

Specifications

"F" & "A" Landmatics

- For applications where the part rotates and the threading tool is stationary
- For straight threading, large diameter, and tapered thread applications from #4 to 6-1/2" maximum oversize (3 to 165 mm)
- Self-opening, manually, or cam closed operations available
- Generally applied to turret lathes, automatics, hand screw, and similar machines
- Manually closed, but can be optionally equipped with an overtravel feature allowing use with machines having a cam or automatic closing device

Specs/Dimensions

[5/8" F Chaser Holders](#)

[7/8" F Chaser Holders](#)

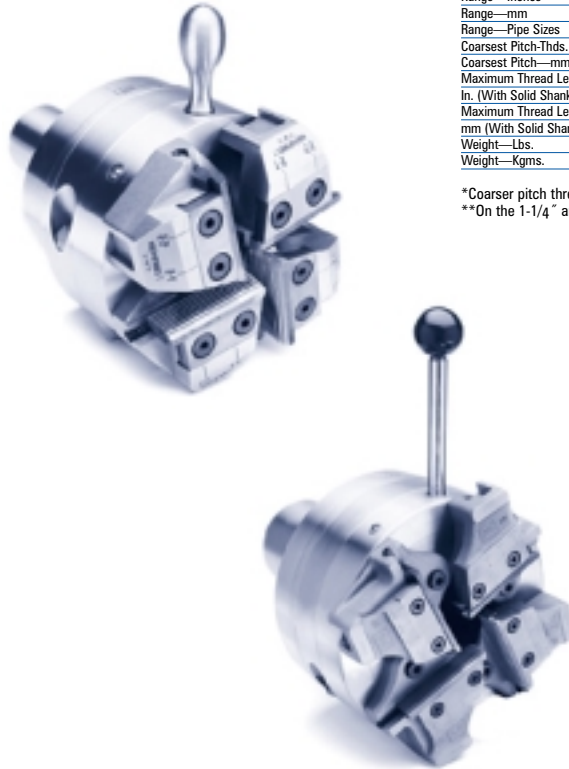
[1-1/4" F Chaser Holders](#)

[2" F Chaser Holders](#)

[3" A Chaser Holders](#)

[4" A Chaser Holders](#)

[Oversize F & A Chaser Holders](#)



Specifications

	5/8" 5F	7/8" 7F	1-1/4" 10F	2" 16F	3" 24A	4" 32A
Range—Inches	#4 to 5/8	#4 to 7/8	1/4 to 1-1/4	3/8 to 2	3/4 to 3	1 to 4
Range—mm	3 to 16	3 to 22	6 to 33**	9 to 52**	18 to 76	24 to 100
Range—Pipe Sizes	1/8 and 1/4	1/8 to 1/2	1/8 to 3/4	1/4 to 2	1/2 to 3	1 to 4
Coarsest Pitch—Thds. per in.*	11	9	7	4-1/2	4	4
Coarsest Pitch—mm*	2.0	2.5	3.5	5.0	6.0	6.0
Maximum Thread Length—In. (With Solid Shank)	2-3/4	3-3/8	4-1/2	5-1/8	6-13/16	7-19/32
Maximum Thread Length—mm (With Solid Shank)	69.8	85.7	114.3	130.2	173.1	193.1
Weight—Lbs.	4-3/4	10-1/2	23-1/2	51-1/4	137	252
Weight—Kgms.	2.15	4.76	10.66	23.25	62.14	114.31

*Coarser pitch threads can be produced dependent on thread form, materials, etc. Write for details enclosing print of workpiece.

**On the 1-1/4" and 2" F Heads, there is approximately 1/64" clearance between the I.D. of the bore and the largest Metric size O.D. listed.

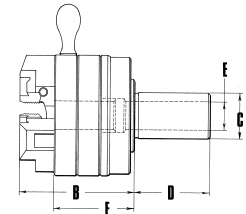
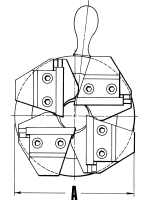
Dimensions

Dimensions	5/8" 5F		7/8" 7F		1-1/4" 10F		2" 16F		3" 24A		4" 32A	
	Inches	mm	Inches	mm	Inches	mm	Inches	mm	Inches	mm	Inches	mm
A	2-15/16	74.6	3-15/16	100	5-1/8	130	6-15/16	176.2	10-1/4	260.3	13-1/4	336.5
B*	3-11/64	80.6	3-3/4	95.2	4-57/64	124.2	6-1/8	155.6	8-11/64	207.6	9-5/16	236.6
C Std. Hollow	1	25.4	1-1/2	38.1	1-3/4	44.4	2-3/4	69.8	4-1/4	107.9	4-1/4	107.9
C Std. Solid	5/8	15.9	1	25.4	1-1/2	38.1	1-3/4	44.4				
TC Min. Hollow	7/8	22.2	1-1/4	31.8	1-3/4	44.4	2-5/8	66.7	3-3/4	95.2	4-1/4	107.9
TC Min. Solid	1/2	12.7	5/8	15.9	1-1/4	31.8	1-1/2	38.1	2	50.8	2-3/4	69.8
D	2	50.8	2-1/2	63.5	3-1/4	82.5	3-1/2	88.9	6	152.4	6	152.4
E	21/32	16.7	15/16	23.8	1-5/16	33.3	2-1/16	52.4	3-1/16	77.8	3-1/16**	77.8**
F	2-3/16	55.6	2-5/8	66.7	3-3/8	87.7	4-3/16	106.4	5-55/64	148.8	6-15/16	175.3

†Special shanks furnished upon order.

**The bore of the 4" LANDMATIC Head is 4-13/16" (122.2 mm) which allows a maximum workpiece O.D. of 4-3/4" (120.6 mm) to be threaded 7-3/4" (196.8 mm) in length. Longer length workpieces can be threaded if their O.D. is within the 3-1/6" I.D. (77.8 mm) of the hollow shank.

* "B" Dimension based upon the use of standard, maximum range U.N.C. Chaser Holders. For correct dimension when using oversize or other holders, please contact Landis Engineering Department.



Specifications

"F" & "A" Landmatics



5/8" 5F LANDMATIC - Standard Chaser HoldersK

RANGE	THREAD FORM	HELIX ANGLE	CHASER SIZE	RIGHT-HAND		LEFT-HAND	
				HOLDER PART NO.	GAGE PART NO.	HOLDER PART NO.	GAGE PART NO.
No. 4 to No. 12	UNC	4-1/4°	5/8 x 1-1/8	LNS0B051962A	L0D051855	LNS0B051963A	LNS0D051857
3/16 to 5/8	UNC	3-1/2°	5/8 x 1-1/8	LSB060069A	LOC060052	LNS0B060070A	LOC060053
No. 4 to No. 12	UNF	3-1/2°	5/8 x 1-1/8	LNS0B060069B	L0D051855	LNS0B060070B	LNS0D051857
1/4 to 5/8	UNF	2-1/3°	5/8 x 1-1/8	LSB060071B	LOC060052	LNS0B060072B	LOC060053
1-8 to 7/32	WHIT	4-1/4°	5/8 x 1-1/8	LNS0B051962C	L0D051855	LNS0B051963C	LNS0D051857
3/16 to 5/8	WHIT	3-1/2°	5/8 x 1-1/8	LNS0B060069C	LOC060052	LNS0B060070C	LOC060053
1/4 to 5/8	BSF	2-3/4°	5/8 x 1-1/8	LNS0B060073D	LOC060052	LNS0B060074D	LNS0C060053
4 to 16 mm	METRIC COARSE	3-1/2°	5/8 x 1-1/8	LNS0B060069E	LOC060054	LNS0B060070E	LNS0C060055
4 to 16 mm	METRIC FINE	2°	5/8 x 1-1/8	LNS0B060075F	LOC060054	LNS0B060154F	LNS0C060055
1/8 to 1/4	PIPE	2°	5/8 x 1-1/8	LNS0B060075I	LOC060056	LNS0B060154I	LNS0C060057

7/8" 7F LANDMATIC - Standard Chaser HoldersK

RANGE	THREAD FORM	HELIX ANGLE	CHASER SIZE	RIGHT-HAND		LEFT-HAND	
				HOLDER PART NO.	GAGE PART NO.	HOLDER PART NO.	GAGE PART NO.
No. 4 to No. 12	UNC	4-1/4°	3/4 x 1-5/8	LNS0B090842A	L0D060118	LNS0B090915A	L0D060119
1/4 to 7/8	UNC	3-1/4°	3/4 x 1-5/8	LSB060124A	L0D060118	LNS0B060125A	L0D060119
No. 4 to No. 12	UNF	3-1/2°	3/4 x 1-5/8	LNS0B090839B	L0D060118	LNS0B090912B	L0D060119
1/4 to 7/8	UNF	2-1/4°	3/4 x 1-5/8	LSB060126B	L0D060118	LNS0B060127B	L0D060119
1/8 to 7/32	WHIT	4-1/4°	3/4 x 1-5/8	LNS0B090842C	L0D060118	LNS0B090915C	L0D060119
1/4 to 7/8	WHIT	3-1/4°	3/4 x 1-5/8	LNS0B060124C	L0D060118	LNS0B060125C	L0D060119
1/4 to 7/8	BSF	2-1/2°	3/4 x 1-5/8	LNS0B060128D	L0D060118	LNS0B060129D	L0D060119
6 to 22 mm	METRIC COARSE	3-1/4°	3/4 x 1-5/8	LNS0B060124E	L0D060120	LNS0B060125E	LNS0D060121
6 to 22 mm	METRIC FINE	1-3/4°	3/4 x 1-5/8	LNS0B060130F	L0D060120	LNS0B060131F	LNS0D060121
1/8 to 1/2	PIPE	1-3/4°	3/4 x 1-5/8	LSB060130I	L0D060122	LNS0B060131I	LNS0D060123

K Chaser holder and chaser setting gage numbers that have the "L" prefix indicates that they are stocked items. Numbers that are preceded by the "LNS" prefix indicates that they are non-stock items.

Specifications

"F" & "A" Landmatics



1-1/4" 10F LANDMATIC - Standard Chaser HoldersK

RANGE	THREAD FORM	HELIX ANGLE	CHASER SIZE	RIGHT-HAND		LEFT-HAND	
				HOLDER PART NO.	GAGE PART NO.	HOLDER PART NO.	GAGE PART NO.
1/4 to 3/4	UNC	3-1/4°	15/16 x 2-1/8	LSB060420A	LOC060179	LNS0B060421A	LOC060180
13/16 to 1-1/4	UNC	2-1/2°	15/16 x 2-1/8	LSB060422A	LOC060179	LNS0B060423A	LOC060180
1/4 to 7/16	UNF	2-1/2°	15/16 x 2-1/8	LNS0B060424B	LOC060179	LNS0B060425B	LOC060180
1/2 to 3/4	UNF	1-3/4°	15/16 x 2-1/8	LSB060426B	LOC060179	LNS0B060427B	LOC060180
7/8 to 1-1/4	UNF	1-1/2°	15/16 x 2-1/8	LSB60428B	LOC060179	LNS0B060429B	LOC060180
1/4 to 3/4	WHIT	3-1/4°	15/16 x 2-1/8	LNS0B060420C	LOC060179	LNS0B060421C	LOC060180
13/16 to 1-1/4	WHIT	2-1/2°	15/16 x 2-1/8	LNS0B060422C	LOC060179	LNS0B060423C	LOC060180
1/4 to 3/4	BSF	2-1/2°	15/16 x 2-1/8	LNS0B060424D	LOC060179	LNS0B060425D	LOC060180
13/16 to 1-1/4	BSF	2°	15/16 x 2-1/8	LNS0B060430D	LOC060179	LNS0B060431D	LOC060180
6 to 18 mm	METRIC COARSE	3-1/4°	15/16 x 2-1/8	LNS0B060420E	LOC060181	LNS0B060421E	LNS0C060182
20 to 33 mm	METRIC COARSE	2-1/2°	15/16 x 2-1/8	LNS0B060422E	LOC060181	LNS0B060423E	LNS0C060182
6 to 18 mm	METRIC FINE	2°	15/16 x 2-1/8	LNS0B060435F	LOC060181	LNS0B060439F	LNS0C060182
20 to 33 mm	METRIC FINE	1-1/2°	15/16 x 2-1/8	LNS0B060428F	LOC060181	LNS0B060429F	LNS0C060182
1/8 to 3/8	TAPER PIPE	2°	15/16 x 2-1/8	LSB060432G	LOC060185	LNS0B060433G	LNS0C060186
1/8 to 1/2	TAPER PIPE	2°	15/16 x 2-1/8	LNS0B060432G1	LOC060185	-	-
1/2 to 3/4	TAPER PIPE	1-1/4°	15/16 x 2-1/8	LSB060434G	LOC060185	LNS0B060438G	LNS0C060186
1/8 to 3/8	STR. PIPE	2°	15/16 x 2-1/8	LNS0B060435H	LOC060183	LNS0B060439H	LNS0C060184
1/2 to 3/4	STR. PIPE	1-1/4°	15/16 x 2-1/8	LNS0B060436H	LOC060183	LNS0B060437H	LNS0C060184

2" 16F LANDMATIC - Standard Chaser HoldersK

RANGE	THREAD FORM	HELIX ANGLE	CHASER SIZE	RIGHT-HAND		LEFT-HAND	
				HOLDER PART NO.	GAGE PART NO.	HOLDER PART NO.	GAGE PART NO.
3/8 to 1-1/4	UNC	2-3/4°	15/16 x 2-1/8	LSX015534A	L015658	LNS105984A	L016105
1/4 to 1-1/4*	UNC	2-3/4°	15/16 x 2-1/8	LNS015534A*	L015658	-	-
1-3/8 to 2	UNC	2-1/4°	1-1/4 x 2-3/4	LSX015905A	L015659	LNS015970A	LNS016106
1/2 to 5/8	UNF	2°	15/16 x 2-1/8	LNS016903B	L015658	LNS019141B	L016105
3/4 to 1-1/4	UNF	1-1/2°	15/16 x 2-1/8	LSX016904B	L015658	LNS019226B	L016105
1-3/8 to 1-1/2	UNF	1-1/4°	15/16 x 2-1/8	LSX016905B	L016095	LNS019707B	LNS016096
3/8 to 1-1/4	WHIT	2-3/4°	15/16 x 2-1/8	LNS015534C	L015658	LNS015984C	L016105
1-3/8 to 2	WHIT	2-1/4°	1-1/4 x 2-3/4	LNS015905C	L015658	LNS015970C	L016106
1/2 to 5/8	BSF	2-1/4°	15/16 x 2-1/8	LNS017077D	L015658	LNS017078D	L016105
3/4 to 1-1/4	BSF	2°	15/16 x 2-1/8	LNS016903D	L015658	LNS019141D	L016105
1-3/8 to 2	BSF	1-3/4°	15/16 x 2-1/8	LNS019250D	L016095	LNS050704D	LNS016096
9 to 33 mm	METRIC COARSE	2-3/4°	15/16 x 2-1/8	LNS015534E	L016301	LNS015984E	LNS016302
36 to 52 mm	METRIC COARSE	2-1/4°	1-1/4 x 2-3/4	LNS015905E	L00015484	LNS015970E	LNS016304
9 to 14 mm	METRIC FINE	2°	15/16 x 2-1/8	LNS016903F	L016301	LNS019141F	LNS016302
16 to 33 mm	METRIC FINE	1-1/2°	15/16 x 2-1/8	LNS016904F	L016301	LNS019226F	LNS016302
36 to 52 mm	METRIC FINE	3/4°	15/16 x 2-1/8	LNS015535F	LNS017582	LNS015474F	LNS0C003762
1/8 to 3/4	TAPER PIPE	1-3/4°	15/16 x 2-1/8	LNS015579G1	L016099	-	-
1/2 to 3/4	TAPER PIPE	1-3/4°	15/16 x 2-1/8	LNS015579G	L016099	-	-
1/4 to 3/4	TAPER PIPE	1-3/4°	15/16 x 2-1/8	LSX015579G	L016099	LNS019728G	LNS019729
1 to 2	TAPER PIPE	1°	1-1/4 x 2-3/4	LSX015580G	L016100	LNS019102G	LNS019103
1/8 to 3/4	STR. PIPE	1-3/4°	15/16 x 2-1/8	LNS019737H1	L00007109	-	-
1/2 to 3/4	STR. PIPE	1-3/4°	15/16 x 2-1/8	LNS019737H2	L00007109	-	-
1/4 to 3/4	STR. PIPE	1-3/4°	15/16 x 2-1/8	LNS019737H	L00007109	LNS019760H	LNS0D007110
1 to 2	STR. PIPE	1°	15/16 x 2-1/8	LSB091657H	L00013394	LNS0C091826H	LNS0D069344

*For 16 JNB Die Head

K. Chaser holder and chaser setting gage numbers that have the "L" prefix indicates that they are stocked items. Numbers that are preceded by the "LNS" prefix indicates that they are non-stock items.



Specifications

"F" & "A" Landmatics



3" 24A LANDMATIC - Standard Chaser HoldersK

RANGE	THREAD FORM	HELIX ANGLE	CHASER SIZE	RIGHT-HAND		LEFT-HAND	
				HOLDER PART NO.	GAGE PART NO.	HOLDER PART NO.	GAGE PART NO.
3/4 to 1-1/2	UNC	2-1/2°	1-3/64 or 1-7/64 x 4	LNSOB049448A	LOC048412	LNSOB050707A	LNSOC050231
1-5/8 to 3	UNC	2°	1-1/2 x 4	LNSOB055782A	LOC048846	LNSOB055914A	LNSOC050218
3-1/4 to 1-1/4	UNF	1-1/2°	1-3/64 x 4	LNSOB053530B	LOC048412	LNSOB053534B	LNSOC050231
1-3/8 to 1-1/2	UNF	1-1/4°	1-3/64 x 4	LNSOB053531B	LOC048412	LNSOB053535B	LNSOC050231
3/4 to 1-1/2	WHIT	2-1/2°	1-3/64 or 1-7/64 x 4	LNSOB049448C	LOC048412	LNSOB050707C	LNSOC050231
1-5/8 to 3	WHIT	2°	1-1/2 x 4	LNSOB055782C	LOC048846	LNSOB055914C	LNSOC050218
3/4 to 1-1/2	BSF	1-3/4°	1-3/64 x 4	LNSOB053532D	LOC048412	-	-
1-5/8 to 2-3/4	BSF	1-1/4°	1-3/64 or 1-7/64 x 4	LNSOB53533D	LOC048846	-	-
18 to 39 mm	METRIC COARSE	2-1/2°	1-3/64 or 1-7/64 x 4	LNSOB049498E	LNSOC050236	LNSOB050707E	LNSOC050237
42 to 76 mm	METRIC COARSE	2°	1-1/2 x 4	LNSOB055782E	LNSOC050238	LNSOB055914E	LNSOC050239
1/2 to 3-1/4	TAPER PIPE	1-3/4°	1-3/64 x 4	LNSOB050705G	LNSOC058402	LNSOB050709G	LNSOC050224
1 to 2	TAPER PIPE	1°	1-1/4 x 4	LNSOB050706G	LNSOC058401	LNSOB050710G	LNSOC050232
2-1/2 to 3	TAPER PIPE	3/4°	1-7/8 x 4	LNSOB049447G	LNSOC048848	LNSOB050711G	LNSOC050233
1/2 to 3/4	STR Pipe	1-3/4°	1-3/64 x 4	LNSOB053532H	LNSOC052240	-	-
1 to 2	STR Pipe	1°	1-3/64 x 4	LNSOB054076H	LNSOC050062	-	-
2-1/2 to 3	STR Pipe	3/4°	1-3/64 x 4	LNSOB054077H	LNSOC051010	-	-

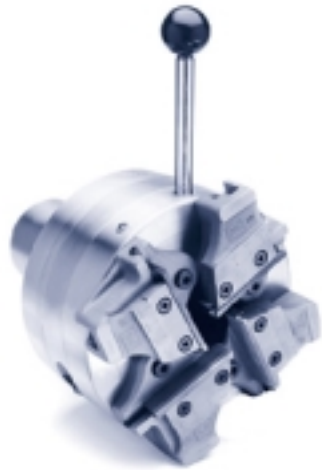
4" 32A LANDMATIC - Standard Chaser HoldersK

RANGE	THREAD FORM	HELIX ANGLE	CHASER SIZE	RIGHT-HAND		LEFT-HAND	
				HOLDER PART NO.	GAGE PART NO.	HOLDER PART NO.	GAGE PART NO.
1 to 1-1/2	UNC	2-1/2°	1-3/64 or 1-7/64 x 4	LNSOB049446A	LOC048413	LNSOB050802A	LNSOC050217
1-5/8 to 3	UNC	2°	1-1/2 x 4	LNSOB055780A	LOC050094	LNSOB055915A	LNSOC050219
3-1/4 to 4	UNC	1-1/4°	1-1/2 x 4	LNSOB055781A	LOC051022	LNSOB055916A	LNSOC051917
1 to 1-1/2	UNF	1-1/4°	1-3/64 x 4	LNSOB093197B	LOC048413	-	-
1 to 1-1/2	WHIT	2-1/2°	1-3/64 or 1-7/64 x 4	LNSOB049446C	LOC048413	LNSOB050802C	LNSOC050217
1-5/8 to 3	WHIT	2°	1-1/2 x 4	LNSOB055780C	LOC050094	LNSOB055915C	LNSOC050219
3-1/4 to 4	WHIT	1-3/4°	1-7/8 x 4	LNSOB050721C	LNSOC048851	LNSOB050804C	LNSOC050099
1 to 1-1/2	BSF	1-3/4°	1-3/64 x 4	LNSOB093199D	LOC048413	-	-
1-5/8 to 2-3/4	BSF	1-1/4°	1-3/64 or 1-7/64 x 4	LNSOB050795D	LOC050094	-	-
3 to 4	BSF	1-1/4°	1-1/2 x 4	LNSOB055781D	LOC051022	-	-
25 to 38 mm	METRIC COARSE	2-1/2°	1-3/64 or 1-7/64 x 4	LNSOB049446E	LNSOC050240	LNSOB050802E	LNSOC050241
42 to 76 mm	METRIC COARSE	2°	1-1/2 x 4	LNSOB055780E	LNSOC050242	LNSOB055915E	LNSOC050243
1/2 TO 3/4	TAPER PIPE	1-3/4°	1-3/64 X 4	LNSOB050789G	LNSOC048844	LNSOB050228G	LNSOC050224
1 TO 2	TAPER PIPE	1°	1-1/4 X 4	LNSOB050790G	LNSOC050095	LNSOB050806G	LNSOC050096
2-1/2 TO 4	TAPER PIPE	1/2°	1-7/8 X 4	LNSOB050791G	LNSOC048853	LNSOB050807G	LNSOC050225
1 to 2	STR. PIPE	1°	1-3/64 x 4	LNSOB052237H	LNSOC052243	-	-
2-1/2 to 4	STR. PIPE	3/4°	1-3/64 x 4	LNSOB052238H	LNSOC052244	-	-

K Chaser holder and chaser setting gage numbers that have the "L" prefix indicates that they are stocked items.
Numbers that are preceded by the "LNS" prefix indicates that they are non-stock items.

Specifications

"F" & "A" Landmatics



Range Inch – (mm)	Oversize Chaser Holders K		Maximum Thread Length** Inch – (mm)
	Chaser Size	Coarsest Pitch Thrds. Per In.-(mm)	
5/8" – 5F			
3/4 to 1 – (18 to 24 mm)	5/8 x 1-1/8	14 – (1.75 mm)	7/8 – (22 mm)
1 to 1-1/4 – (24 to 34 mm)	5/8 x 1-1/8	14 – (1.75 mm)	1-5/16 – (33 mm)
7/8" – 7F			
15/16 to 1-1/2 – (24 to 39 mm)	3/4 x 1-5/8	14 – (1.75 mm)	1-1/8 – (28 mm)
1-9/16 to 2 – (42 to 52 mm)	3/4 x 1-5/8	14 – (1.75 mm)	2" – (51 mm*)
1-1/4" – 10F			
1-5/16 to 2 – (33 to 52 mm)	15/16 x 2-1/8	12 – (2 mm)	1-3/16 or 2-7/8* – (30 or 73 mm*)
2-1/8 to 2-3/4 – (52 to 72 mm)	15/16 x 2-1/8	8 – (3 mm)	1-3/16 or 2-5/8* – (30 or 67 mm*)
2" – 16F			
2-1/8 to 3 – (54 to 76 mm)	15/16 x 2-1/8	8 – (3 mm)	1-5/16 or 2-1/8* (33 or 81 mm**†)
3-1/8 to 3-3/4 – (80 to 96 mm)	15/16 x 2-1/8	8 – (3 mm)	1-5/16 or 2-3/16* (33 or 56 mm**†)
3" – 24A			
3-1/8 to 4-1/4 – (78 to 108 mm)	1-3/64 or 1-7/64 x 4"	6 – (4 mm)	1-1/2 or 3-1/16* – (38 or 78 mm*)
	1-1/4 x 4 or 1-1/2 x 4	6 – (4 mm)	
4-3/8 to 5-1/2 – (112 to 140 mm)	1-3/64 or 1-7/64 x 4	6 – (4 mm)	1-7/8 (48 mm)
4" – 32A			
4-1/8 to 4-3/4* – (104 to 121 mm)	1-3/64 or 1-7/64 x 4	6 – (4 mm)	2-5/16 – (59 mm)
5 to 6-1/2 – (125 to 165 mm)	1-3/64 or 1-7/64 x 4 or 1-1/4 x 4	6 – (4 mm) 6 – (4 mm)	1-7/8 or 4-1/4* – (48 or 108 mm*)

*Requires Special Built-Up Holders.

**Important—Total thread length allowing 1/8" clearance.

†2-3/16" (56 mm) on 2-1/8" to 2-3/4" diameters and 1-15/16" (49 mm) on 2-7/8" and 3" diameters.

††Note: Oversized chaser holders are furnished against order to thread specific diameter and pitch combinations.

Often, more than one diameter and pitch combination can be threaded with a particular set of oversize chaser holders depending upon the helix angles involved.

Also, the thread must be within the coarsest pitch and maximum thread length limitations of the chaser holders.

Please refer complete information on diameter and pitch combinations for engineering review.

K Chaser holder and chaser setting gage numbers that have the "L" prefix indicates that they are stocked items.

Numbers that are preceded by the "LNS" prefix indicates that they are non-stock items.