

Quality™ CHASERS FOR OSTER STYLE DIE HEADS RECOMMENDED CUTTING FACE ANGLES

MATERIAL		SYMBOL DIES		
		300 X1 784 542	8R 704-6 6A	QUAD 74
Aluminum	Drawn	15° - 20°	25° - 30°	20° - 25°
	Bar	15° - 20°	25° - 30°	20° - 25°
	Conduit	15° - 25°	25° - 35°	20° - 30°
	Die Cast	15° - 20°	25° - 30°	20° - 25°
Brass	Cast	Str.- 5° Snub	Str. - 5°	Str. - 5°
	Yellow		Str. - 5°	
	Thin Walled Tubing	5° - 10° Snub		Str. - 5° Snub
	Free Machining	Str.- 5° Snub	Str. - 5°	Str. - 5°
	Red (85 -15)	10° - 15°	20° - 30°	15° - 25°
Bronze	Cast	Str.- 5° Snub	Str. - 5°	Str. - 5°
	Manganese	Str.- 5° Snub	Str. - 5°	Str. - 5°
	Naval	Str.- 5° Snub	20° - 25°	Str. - 5°
	Phosphor	10° - 15°	20° - 25°	15° - 20°
Copper		15° - 20°	25° - 30°	20° - 25°
Non-Metallic	Fiber	20° - 30° Snub		15° Snub
	PVC	10° Snub	Str.	5° Snub
	Rubber	10° Snub	Str.	5° Snub
	Uscolite	10° Snub	Str.	5° Snub
	Bakelite	10° Snub	Str.	5° Snub
	Celluloid	10° Snub	Str.	5° Snub
Iron	Cast	Str.	Str. - 5°	5°
	Malleable	10° - 15°	20° - 25°	15° - 20°
	Wrought	15°	25°	20°
Steel	Bessemer	15°	25°	20°
	Screw Stock	15°	25°	20°
	SAE 1117 - 1145	15°	25°	20°
	Stainless	20°	30°	25°
	Chrome	20°	30°	25°
	Nickel	20°	30°	25°
	Seamless Tubing	20°	30°	25°
Monel		20°	30°	25°
Inconel		20°	30°	25°
Titanium		20°		
Steel Pipe	API 5-L	15°	25°	20°
	ASTM A-53	15° - 20°	25° - 30°	20° - 25°
	ASTM A-72	15°	25°	20°
	ASTM A-83	15° - 20°		15° - 20°
	ASTM A-93		20° - 25°	
	ASTM A-106	15° - 20°	20° - 25°	15° - 20°
	ASTM A-120	15°	25°	20°
	Stainless	20°	30°	25°