

RECOMMENDED CUTTING FACE ANGLES GEOMETRIC STYLE **S** & **SJ** TAP CHASERS

MATERIAL		STRAIGHT THREADS	TAPERED THREADS
ALUMINUM	Cast	20° Radial Hook	20° Radial Hook
	Die Cast	20° Radial Hook	20° Radial Hook
	Rod	20° Radial Hook	20° Radial Hook
	Stamping	20° Radial Hook	20° Radial Hook
Bakelite		5° Hook	5° Hook
BRASS	Bar	5° Hook	5° Hook
	Cast	5° Hook	5° Hook
	Forging	10° Hook	10° Hook
	Stamping	10° Hook	10° Hook
	Tubing	10° Hook	10° Hook
	Naval	10° Hook	10° Hook
BRONZE	Bar	10° Hook	10° Hook
	Cast	5° Hook	5° Hook
	Cast Aluminum	10° Hook	10° Hook
	Manganese	10° Hook	10° Hook
	Naval	10° Hook	10° Hook
	Phosphor	10° Hook	10° Hook
	Tubing	10° Hook	10° Hook
Celluloid		5° Hook	5° Hook
Copper		20° Lip Hook	20° Radial Hook
Everdur		10° Hook	10° Hook
Fibre		5° Hook	5° Hook
IRON	Cast	5° Hook	5° Hook
	Malleable	10° Hook	10° Hook
	Wrought	10° Hook	10° Hook
Magnesium		20° Radial Hook	20° Radial Hook
Monel Metal		10° Hook	10° Hook
Nickel		20° Lip Hook	15° Radial Hook

MATERIAL		STRAIGHT THREADS	TAPERED THREADS	
Rubber		5° Hook	5° Hook	
Silver - German		10° Hook	10° Hook	
STEEL	Bessemer Screw	10° Hook	10° Hook	
	Cast	10° Hook	10° Hook	
	Carbon - SAE 1010-1035 - SAE 1112-X1340 - SAE 1040-1095	10° Hook 10° Hook 20° Lip Hook	10° Hook 10° Hook 15° Radial Hook	
	Chrome - SAE 5120-52100	20° Lip Hook	15° Radial Hook	
	Chrome Vanadium -SAE 6115-6195	20° Lip Hook	15° Radial Hook	
	Forged	20° Lip Hook	15° Radial Hook	
	Manganese - SAE T1330-T1350	20° Lip Hook	15° Radial Hook	
	Molybdenum - SAE 4130-4820	20° Lip Hook	15° Radial Hook	
	Nickel - SAE 2015-2515	20° Lip Hook	15° Radial Hook	
	Ni-Chrome - SAE 3115-3450	20° Lip Hook	15° Radial Hook	
	Nitralloy	20° Lip Hook	15° Radial Hook	
	Stainless	20° Lip Hook	15° Radial Hook	
	Semi-Casting	5° Hook	5° Hook	
	Stamping	20° Lip Hook	15° Radial Hook	
	Tool	20° Lip Hook	15° Radial Hook	
	Tubing	20° Lip Hook	5° Hook	
	Zinc, Diecast		20° Radial Hook	20° Radial Hook