

## H & G Insert Chasers FACE GRIND & CHAMFER CHART

Material To Be Threaded	Cutting Speed In Feet Per Minute	Chamfer Grind In Degrees	FACE GRIND ANGLE	
			Chasers for all 00 and diameters 5/16 and below for 101, 102 and 103 Die Heads	Chasers for all diameters above 5/16 for 101, 102, 103, 108 & heavy duty Die Heads
1010 Carbon Steel	20-35	20	10	15
1015 Carbon Steel	20-35	20	10	15
1020 Carbon Steel	20-35	20	10	15
1025 Carbon Steel	20-35	20	10	15
1035 Carbon Steel	25-35	20	10	15
1045 Carbon Steel	15-30	20	10	15
1050 Carbon Steel	10-25	20	10	15
1090 Carbon Steel	10-20	15	10	15
1112 Screw Stock	30-60	20	10	15
1120 Screw Stock	25-45	20	10	15
1330 Screw Stock	15-30	20	10	15
2315 Nickel Steels	15-25	20	10	15
2330 Nickel Steels	15-25	20	10	15
3120 Nickel Chrome	15-25	20	10	15
3135 Nickel Chrome	15-25	20	10	15
5120 Chromium	15-20	20	10	15
6150 Chrome Vanad.	10-15	15	10	15
Brass Rod	Any	30	5 Neg.	5 Neg.
Brass Cast	Any	30	0-5 Neg.	0-5 Neg.
Brass Drawn Tube	Any	30	5	10
Bronze	30-50	30	5	10
Copper	25-50	30	5	10
Fibre	Any	30	0	5
Aluminum	20-50	30	10	15
Dural Forgings	20-50	20 or 30	5-10	10-15
Monel Metal	15-25	20	10	15
Rubber, Hard	Any	30	5	10
Steel Tube	20-40	20	10	15
Tool Steel	5-10	15	10	15
Cast Iron	20-40	30	5-10	10-15
Malleable Iron	20-50	30	0-10	0-15
Stainless Steel	10-15	20 or 15	10	15