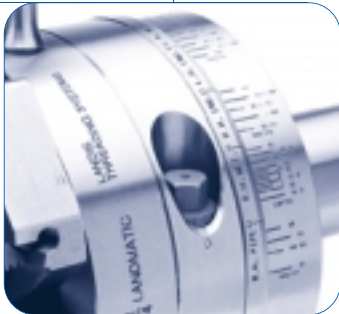
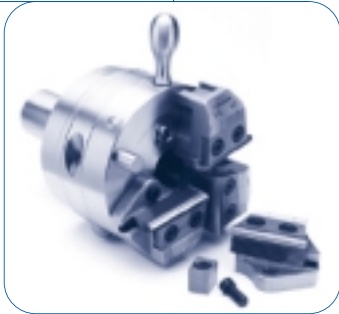


Landis Thread Cutting

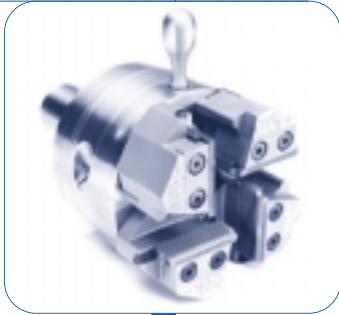
Die Heads



- Excellent for producing UN, BSF, Whitworth and Metric straight threads, NPT, NPTF, NPSM, BSTP, BSPP and API pipe threads.
- Unequaled for producing Acme and similar coarse pitch threads requiring heavy metal removal.
- Face mounted chaser holder sets provide wide range and oversize capacities. Special chaser holders are required to thread special diameter and pitch combinations, to cut Acme and similar threads or when close tolerances must be held.
- Heads are locked in the closed position by hardened pins engaged in hardened bushings.
- Self-opening action or yoke movement, depending upon model of die head used, withdraws pins from bushings to effect opening.
- When the pins withdraw from the bushings, the closing ring rotates snapping the chaser holders radially outward to clear the chasers from finished thread. Pins and bushings are replaceable when worn.
- A worm screw mechanism maintains size while allowing infinite adjustment for any diameter within the range of the head.
- Chasers are securely held in the cutting position by dovetailed clamps and backed-up with an abutting screw. They are easily set by loosening the clamps and turning the abutting screw with a hex wrench until the appropriate size graduation lines on the setting gage and chaser holder agree.
- Chasers are adjustable and can be nominally moved "ahead" or "back" of center changing tool clearance until best performance is obtained.
- Excluding the 5/8" 5DE Landmatic, all standard Landis heads can be used to thread right- or left-hand threads when equipped with suitable R.H. and L.H. holder sets.
- Self-opening F and A Landmatics can be fitted with an internal trip bar to allow uniform, repetitive thread length regardless of variation in workpiece length or gripping position.
- Can be equipped with hollow milling holders and cutters to turn, form, and face. See section on Hollow Milling.
- Only Landis Offers the Unique Cost Saving, Replaceable Chaser Holder System.
- Standard chaser holder sets available to thread UNC, UNF, BSF, Whitworth, Metric coarse and fine (of unlimited length), NPT, NPSM, BSTP, and BSPP taper and straight pipe threads within minimum to maximum O.D. capability of the head.
- Oversize holder sets, which can more than double the standard O.D. range of the head, allow large diameter, short length threading.
- Special holders, with helix angle dedicated to a specific diameter and pitch combination can be furnished for work requiring especially close tolerances.
- Face mounted holders are supported between pivoting trunnions and sliding blocks.

Landis Thread Cutting

Die Heads



- Clearance between back face of holder and front face of head provides float assuring proper tracking of all chasers in the cut. Holders are rotated radially outward or inward around the pivoting trunnion to establish threading size.
- Fastened by a single screw, holder change-over is quick and easy. Face mounting makes chasers readily accessible for setting and replacement and provides ample chip clearance.
- Clamped chasers extend a minimum distance out from holder and always are securely supported regardless of diameter being worked.
- The chaser seating surface of the holder is machined at an angle that presents the chaser to the work at a suitable helix angle. This provides numerous application advantages:
- (1) Allows Landis chasers to be used with suitable chaser holders to produce that pitch on any diameter within a specific die head's range, or with any die head that uses the same physical size chaser. Separate chaser sets are not required for each diameter and pitch combination.
- (2) Offers simple chaser setting and grinding. Precision fixture grinding is not required, chasers can be ground by hand and do not need to be ground in sets.
- (3) Can be interchanged to the extent that a new individual chaser or one from a set on hand can be substituted without replacing the whole set. Also allows chasers of varying length to be used within a set.
- Separate chaser holder sets are supplied to "jam cut" tapered pipe threads. Landmatic heads in 1/2", 5/8", and 7/8" sizes, and 1/2" and 13/16" Landex heads, use chaser holders with integral trunnion and use chasers with built in taper. Most other heads have separate holders and trunnions and use parallel chasers. The 12S, 20S, and 48S Receding Chaser die heads, which use tapered chasers, are exceptions.
- Heads can be equipped with hollow milling holders and cutters to turn, form, and face.
- See section on "Hollow Milling".