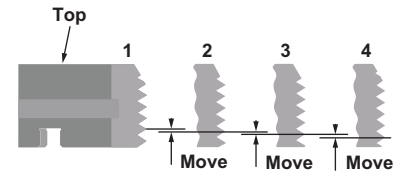
To provide clearance longitudinally between the chaser and the work as shown so all the cutting will be done at the chamfer.



Move (Single Thread)

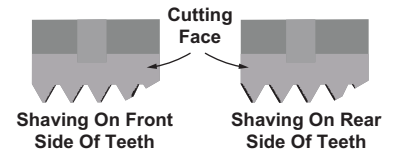
The distance or advance of a given thread from chaser to chaser is the "MOVE".

The distance is the same from one chaser to the next in a set (on single thread).



Tracking

Chasers "track" properly when all chasers of a set follow exactly in the groove cut by the preceding chaser or chasers.



Shaving

Shaving is the side cutting action of one or more chasers resulting in thin threads.

HOW TO ORDER Geometric Chasers

For D-Style and DJ Geometric chasers please fill in below:

Qty. Ordered	EDP Number	Diameter	Pitch/TPI Thread Per Inch	Thread Form NC, NF, NS NPT, NPS ACME, etc.	Righ or Left Hand	Type Milled Ground Supermetric Tapped Form	Chamfer 45, 33 22, 15, ect. Degrees	Projection O'hanging Regular Style	Die Head or Tap Size/Style	Construction No. or Serial Numbers	Face Grind Hook Str, Neg 5, 5P, 10P, 15P ect.	Material to Be Cut Steel, Brass Alum, ect.	Coating

For SAMN and SAMAN Geometric chasers please fill in below:

Qty. Ordered	EDP Number	Diameter	Pitch/TPI Thread Per Inch	Thread Form NC, NF, NS NPT, NPS ACME, etc.	Righ or Left Hand	Series 00 100, 200	Number Per set	Blank Width	Chamfer 45, 35 25, ect. Degrees	Die Head Size/Style	Face Grind Hook Str, Neg 5, 5P, 10P, 15P ect.	Material to Be Cut Steel, Brass Alum, ect.	Coating