
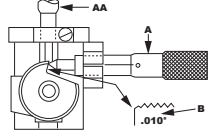


# Circular Chaser Diehead Seminar

Circular Chaser Seminar

## Suggested Grinds 4 Per Set Circular Chasers For Straight Threads

This chart is a guide for setting circular chaser cutting tool highs. Grinds for different materials may vary according to analysis, condition of machine, speeds and cutting coolant being used.

Material											
	Fixture Base Setting (Deg.)	Face Angle "b" on Chaser	Hook Angle "c" on Chaser	Namco Style MGA micrometer guage barrel AA is set to read single thread depth plus .010". This positions chaser in gauge so barrel A contacts chaser .010" below root of first full thread as at B. Face grind readings are then made on barrel A.							
				Face Grind Readings on Micrometer A: :NOTE: Readings shown for circular chasers and cutters for various head sizes Styles DR-DRD-DS-DBS - not thread diameters.							
				1/4 to 5/16	3/8	9/16	13/16	1 to 1-1/6	1-5/8	2-3/8	
Aluminum	84	2	20	.095 to .100	.500 to .505	.510 to .515	.513 to .518	.515 to .523	.518 to .528	.525 to .533	
Bronze (Al 10%)	84-1/2	1-1/2	20	.095 to .100	.500 to .505	.510 to .515	.513 to .518	.515 to .523	.518 to .525	.525 to .533	
Brass Free Cut	89-1/2	1-1/2	5 Rev.	.100 to .105	.510 to .515	.513 to .518	.515 to .523	.518 to .528	.525 to .530	.518 to .535	
Copper	84	2	20	.095 to .100	.500 to .505	.510 to .515	.513 to .518	.515 to .523	.518 to .525	.525 to .533	
Steels non Heat Treated	84-1/2	1-1/2	20	.098 to .100	.495 to .500	.502 to .510	.508 to .513	.510 to .518	.518 to .525	.525 to .533	
Steels Heat Treated	85	2	15	.098 to .100	.495 to .500	.502 to .510	.508 to .515	.510 to .518	.518 to .528	.525 to .533	
Steels Stainless	83-1/2	1-1/2	25	.095 to .100	.495 to .500	.502 to .510	.508 to .513	.510 to .518	.515 to .523	.523 to .530	
Iron Cast	87	2	5	.100 to .105	.500 to .505	.510 to .515	.513 to .518	.515 to .523	.518 to .525	.523 to .528	
Iron Malleable	87-1/2	1-1/2	5	.100 to .105	.500 to .505	.510 to .515	.513 to .518	.515 to .523	.518 to .525	.523 to .528	

RSVP Tooling, Inc.

