

## Quality™ CHASERS FOR GEOMETRIC **D** & **K** DIE HEADS RECOMMENDED CUTTING FACE ANGLES

MATERIAL		STRAIGHT THREADS	TAPERED THREADS
ALUMINUM	Cast	15° Radial Hook	10° Radial Hook
	Die Cast	15° Radial Hook	10° Radial Hook
	Bronze Cast	10° Hook	5° Hook
	Rod	15° Radial Hook	10° Radial Hook
	Stamping	15° Radial Hook	10° Radial Hook
Bakelite		5° Snub	5° Snub
Beryllium		15° Hook	10° Hook
BRASS	Bar	5° Hook	Straight
	Cast	5° Snub	5° Snub
	Forging	10° Hook	5° Hook
	Red	10° Hook	5° Hook
	Stamping	10° Hook	5° Hook
	Tubing	10° Hook	5° Hook
	Naval	10° Hook	5° Hook
	Yellow	5° Hook	Straight
BRONZE	Bar	10° Hook	5° Hook
	Cast	Straight	Straight
	Cast Aluminum	10° Hook	5° Hook
	Manganese	10° Hook	5° Hook
	Naval	10° Hook	5° Hook
	Phosphor	10° Hook	5° Hook
	Silicone	5° Hook	Straight
	Tubing	10° Hook	5° Hook
Celluloid		Straight	Straight
Copper		15° Radial Lip Hook	10° Radial Hook
Delron		Straight	Straight
Drill Rod		10° Hook	10° Hook
Everdur		10° Hook	5° Hook
Fiberglas®		5° Hook	5° Hook
Fibre		5° Snub	5° Snub
Formica®		5° Hook	
Hastalloy		15° Hook	10° Hook
Inconel		15° Hook	10° Hook
Invar		15° Hook	10° Hook
IRON	Black Pipe	10° Hook	5° Hook
	Cast	Straight	Straight
	Ductile	Straight	Straight
	Gray	Straight	Straight
	Malleable	10° Hook	5° Hook
	Wrought	10° Hook	5° Hook
Magnesium		15° Radial Hook	10° Radial Hook
Manganese		15° Hook	10° Hook
Monel Metal		10° Hook	5° Hook

MATERIAL		STRAIGHT THREADS	TAPERED THREADS
Nickel		15° Hook	10° Hook
Nylon		5° Hook	5° Hook
Plastic		5° Hook	5° Hook
Polypropylene		5° Hook	5° Hook
Rubber		5° Snub	5° Snub
STEEL	12L14 & 12L17	10° Hook	5° Hook
	A-36	15° Hook	10° Hook
	Bessemer Screw	10° Hook	5° Hook
	Bolt, grade 2 & 3	10° Hook	5° Hook
	Bolt, grade 5 & 8	15° Hook	10° Hook
	Cast	10° Hook	5° Hook
	<b>Carbon</b>		
	- SAE 1010-1035	10° Hook	5° Hook
	- SAE 1112-X1340	10° Hook	5° Hook
	- SAE 1040-1095	15° Hook	10° Hook
	<b>Chrome</b>		
	- SAE 5120-52100	15° Hook	10° Hook
	<b>Chrome Vanadium</b>		
	-SAE 6115-6195	15° Hook	10° Hook
	Forged	15° Hook	10° Hook
	Leaded	10° Hook	5° Hook
	<b>Manganese</b>		
	- SAE T1330-T1350	15° Hook	10° Hook
	<b>Molybdenum</b>		
	- SAE 4130-4820	15° Hook	10° Hook
	<b>Nickel</b>		
	- SAE 2015-2515	15° Hook	10° Hook
	<b>Ni-Chrome</b>		
	- SAE 3115-3450	15° Hook	10° Hook
	Nitralloy	15° Hook	10° Hook
	Rolled (Hot & Cold)	10° Hook	5° Hook
	Semi-Casting	Straight	Straight
	<b>Stainless</b>		
- 300 series	15° Hook	15° Hook	
- 400 series	10° Hook	10° Hook	
Stamping	15° Hook	5° Hook	
Stress & Fatigue Proof	10° Hook	10° Hook	
Stress Proof 8620	15° Hook	10° Hook	
Tool	15° Hook	10° Hook	
Tubing	10° Hook	5° Hook	
Teflon		5° Hook	5° Hook
Titanium		15° Hook	15° Hook
Zinc, Diecast		15° Radial Hook	10° Radial Hook