



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 grind, 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 (00 SERIES)

AMERICAN NATIONAL FORMS - UNC, UNF, UNS RIGHT HAND AND LEFT HAND THREADS

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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
#0-80 NF	1/2" WIDE	IP	80001	50010	50011	50012	50013	50014	50015
#1-64 NC	1/2" WIDE	IP	80003	50016	50017	50018	50019	50020	50021
#1-72 NF	1/2" WIDE	IP	80005	50022	50023	50024	50025	50026	50027
#2-56 NC	1/2" WIDE	IH	80007	50028	50029	50030	50031	50032	50033
#2-64 NF	1/2" WIDE	IP	80009	50034	50035	50036	50037	50038	50039
#3-48 NC	1/2" WIDE	IP	80011	50040	50041	50042	50043	50044	50045
#3-56 NF	1/2" WIDE	IP	80013	50046	50047	50048	50049	50050	50051
#4-40 NC	1/2" WIDE	IA	80015	50052	50053	50054	50055	50056	50057
#4-40 NC LH	1/2" WIDE	IP	80115	50352	50353	50354	50355	50356	50357
#4-48 NF	1/2" WIDE	IP	80017	50058	50059	50060	50061	50062	50063
#5-40 NC	1/2" WIDE	IA	80019	50064	50065	50066	50067	50068	50069
#5-40 NC LH	1/2" WIDE	IP	80117	50358	50359	50360	50361	50362	50363
#5-44 NF	1/2" WIDE	IP	80021	50070	50071	50072	50073	50074	50075
#6-32 NC	1/2" WIDE	IA	80023	50076	50077	50078	50079	50080	50081
#6-32 NC LH	1/2" WIDE	IP	80119	50364	50365	50366	50367	50368	50369
#6-40 NF	1/2" WIDE	IA	80025	50082	50083	50084	50085	50086	50087
#8-32 NC	1/2" WIDE	IA	80027	50088	50089	50090	50091	50092	50093
#8-32 NC LH	1/2" WIDE	IP	80121	50370	50371	50372	50373	50374	50375
#8-36 NF	1/2" WIDE	IA	80029	50094	50095	50096	50097	50098	50099
#8-36 NF LH	1/2" WIDE	IP	80123	50376	50377	50378	50379	50380	50381
#8-40 NS	1/2" WIDE	IP	80031	50100	50101	50102	50103	50104	50105
#8-40 NS LH	1/2" WIDE	IP	80125	50382	50383	50384	50385	50386	50387
#10-24 NC	1/2" WIDE	IA	80033	50106	50107	50108	50109	50110	50111
#10-24 NC LH	1/2" WIDE	IP	80127	50388	50389	50390	50391	50392	50393
#10-32 NF	1/2" WIDE	IA	80035	50112	50113	50114	50115	50116	50117
#10-32 NF LH	1/2" WIDE	IP	80129	50394	50395	50396	50397	50398	50399
#10-40 NS	1/2" WIDE	IH	80037	50118	50119	50120	50121	50122	50123
#12-24 NC	1/2" WIDE	IA	80039	50124	50125	50126	50127	50128	50129
#12-28 NF	1/2" WIDE	IA	80041	50130	50131	50132	50133	50134	50135
#12-32 NS	1/2" WIDE	IH	80043	50136	50137	50138	50139	50140	50141
#14-24 NS	1/2" WIDE	IH	80045	50142	50143	50144	50145	50146	50147
1/4-20 NC	1/2" WIDE	IA	80047	50148	50149	50150	50151	50152	50153
1/4-20 NC LH	1/2" WIDE	IP	80131	50400	50401	50402	50403	50404	50405
1/4-24 NS	1/2" WIDE	IH	80049	50154	50155	50156	50157	50158	50159
1/4-28 NF	1/2" WIDE	IA	80051	50160	50161	50162	50163	50164	50165
1/4-28 NC LH	1/2" WIDE	IP	80133	50406	50407	50408	50409	50410	50411
1/4-32 NS	1/2" WIDE	IH	80053	50166	50167	50168	50169	50170	50171
1/4-32 NS LH	1/2" WIDE	IP	80135	50412	50413	50414	50415	50416	50417
1/4-36 UN	1/2" WIDE	IP	80055	50172	50173	50174	50175	50176	50177
1/4-40 NS	1/2" WIDE	IH	80057	50178	50179	50180	50181	50182	50183
1/4-40 NS LH	1/2" WIDE	IP	80137	50418	50419	50420	50421	50422	50423
5/16-18 NC	1/2" WIDE	IA	80059	50184	50185	50186	50187	50188	50189
5/16-18 NC LH	1/2" WIDE	IP	80139	50424	50425	50426	50427	50428	50429
5/16-20 UN	1/2" WIDE	IP	80061	50190	50191	50192	50193	50194	50195
5/16-24 NF	1/2" WIDE	IA	80063	50196	50197	50198	50199	50200	50201
5/16-24 NF LH	1/2" WIDE	IP	80141	50430	50431	50432	50433	50434	50435
5/16-27 UN	1/2" WIDE	IH	80065	50202	50203	50204	50205	50206	50207
5/16-28 NS	1/2" WIDE	IP	80067	50208	50209	50210	50211	50212	50213
5/16-32 NS	1/2" WIDE	IH	80069	50214	50215	50216	50217	50218	50219
5/16-40 NS	1/2" WIDE	IP	80071	50220	50221	50222	50223	50224	50225
11/32-32 UN	1/2" WIDE	IP	80073	50226	50227	50228	50229	50230	50231
3/8-16 NC	1/2" WIDE	IA	80075	50232	50233	50234	50235	50236	50237
3/8-16 NC LH	1/2" WIDE	IP	80143	50436	50437	50438	50439	50440	50441
3/8-20 UN	1/2" WIDE	IP	80077	50238	50239	50240	50241	50242	50243
3/8-24 NF	1/2" WIDE	IA	80079	50244	50245	50246	50247	50248	50249
3/8-24 NF LH	1/2" WIDE	IP	80145	50442	50443	50444	50445	50446	50447
3/8-27 UN	1/2" WIDE	IH	80081	50250	50251	50252	50253	50254	50255
3/8-32 NS	1/2" WIDE	IH	80083	50256	50257	50258	50259	50260	50261
3/8-32 NS LH	1/2" WIDE	IP	80147	50448	50449	50450	50451	50452	50453
3/8-40 UN	1/2" WIDE	IP	80085	50262	50263	50264	50265	50266	50267

Quality™ CHASERS for
CLEVELAND STYLE DIE HEADS

RED = Normally available for IMMEDIATE SHIPMENT



INSERT CHASERS (00 SERIES)

AMERICAN NATIONAL FORMS - UNC, UNF, UNS
RIGHT HAND AND LEFT HAND THREADS

2

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
7/16-14 NC	1/2" WIDE	IA	80087	50268	50269	50270	50271	50272	50273
7/16-14 NC LH	1/2" WIDE	IP	80149	50454	50455	50456	50457	50458	50459
7/16-20 NF	1/2" WIDE	IA	80089	50274	50275	50276	50277	50278	50279
7/16-20 NF LH	1/2" WIDE	IP	80151	50460	50461	50462	50463	50464	50465
7/16-24 NS	1/2" WIDE	IH	80091	50280	50281	50282	50283	50284	50285
7/16-24 NS LH	1/2" WIDE	IP	80153	50466	50467	50468	50469	50470	50471
7/16-27 UN	1/2" WIDE	IH	80093	50286	50287	50288	50289	50290	50291
7/16-28 NS	1/2" WIDE	IP	80095	50292	50293	50294	50295	50296	50297
7/16-32 NS	1/2" WIDE	IP	80097	50298	50299	50300	50301	50302	50303
15/32-32 NS	1/2" WIDE	IP	80099	50304	50305	50306	50307	50308	50309
1/2-13 NC	1/2" WIDE	IA	80101	50310	50311	50312	50313	50314	50315
1/2-13 NC LH	1/2" WIDE	IP	80155	50472	50473	50474	50475	50476	50477
1/2-16 UN	1/2" WIDE	IP	80103	50316	50317	50318	50319	50320	50321
1/2-20 NF	1/2" WIDE	IA	80105	50322	50323	50324	50325	50326	50327
1/2-20 NF LH	1/2" WIDE	IP	80157	50478	50479	50480	50481	50482	50483
1/2-24 NS	1/2" WIDE	IH	80107	50328	50329	50330	50331	50332	50333
1/2-27 NS	1/2" WIDE	IH	80109	50334	50335	50336	50337	50338	50339
1/2-28 NS	1/2" WIDE	IH	80111	50340	50341	50342	50343	50344	50345
1/2-32 NS	1/2" WIDE	IP	80113	50346	50347	50348	50349	50350	50351

Quality™ CHASERS for
CLEVELAND STYLE DIE HEADS



INSERT CHASERS (00 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
M4 X .7	1/2" WIDE	IA	80159	50484	50485	50486	50487	50488	50489
M4.5 X .75	1/2" WIDE	IA	80161	50490	50491	50492	50493	50494	50495
M5 X .8	1/2" WIDE	IA	80163	50496	50497	50498	50499	50500	50501
M6 X 1.0	1/2" WIDE	IA	80165	50502	50503	50504	50505	50506	50507
M8 X 1.0	1/2" WIDE	IA	80167	50508	50509	50510	50511	50512	50513
M8 X 1.25	1/2" WIDE	IA	80169	50514	50515	50516	50517	50518	50519



INSERT CHASERS (00 SERIES)

AMERICAN STANDARD PIPE THREADS - NPT, NPTF, NPS
BRITISH STANDARD PIPE 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
1/16-27 NPT	1/2" WIDE	IA	80171	50520	50521	50522	50523	50524	50525
1/8-27 NPT	1/2" WIDE	IA	80173	50526	50527	50528	50529	50530	50531
1/8-27 NPTF	1/2" WIDE	IA	80175	50532	50533	50534	50535	50536	50537
1/8-27 NPS	1/2" WIDE	IA	80177	50538	50539	50540	50541	50542	50543
1/8-28 BSPT	1/2" WIDE	IP	80179	50544	50545	50546	50547	50548	50549
1/8-28 BSPP	1/2" WIDE	IP	80181	50550	50551	50552	50553	50554	50555

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