

Landis® Tangential Chasers RAKE ANGLES

MATERIAL	RAKE ANGLE
Iron & Steel Alloys	
Cast Iron	15° positive
Wrought Iron	18° positive
Malleable Iron	18° positive
Low Carbon Steels <i>Free machining</i>	
B1112, C1117, etc.	22° positive
Low Carbon Steels <i>Non Free machining</i>	
C1010, C1018, etc.	22° positive
Alloy Steels <i>SAE 2000 to 6000 series, etc</i>	
160/200 Brinell	25° positive
200/300 Brinell	18° to 22° positive
Stainless Steel	25° positive
Aluminum & Aluminum Alloys	
Aluminum Shapes, Bars and Castings	10° positive
Alloy Castings	10° positive
Alloy Bars and Shapes	25° positive
Copper & Copper Alloy	
Copper	28° positive
Cast Brass	5° neg. to 0°
Cast Bronze	5° neg. to 0°
Forged or Rolled Brass <i>except free cutting</i>	22° positive
Free Cutting Brass <i>Bars and Forgings</i>	10° positive
Forged or Rolled Bronze	10° positive
Special Alloys	
Manganese Bronze	0° to 10° positive
Silicone Bronze (Everdur)	22° positive
Aluminum Bronze (Ampco Metal)	18° to 22° positive
Naval Bronze	0° to 10° positive
Plastics & Fiber	
Bakelite	0° to 10° positive
Lucite	0° to 15° negative