
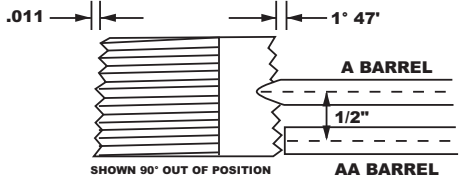


Circular Chaser Diehead Seminar

Suggested Grinds For Taper Threads

This chart is a guide for setting circular chaser cutting tool highs. Grinds for different material may vary according to analysis, condition of machine, speeds and cutting coolant being used. As taper pipe chasers are made with 1-47' taper on them it is necessary to compensate for this taper. When taper chasers are ground and set will have no face angle, and will be square with the base of the chasers block.

Material										
	Fixture Base Setting (Deg.)	Face Angle "b" on Chaser	Hook Angle "c" on Chaser	1/4 to 5/16	3/8	9/16	13/16	1 to 1-1/6	1-5/8	2-3/8
Aluminum	86	0	20	.09118 to .103	.503 to .508	.510 to .515	.513 to .518	.518 to .523	.520 to .525	.528 to .533
Bronze (Al 10%)	86	0	20	.098 to .103	.503 to .508	.510 to .515	.513 to .518	.518 to .523	.520 to .525	.528 to .533
Copper	86	0	20	.098 to .103	.503 to .508	.510 to .515	.513 to .518	.518 to .523	.520 to .525	.528 to .533
Brass Freecut	89	0	5 Rev.	.100 to .105	.510 to .515	.513 to .518	.515 to .520	.520 to .528	.525 to .530	.528 to .533
Steels non Heat Treated	86	0	20	.098 to .105	.500 to .505	.502 to .512	.508 to .518	.513 to .523	.518 to .525	.520 to .530
Steels Heat Treated	81	0	15	.100 to .105	.500 to .508	.505 to .513	.510 to .518	.515 to .523	.518 to .525	.525 to .535
Steels Stainless	85	0	25	.100 to .105	.495 to .500	.502 to .510	.510 to .518	.513 to .520	.518 to .525	.520 to .530
Iron Cast	89	0	5	.100 to .105	.505 to .513	.510 to .518	.513 to .523	.515 to .525	.520 to .528	.525 to .533
Iron Malleable	89	0	5	.100 to .105	.505 to .513	.510 to .518	.513 to .523	.515 to .525	.520 to .525	.525 to .533