



Quality™ Chasers for Cleveland Style Die Heads

STANDARD BLANK

CUSTOM WIDTHS AVAILABLE



00 & 100 SERIES
DIE HEAD CHASERS

ESSENTIALS:

The following pages list Quality Chaser Insert chasers in many popular diameter and pitch combinations. The numbers listed across each row represent the different cutting edge grinds that are available. Tools listed in the first column are stocked without the chamfer or cutting edge ground, hence the term "Semi-Finished". The following six columns list finished chasers with the final grinding operations complete. Please order *finished* numbers whenever possible.

Our line of insert chasers is manufactured from premium-grade M2 steel. We also offer these chasers made from premium-grade M-42 "cobalt". Part numbers listed on the following pages signify M2 product.

SPECIFICS:

For proper order entry, you will need the following:

1. Number of sets required
2. Part Number
3. Material being threaded

If no part number is available, you must also supply:

4. Diameter and Pitch of thread to be cut
5. Thread Form (UN, ACME, METRIC, PIPE, etc.)
6. Cutting Face Angle and Type
7. Chamfer Angle
8. Blank Width & Chaser Series
9. Size and Style of Die Head

TO ORDER

USE OUR 24 HOUR TOLL-FREE FAX LINE

800-562-7799

OR

CALL OUR CUSTOMER SERVICE DEPT.

586-752-5555

MONDAY - FRIDAY

8:00 AM - 5:00 PM ET



INSERT CHASERS (100 SERIES)

AMERICAN NATIONAL FORMS - UNC, UNF, UNS

RIGHT AND LEFT HAND THREADS

1

SIZE	BLANK WIDTH	PRICE CODE	SEMI FINISHED	STEEL / 10 POS. HOOK			BRASS / 5 NEG. HOOK		
				22 CHAMFER	33 CHAMFER	45 CHAMFER	22 CHAMFER	33 CHAMFER	45 CHAMFER
#0-80 NF	5/8" WIDE	IQ	80201	50601	50602	50603	50604	50605	50606
#1-64 NC	5/8" WIDE	IQ	80203	50607	50608	50609	50610	50611	50612
#1-72 NF	5/8" WIDE	IQ	80205	50613	50614	50615	50616	50617	50618
#2-56 NC	5/8" WIDE	IQ	80207	50619	50620	50621	50622	50623	50624
#2-64 NF	5/8" WIDE	IQ	80209	50625	50626	50627	50628	50629	50630
#3-48 NC	5/8" WIDE	IQ	80211	50631	50632	50633	50634	50635	50636
#3-56 NF	5/8" WIDE	IQ	80213	50637	50638	50639	50640	50641	50642
#4-40 NC	5/8" WIDE	IB	80215	50643	50644	50645	50646	50647	50648
#4-40 NC LH	5/8" WIDE	IQ	80485	51453	51454	51455	51456	51457	51458
#4-48 NF	5/8" WIDE	IQ	80217	50649	50650	50651	50652	50653	50654
#5-40 NC	5/8" WIDE	IB	80219	50655	50656	50657	50658	50659	50660
#5-40 NC LH	5/8" WIDE	IQ	80487	51459	51460	51461	51462	51463	51464
#5-44 NF	5/8" WIDE	IQ	80221	50661	50662	50663	50664	50665	50666
#6-32 NC	5/8" WIDE	IB	80223	50667	50668	50669	50670	50671	50672
#6-32 NC LH	5/8" WIDE	IQ	80489	51465	51466	51467	51468	51469	51470
#6-40 NF	5/8" WIDE	IB	80225	50673	50674	50675	50676	50677	50678
#8-32 NC	5/8" WIDE	IB	80227	50679	50680	50681	50682	50683	50684
#8-32 NC LH	5/8" WIDE	IQ	80491	51471	51472	51473	51474	51475	51476
#8-36 NF	5/8" WIDE	IB	80229	50685	50686	50687	50688	50689	50690
#8-36 NF LH	5/8" WIDE	IQ	80493	51477	51478	51479	51480	51481	51482
#8-40 NS	5/8" WIDE	IQ	80231	50691	50692	50693	50694	50695	50696
#8-40 NS LH	5/8" WIDE	IQ	80495	51483	51484	51485	51486	51487	51488
#10-24 NC	5/8" WIDE	IB	80233	50697	50698	50699	50700	50701	50702
#10-24 NC LH	5/8" WIDE	IQ	80497	51489	51490	51491	51492	51493	51494
#10-32 NF	5/8" WIDE	IB	80235	50703	50704	50705	50706	50707	50708
#10-32 NF LH	5/8" WIDE	IQ	80499	51495	51496	51497	51498	51499	51500
#10-40 NS	5/8" WIDE	IJ	80237	50709	50710	50711	50712	50713	50714
#12-24 NC	5/8" WIDE	IB	80239	50715	50716	50717	50718	50719	50720
#12-28 NF	5/8" WIDE	IB	80241	50721	50722	50723	50724	50725	50726
#12-32 NS	5/8" WIDE	IJ	80243	50727	50728	50729	50730	50731	50732
#14-24 NS	5/8" WIDE	IJ	80245	50733	50734	50735	50736	50737	50738
1/4-20 NC	5/8" WIDE	IB	80247	50739	50740	50741	50742	50743	50744
1/4-20 NC LH	5/8" WIDE	IQ	80501	51501	51502	51503	51504	51505	51506
1/4-24 NS	5/8" WIDE	IJ	80249	50745	50746	50747	50748	50749	50750
1/4-28 NF	5/8" WIDE	IB	80251 C	50751	50752	50753	50754	50755	50756
1/4-28 NC LH	5/8" WIDE	IQ	80503	51507	51508	51509	51510	51511	51512
1/4-32 NS	5/8" WIDE	IJ	80253	50757	50758	50759	50760	50761	50762
1/4-32 NS LH	5/8" WIDE	IQ	80505	51513	51514	51515	51516	51517	51518
1/4-36 UN	5/8" WIDE	IJ	80255	50763	50764	50765	50766	50767	50768
1/4-40 NS	5/8" WIDE	IJ	80257	50769	50770	50771	50772	50773	50774
1/4-40 NS LH	5/8" WIDE	IQ	80507	51519	51520	51521	51522	51523	51524
5/16-18 NC	5/8" WIDE	IB	80259 C	50775	50776	50777	50778	50779	50780
5/16-18 NC LH	5/8" WIDE	IQ	80509	51525	51526	51527	51528	51529	51530
5/16-20 UN	5/8" WIDE	IJ	80261	50781	50782	50783	50784	50785	50786
5/16-24 NF	5/8" WIDE	IB	80263	50787	50788	50789	50790	50791	50792
5/16-24 NF LH	5/8" WIDE	IQ	80511	51531	51532	51533	51534	51535	51536
5/16-27 UN	5/8" WIDE	IJ	80265	50793	50794	50795	50796	50797	50798
5/16-28 NS	5/8" WIDE	IQ	80267	50799	50800	50801	50802	50803	50804
5/16-32 NS	5/8" WIDE	IJ	80269	50805	50806	50807	50808	50809	50810
5/16-40 NS	5/8" WIDE	IJ	80271	50811	50812	50813	50814	50815	50816
11/32-32 UN	5/8" WIDE	IJ	80273	50817	50818	50819	50820	50821	50822

Quality™ CHASERS for CLEVELAND STYLE DIE HEADS

C = Available in M-42 steel

RED = Normally available for IMMEDIATE SHIPMENT



INSERT CHASERS (100 SERIES)

AMERICAN NATIONAL FORMS - UNC, UNF, UNS

RIGHT AND LEFT HAND THREADS

2

SIZE	BLANK WIDTH	PRICE CODE	SEMI FINISHED	STEEL / 10 POS. HOOK			BRASS / 5 NEG. HOOK		
				22 CHAMFER	33 CHAMFER	45 CHAMFER	22 CHAMFER	33 CHAMFER	45 CHAMFER
3/8-16 NC	5/8" WIDE	IB	80275 C	50823	50824	50825	50826	50827	50828
3/8-16 NC LH	5/8" WIDE	IQ	80513	51537	51538	51539	51540	51541	51542
3/8-20 UN	5/8" WIDE	IJ	80277	50829	50830	50831	50832	50833	50834
3/8-24 NF	5/8" WIDE	IB	80279 C	50835	50836	50837	50838	50839	50840
3/8-24 NF LH	5/8" WIDE	IQ	80515	51543	51544	51545	51546	51547	51548
3/8-27 UN	5/8" WIDE	IJ	80281	50841	50842	50843	50844	50845	50846
3/8-32 NS	5/8" WIDE	IJ	80283	50847	50848	50849	50850	50851	50852
3/8-32 NS LH	5/8" WIDE	IQ	80517	51549	51550	51551	51552	51553	51554
3/8-40 UN	5/8" WIDE	IJ	80285	50853	50854	50855	50856	50857	50858
7/16-14 NC	5/8" WIDE	IB	80287	50859	50860	50861	50862	50863	50864
7/16-14 NC LH	5/8" WIDE	IQ	80519	51555	51556	51557	51558	51559	51560
7/16-20 NF	5/8" WIDE	IB	80289	50865	50866	50867	50868	50869	50870
7/16-20 NF LH	5/8" WIDE	IQ	80521	51561	51562	51563	51564	51565	51566
7/16-24 NS	5/8" WIDE	IJ	80291	50871	50872	50873	50874	50875	50876
7/16-24 NS LH	5/8" WIDE	IQ	80523	51567	51568	51569	51570	51571	51572
7/16-27 UN	5/8" WIDE	IJ	80293	50877	50878	50879	50880	50881	50882
7/16-28 NS	5/8" WIDE	IJ	80295	50883	50884	50885	50886	50887	50888
7/16-32 NS	5/8" WIDE	IJ	80297	50889	50890	50891	50892	50893	50894
15/32-32 NS	5/8" WIDE	IJ	80299	50895	50896	50897	50898	50899	50900
1/2-13 NC	5/8" WIDE	IB	80301 C	50901	50902	50903	50904	50905	50906
1/2-13 NC LH	5/8" WIDE	IQ	80525	51573	51574	51575	51576	51577	51578
1/2-16 UN	5/8" WIDE	IJ	80303	50907	50908	50909	50910	50911	50912
1/2-20 NF	5/8" WIDE	IB	80305	50913	50914	50915	50916	50917	50918
1/2-20 NF LH	5/8" WIDE	IQ	80527	51579	51580	51581	51582	51583	51584
1/2-24 NS	5/8" WIDE	IJ	80307	50919	50920	50921	50922	50923	50924
1/2-27 NS	5/8" WIDE	IJ	80309	50925	50926	50927	50928	50929	50930
1/2-28 NS	5/8" WIDE	IJ	80311	50931	50932	50933	50934	50935	50936
1/2-32 NS	5/8" WIDE	IQ	80313	50937	50938	50939	50940	50941	50942
9/16-12 NC	5/8" WIDE	IB	80315	50943	50944	50945	50946	50947	50948
9/16-18 NF	5/8" WIDE	IB	80317	50949	50950	50951	50952	50953	50954
9/16-18 NF LH	5/8" WIDE	IQ	80529	51585	51586	51587	51588	51589	51590
9/16-20 UN	5/8" WIDE	IJ	80319	50955	50956	50957	50958	50959	50960
9/16-24 NS	5/8" WIDE	IB	80321	50961	50962	50963	50964	50965	50966
9/16-27 UN	5/8" WIDE	IJ	80323	50967	50968	50969	50970	50971	50972
9/16-32 UN	5/8" WIDE	IJ	80325	50973	50974	50975	50976	50977	50978
5/8-11 NC	5/8" WIDE	IB	80327	50979	50980	50981	50982	50983	50984
5/8-11 NC LH	5/8" WIDE	IQ	80531	51591	51592	51593	51594	51595	51596
5/8-18 NF	5/8" WIDE	IB	80329	50985	50986	50987	50988	50989	50990
5/8-18 NF LH	5/8" WIDE	IQ	80533	51597	51598	51599	51600	51601	51602
5/8-24 NS	5/8" WIDE	IJ	80331	50991	50992	50993	50994	50995	50996
5/8-27 UN	5/8" WIDE	IJ	80333	50997	50998	50999	51000	51001	51002
11/16-16 UN	5/8" WIDE	IJ	80335	51003	51004	51005	51006	51007	51008
11/16-18 UN	5/8" WIDE	IJ	80337	51009	51010	51011	51012	51013	51014
11/16-20 UN	5/8" WIDE	IJ	80339	51015	51016	51017	51018	51019	51020
11/16-24 UN	5/8" WIDE	IJ	80341	51021	51022	51023	51024	51025	51026
11/16-27 UN	5/8" WIDE	IJ	80343	51027	51028	51029	51030	51031	51032
11/16-32 UN	5/8" WIDE	IJ	80345	51033	51034	51035	51036	51037	51038
3/4-10 NC	5/8" WIDE	IB	80347	51039	51040	51041	51042	51043	51044
3/4-10 NC LH	5/8" WIDE	IQ	80535	51603	51604	51605	51606	51607	51608
3/4-12 UN	5/8" WIDE	IJ	80349	51045	51046	51047	51048	51049	51050
3/4-14 UN	5/8" WIDE	IJ	80351	51051	51052	51053	51054	51055	51056
3/4-16 NF	5/8" WIDE	IB	80353	51057	51058	51059	51060	51061	51062
3/4-16 NF LH	5/8" WIDE	IQ	80537	51609	51610	51611	51612	51613	51614
3/4-18 UN	5/8" WIDE	IJ	80355 C	51063	51064	51065	51066	51067	51068
3/4-20 NS	5/8" WIDE	IJ	80357	51069	51070	51071	51072	51073	51074
3/4-24 UN	5/8" WIDE	IJ	80359	51075	51076	51077	51078	51079	51080
3/4-27 UN	5/8" WIDE	IJ	80361	51081	51082	51083	51084	51085	51086
3/4-32 UN	5/8" WIDE	IJ	80363	51087	51088	51089	51090	51091	51092
13/16-16 UN	5/8" WIDE	IJ	80365	51093	51094	51095	51096	51097	51098
13/16-18 UN	5/8" WIDE	IJ	80367	51099	51100	51101	51102	51103	51104
13/16-20 UN	5/8" WIDE	IJ	80369	51105	51106	51107	51108	51109	51110
13/16-27 UN	5/8" WIDE	IJ	80371	51111	51112	51113	51114	51115	51116
13/16-32 UN	5/8" WIDE	IJ	80373	51117	51118	51119	51120	51121	51122

Quality™ CHASERS for CLEVELAND STYLE DIE HEADS

C = Available in M-42 steel

RED = Normally available for IMMEDIATE SHIPMENT



INSERT CHASERS (100 SERIES)

AMERICAN NATIONAL FORMS - UNC, UNF, UNS

RIGHT AND LEFT HAND THREADS

3

SIZE	BLANK WIDTH	PRICE CODE	SEMI FINISHED	STEEL / 10 POS. HOOK			BRASS / 5 NEG. HOOK		
				22	33	45	22	33	45
				CHAMFER	CHAMFER	CHAMFER	CHAMFER	CHAMFER	CHAMFER
7/8-9 NC	5/8" WIDE	IB	80375	51123	51124	51125	51126	51127	51128
7/8-9 NC LH	5/8" WIDE	IQ	80539	51615	51616	51617	51618	51619	51620
7/8-12 UN	5/8" WIDE	IJ	80377	51129	51130	51131	51132	51133	51134
7/8-14 NF	5/8" WIDE	IB	80379	51135	51136	51137	51138	51139	51140
7/8-14 NF LH	5/8" WIDE	IQ	80541	51621	51622	51623	51624	51625	51626
7/8-16 UN	5/8" WIDE	IJ	80381	51141	51142	51143	51144	51145	51146
7/8-18 UN	5/8" WIDE	IJ	80383	51147	51148	51149	51150	51151	51152
7/8-20 NS	5/8" WIDE	IJ	80385	51153	51154	51155	51156	51157	51158
7/8-27 UN	5/8" WIDE	IJ	80387	51159	51160	51161	51162	51163	51164
7/8-32 UN	5/8" WIDE	IJ	80389	51165	51166	51167	51168	51169	51170
15/16-16 UN	5/8" WIDE	IJ	80391	51171	51172	51173	51174	51175	51176
15/16-18 UN	5/8" WIDE	IJ	80393	51177	51178	51179	51180	51181	51182
15/16-20 UN	5/8" WIDE	IJ	80395	51183	51184	51185	51186	51187	51188
1-8 NC	5/8" WIDE	IB	80397	51189	51190	51191	51192	51193	51194
1-8 NC LH	5/8" WIDE	IQ	80543	51627	51628	51629	51630	51631	51632
1-12 NF	5/8" WIDE	IB	80399	51195	51196	51197	51198	51199	51200
1-14 NS	5/8" WIDE	IB	80401 C	51201	51202	51203	51204	51205	51206
1-14 NF LH	5/8" WIDE	IQ	80545	51633	51634	51635	51636	51637	51638
1-16 UN	5/8" WIDE	IJ	80403	51207	51208	51209	51210	51211	51212
1-20 UN	5/8" WIDE	IJ	80405	51213	51214	51215	51216	51217	51218
1-24 UN	5/8" WIDE	IJ	80407	51219	51220	51221	51222	51223	51224
1-27 UN	5/8" WIDE	IJ	80409	51225	51226	51227	51228	51229	51230
1-28 UN	5/8" WIDE	IJ	80411	51231	51232	51233	51234	51235	51236
1 1/16-12 UN	5/8" WIDE	IJ	80413	51237	51238	51239	51240	51241	51242
1 1/16-14 UN	5/8" WIDE	IJ	80415	51243	51244	51245	51246	51247	51248
1 1/16-16 UN	5/8" WIDE	IJ	80417	51249	51250	51251	51252	51253	51254
1 1/16-18 UN	5/8" WIDE	IJ	80419	51255	51256	51257	51258	51259	51260
1 1/16-20 UN	5/8" WIDE	IJ	80421	51261	51262	51263	51264	51265	51266
1 1/8-7 NC	5/8" WIDE	IB	80423	51267	51268	51269	51270	51271	51272
1 1/8-12 NF	5/8" WIDE	IB	80425	51273	51274	51275	51276	51277	51278
1 1/8-16 UN	5/8" WIDE	IJ	80427	51279	51280	51281	51282	51283	51284
1 1/8-18 UN	5/8" WIDE	IJ	80429	51285	51286	51287	51288	51289	51290
1 1/8-20 UN	5/8" WIDE	IJ	80431	51291	51292	51293	51294	51295	51296
1 1/8-24 UN	5/8" WIDE	IJ	80433	51297	51298	51299	51300	51301	51302
1 3/16-12 UN	5/8" WIDE	IJ	80435	51303	51304	51305	51306	51307	51308
1 3/16-16 UN	5/8" WIDE	IJ	80437	51309	51310	51311	51312	51313	51314
1 3/16-18 UN	5/8" WIDE	IJ	80439	51315	51316	51317	51318	51319	51320
1 1/4-7 NC	5/8" WIDE	IB	80441	51321	51322	51323	51324	51325	51326
1 1/4-12 NF	5/8" WIDE	IB	80443	51327	51328	51329	51330	51331	51332
1 1/4-14 UN	5/8" WIDE	IJ	80445	51333	51334	51335	51336	51337	51338
1 1/4-16 UN	5/8" WIDE	IJ	80447	51339	51340	51341	51342	51343	51344
1 1/4-18 UN	5/8" WIDE	IJ	80449	51345	51346	51347	51348	51349	51350
1 1/4-20 UN	5/8" WIDE	IJ	80451	51351	51352	51353	51354	51355	51356
1 1/4-24 UN	5/8" WIDE	IJ	80453	51357	51358	51359	51360	51361	51362
1 5/16-12 UN	5/8" WIDE	IJ	80455	51363	51364	51365	51366	51367	51368
1 5/16-16 UN	5/8" WIDE	IJ	80457	51369	51370	51371	51372	51373	51374
1 5/16-18 UN	5/8" WIDE	IJ	80459	51375	51376	51377	51378	51379	51380
1 3/8-6 NC	5/8" WIDE	IQ	80461	51381	51382	51383	51384	51385	51386
1 3/8-12 NF	5/8" WIDE	IB	80463	51387	51388	51389	51390	51391	51392
1 3/8-16 UN	5/8" WIDE	IJ	80465	51393	51394	51395	51396	51397	51398
1 3/8-18 UN	5/8" WIDE	IJ	80467	51399	51400	51401	51402	51403	51404
1 1/2-6 NC	5/8" WIDE	IQ	80469	51405	51406	51407	51408	51409	51410
1 1/2-12 NF	5/8" WIDE	IB	80471	51411	51412	51413	51414	51415	51416
1 1/2-16 UN	5/8" WIDE	IJ	80473	51417	51418	51419	51420	51421	51422
1 1/2-24 UN	5/8" WIDE	IJ	80475	51423	51424	51425	51426	51427	51428
1 3/4-5 NC	5/8" WIDE	IQ	80477	51429	51430	51431	51432	51433	51434
1 3/4-12 NS	5/8" WIDE	IQ	80479	51435	51436	51437	51438	51439	51440
2-12 NS	5/8" WIDE	IQ	80481	51441	51442	51443	51444	51445	51446
2 1/4-12 NS	5/8" WIDE	IQ	80483	51447	51448	51449	51450	51451	51452

Quality™ CHASERS for CLEVELAND STYLE DIE HEADS

C = Available in M-42 steel

RED = Normally available for IMMEDIATE SHIPMENT



INSERT CHASERS (100 SERIES) ISO METRIC THREAD FORMS RIGHT HAND THREADS

4

SIZE	BLANK WIDTH	PRICE CODE	SEMI FINISHED	STEEL / 10 POS. HOOK			BRASS / 5 NEG. HOOK		
				22	33	45	22	33	45
				CHAMFER	CHAMFER	CHAMFER	CHAMFER	CHAMFER	CHAMFER
M4 X .7	5/8" WIDE	IB	80547	51639	51640	51641	51642	51643	51644
M4.5 X .75	5/8" WIDE	IB	80549	51645	51646	51647	51648	51649	51650
M5 X .8	5/8" WIDE	IB	80551	51651	51652	51653	51654	51655	51656
M6 X 1.0	5/8" WIDE	IB	80553	51657	51658	51659	51660	51661	51662



INSERT CHASERS (100 SERIES) ISO METRIC THREAD FORMS RIGHT HAND THREADS

SIZE	BLANK WIDTH	PRICE CODE	SEMI FINISHED	STEEL / 10 POS. HOOK			BRASS / 5 NEG. HOOK		
				22	33	45	22	33	45
				CHAMFER	CHAMFER	CHAMFER	CHAMFER	CHAMFER	CHAMFER
M8 X 1	5/8" WIDE	IB	80555	51663	51664	51665	51666	51667	51668
M8 X 1.25	5/8" WIDE	IB	80557	51669	51670	51671	51672	51673	51674
M10 X 1	5/8" WIDE	IB	80559	51675	51676	51677	51678	51679	51680
M10 X 1.25	5/8" WIDE	IB	80561	51681	51682	51683	51684	51685	51686
M10 X 1.5	5/8" WIDE	IB	80563	51687	51688	51689	51690	51691	51692
M12 X 1.25	5/8" WIDE	IB	80565	51693	51694	51695	51696	51697	51698
M12 X 1.5	5/8" WIDE	IB	80567	51699	51700	51701	51702	51703	51704
M12 X 1.75	5/8" WIDE	IB	80569	51705	51706	51707	51708	51709	51710
M14 X 1.5	5/8" WIDE	IB	80571	51711	51712	51713	51714	51715	51716
M14 X 2	5/8" WIDE	IB	80573	51717	51718	51719	51720	51721	51722
M16 X 1.5	5/8" WIDE	IB	80575	51723	51724	51725	51726	51727	51728
M16 X 2	5/8" WIDE	IB	80577	51729	51730	51731	51732	51733	51734
M18 X 1.5	5/8" WIDE	IB	80579	51735	51736	51737	51738	51739	51740
M18 X 2.5	5/8" WIDE	IB	80581	51741	51742	51743	51744	51745	51746
M20 X 1.5	5/8" WIDE	IB	80583	51747	51748	51749	51750	51751	51752
M20 X 2.5	5/8" WIDE	IB	80585	51753	51754	51755	51756	51757	51758
M22 X 1.5	5/8" WIDE	IB	80587	51759	51760	51761	51762	51763	51764
M22 X 2.5	5/8" WIDE	IB	80589	51765	51766	51767	51768	51769	51770

Quality™ CHASERS for
CLEVELAND STYLE DIE HEADS

C = Available in M-42 steel

RED = Normally available for IMMEDIATE SHIPMENT