

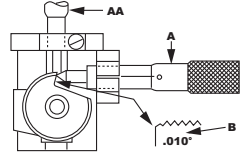


# Circular Chaser Diehead Seminar

## Suggested Grinds 5 Per Set Circular Chasers For Straight Threads

This chart is a guide for approximate Circular Chaser grinds for different materials and may vary according to analysis, condition of machine, speeds and cutting coolant used.

Material							
	Fixture Base Setting (Deg.)	Face Angle "b" on Chaser (Deg.)		Hook Angle "c" on Chaser (Deg.)	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.		
					DRF & DSF 1"	DRF & DSF 1-5/8"	DRF & DSF 2-3/8"
Aluminum	84	2	20	.513 to .518	.515 to .523	.518 to .525	
Bronze (Al 10%)	84-1/2	1-1/2	20	.513 to .518	.515 to .523	.518 to .525	
Brass Free Cut	89-1/2	1-1/2	5 Rev.	.515 to .523	.518 to .528	.525 to .530	
Copper	84	2	20	.513 to .518	.515 to .523	.518 to .525	
Steels non Heat Treated	84-1.2	1-1/2	20	.510 to .515	.512 to .520	.518 to .525	
Steels Heat Treated	85	2	15	.512 to .520	.518 to .528	.520 to .530	
Steels Stainless	83-1/2	1-1/2	25	.508 to .513	.510 to .518	.515 to .523	
Iron Cast	87	2	5	.513 to .520	.515 to .523	.518 to .525	
Iron Malleable	87-1/2	1-1/2	5	.513 to .520	.515 to .523	.518 to .525	