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The side tabs to the left when click will return you to the section index.

On the master index and section indexes the line items also contain links to the indicated pages.

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However, if you would like to take advantage of the built in interactive features you will need to download an app.



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Circular Chasers Section Index

Circular Chaser System

The Circular Chaser shape allows for the chaser to be ground through a full 270 degrees, which makes the circular style chaser by far, the system with the longest tool life over all other threading systems. The circular shape of the cutter permits minimal rubbing action immediately behind the cutting edge to ensure proper lead control eliminating excessive rubbing for smoother threads and longer chaser life. In addition, the chasers body mass and external mounting provides a faster dissipation of heat away from the work, frees chips for faster cutting speeds, and allows for the ability to cut up close to the shoulder of a part.

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DR Diehead



DRD Diehead



DBS Diehead



DRSA Coolant Induced Diehead



DRF Diehead



DSF Diehead



Circular Chasers Advantages

Shape:

The circular shape of the cutter permits only enough rubbing action immediately behind the cutting edge to ensure proper lead control. This eliminates excessive rubbing and assures smooth threads and longer chaser life. In addition, the chaser's body's mass and external mounting provides a faster dissipation of heat away from the work and frees chips for faster cutting speeds.

Sustained Accuracy:

The user is assured that with an RSVP diehead and one set of chasers, precision threads will cut immediately without trial and error method of switching chaser sets. The thread forms of the circular chaser are annular. The helix angle is ground into the face of the holding block at the factory and remains for the life of the tool.

Grinding:

The circular chaser can be re-ground through a full 270 degrees. Compare this basic advantage with others that have thin blades resulting in short chaser life. The circular tool is the simplest and easiest of all to grind with positive accurate results. The throat grind is built in the chaser form and does not change as the chaser is re-sharpened through the entire 270 degrees.

Replacement:

The preset nature of the chaser mounted on the block and precisely ground, assures quick installation. The removal and replacement is done in seconds, as compared to minutes in other styles without disturbing the setup. This is accomplished by a simple turn of a screw on some heads or lifting and turning of the reset handle on others.

Interchangeability:

All circular tools may be interchanged from rotating to non-rotating heads, size for size. The circular chaser's extreme versatility is demonstrated by its ability to machine a wide range of material by changing the grind to a precise, predetermined setting, bringing the cutting edge up to the proper position for the material used.

4-Chaser Dieheads:

Provide the economy of operation, high production and accuracy required making them a true asset to the industry. Their range of size and interchangeability point to one fact; no other threading tool possesses the versatility of RSVP Tooling dieheads. RSVP Tooling's exclusive modular shank dieheads provide the ability to choose the specific shank adapter suitable for your machine or for use in multiple machines. The shank adapter option also minimizes cost associated with shank replacement due to common wear and use.

5-Chaser Dieheads:

Have been developed to cover industry's increasing need to meet higher material specifications and improved gauging methods (such as tri-roll). Due to the rigid 5-point contact between tooling and workpiece, 5-chaser threading is the solution when applied to work pieces having flats, keyways, slots, drilled holes due to the elimination of perpendicular offset between chasers common with 4 chaser heads. Improved roundness is also obtained. The advantages gained and economics achieved when using RSVP tooling 5-chaser dieheads easily outweigh the slightly additional cost. RSVP Tooling's exclusive modular shank dieheads provide the ability to choose the specific shank adapter suitable for your machine or for use in multiple machines. The shank adapter option also minimizes cost associated with shank replacement due to common wear and use.

Circular Chasers

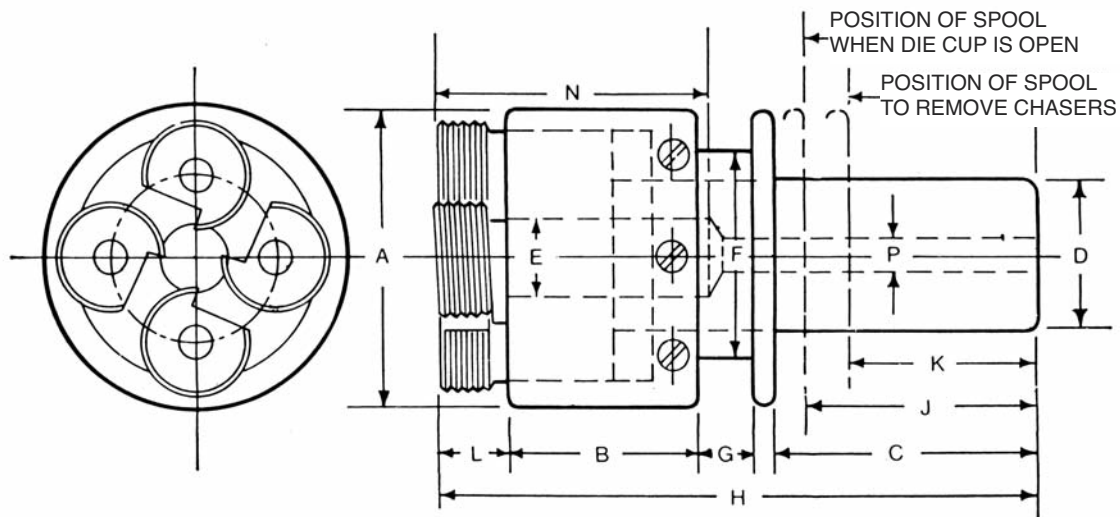
DR

Self Opening Revolving Dieheads

The style DR diehead is for use on machines having a revolving spindle. The head is extremely rugged and suitable for either right hand or left hand threads. Opens and closes by means of external yoke spool. Chasers are interchangeable with those of DS, DBS and DRD dieheads of the same capacity. RSVP Tooling's exclusive modular shank dieheads provide the ability to choose the specific shank adapter suitable for your machine or for use in multiple machines. The shank adapter option also minimizes cost associated with shank replacement due to common wear and use.



DR Diehead Overview



Dimension
Size of
Diehead

		A	B	C	D	E	F	G	+H	J	K	+L	N	*P
5/16	IN.	1 15/16	1 5/16	1 3/4	3/4	3/8	1 3/8	3/8	3 15/16	1 9/16	1 3/8	3/8	1 15/16	--
3/8	IN.	2 5/8	1 23/32	2 9/32	1	9/16	1 3/8	3/8	5 23/64	2 1/16	1 11/16	51/64	2 15/32	1/4
9/16	IN.	2 7/8	1 7/8	2 5/8	1 1/2	5/8	1 27/32	9/16	6 7/64	2 13/32	1 7/8	25/32	3	1/4
13/16	IN.	3 5/8	2 1/16	2 9/16	1 1/2	7/8	1 15/16	9/16	6 7/32	2 7/32	1 13/16	25/32	3 1/4	1/4
1	IN.	4 1/16	2 1/4	2 11/16	1 1/2	1 1/16	2	9/16	6 17/32	2 3/8	1 7/8	25/32	3 1/2	3/8
1 1/16	IN.	3 7/8	2 1/16	2 9/16	1 1/2	1 1/8	2	9/16	6 7/32	2 7/32	1 13/16	25/32	3 1/4	3/8
1 5/8	IN.	4 7/8	2 1/4	3 5/8	2 3/4	1 11/16	3 1/2	3/4	7 7/8	3 9/32	2 11/16	63/64	4 19/32	3/4

+ Dimensions Hand L increase as follows: Add 3/16 in. on die sizes 13/16 in. and 1 in. for 11 pitch or coarser.

Add 1/8 in. on die sizes 1 5/8 in. for 10 pitch or coarser.

Specify diameter of shank when ordering. Diameter "D" can be modified to special order. Always use correct operating yoke. * Shanks bored to larger "P" diameter if required.

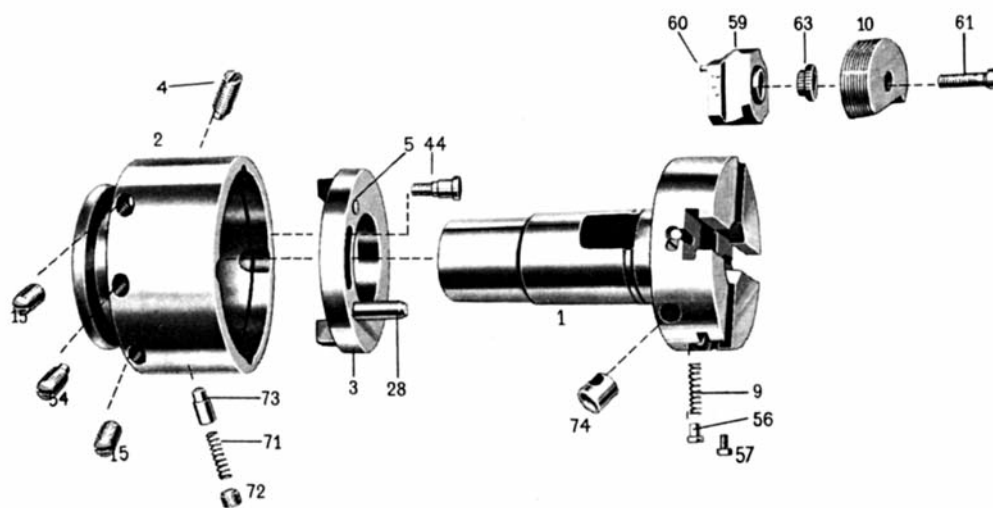


Self Opening for Revolving Spindles Component Parts Breakdown

DR

Diameter Capacity

Diehead Size	No. of Chasers	Straight Threads Inches	Shank Diameter	EDP No.
DR 5/16	4	.056-.312	.750	7001
DR 3/8	4	.188-.375	1.000	7002
DR 9/16	4	.250-.562	1.500	7003
DR 9/16	4	.250-.562	1.000	7004
DR 13/16	4	.250-.812	1.500	7005
DR 1	4	.375-1.000	1.500	7006
DR 1-1/16	4	.500-1.062	1.500	7007
DR 1-5/8	4	.500-1.625	2.750	7008



Part #	Description	Unit Reqd	5/16" EDP No.	3/8" EDP No.	9/16" EDP No.	13/16" EDP No.	1" EDP No.	1-1/16" EDP No.	1-5/8" EDP No.
DR-1A	Body assembly	1	2960	2957	2992	2911	2909	2916	2919
DR-2A	Cup assembly	1	2961	2958	2951	2912	2910	2917	2920
DR-3A	Adjusting plate assembly	1	2962	2959	2952	2913	2907	2918	2921
DR-4	Retaining screw	1	0	3024	3023	3028	3087	3074	3028
DR-5	Stop pin in DR-3A	1	3021	3025	3025	3029	3029	3029	3209
DR-9	Chaser spring	4	3218	3226	3233	3239	3244	3239	3244
DR-9HD	Chaser spring/HD	4	3195	3233	3227	3250	3240	3250	3240
DR-15	Adj Screw in DR-2A	2	3156	3026	3022	3030	3027	3030	3031
DR-28	Guide pin in DR-3A	1	3174	3171	3164	3099	3100	3099	3157
DR-44	Adjusting plate screw	1	3035	3036	3036	3037	3037	3037	3037
DR-54	Chaser locking screw	1	3020	3043	3042	3044	3163	3074	3044
DR-56	Spring plunger for DR-9	4	3073	3080	3080	3080	3046	3080	3046
DR-57	Spring plunger screw	4	3045	3045	3045	3045	3045	3045	3045
DR-60	Pin in block	4	3071	3247	3247	3247	3247	3247	3255
DR-61	Chaser screw		**	**	**	**	**	**	**
DR-63	Serrated brushing		**	**	**	**	**	**	**
DR-71	Spring for DR-73	1	3143	3197	3220	3228	3228	3228	3246
DR-72	Ret screw for DR-73	1	3147	3263	3152	3201	3201	3201	3201
DR-73	Die cup plunger	1	3159	3161	3161	3153	3153	3153	3153
DR-74	Float bushing assembly	1	2953	2953	2953	2908	2908	2908	2922

** See Pages 19 & 20

Circular Chasers

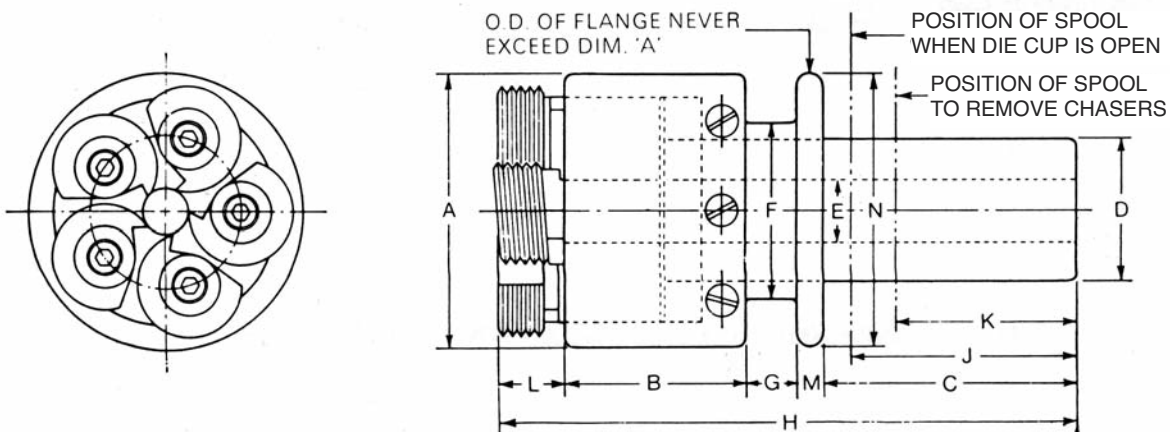
DRF

Self Opening Revolving Dieheads

The style DRF is a 5-chaser diehead for use on machines having a revolving spindle. There are only three main parts the body, cup and adjusting plate. Pitch diameter adjustment is easy and positive, all chasers are simultaneously actuated without disturbing the setup. The head is suitable for either right- or left hand threading. Opens and closes by means of external yoke spool. Chasers are interchangeable with those of DSF dieheads of same capacity. RSVP Tooling's exclusive modular shank dieheads provide the ability to choose the specific shank adapter suitable for your machine or for use in multiple machines. The shank adapter option also minimizes cost associated with shank replacement due to common wear and use.



DRF Diehead Overview



Dimension Size of Diehead

		A	B	C	D	E	F	G	+H	J	K	+L	M	N
13/16	IN.	3 5/8	2 1/16	2 9/16	1 1/2	7/8	2	9/16	6 3/16	2 5/16	1 13/16	25/32	1/4	3
1	IN.	4 1/16	2 1/4	2 11/16	1 1/2	1 1/16*	2	9/16	6 17/32	2 3/8	1 15/16	25/32	1/4	3
1 5/8	IN.	4 7/8	2 1/4	3 5/8	2 3/4	1 11/16*	3 1/2	3/4	7	3 9/32	2 11/16	25/32	1/4	4 5/8
2 3/8	IN.	6	2 9/16	4 3/8	3	2 7/16*	3 7/8	3/4	9 1/8	4	3 3/8	63/64	1/4	4 7/8

+diehead sizes 1 5/8 in for 11 pitch or coarser; add 1/8 in. on diehead sizes 2 3/8 in and larger for 10 pitch or coarser.

Dimension K is standard length of shank.

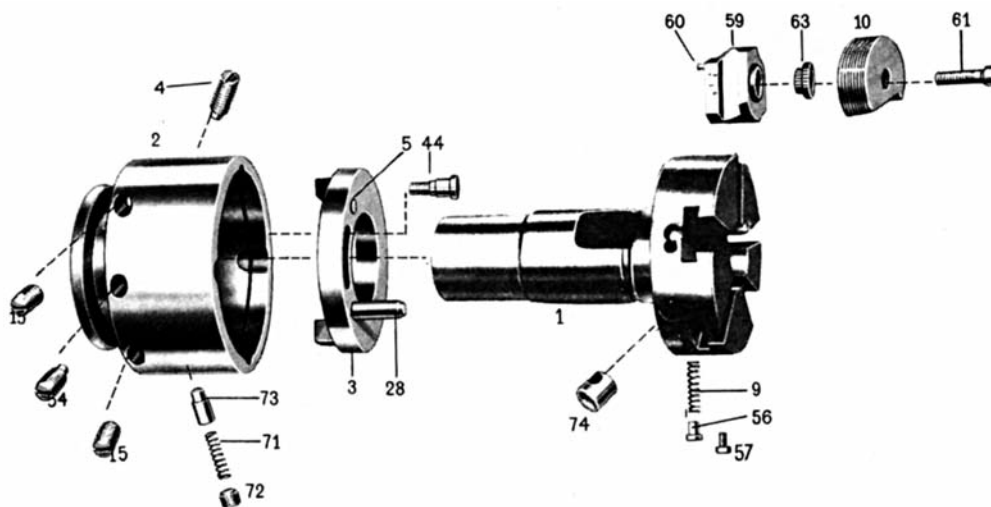
* Standards for diameter and depth of hole in body and diameter of hole in shank.

Self Opening for Revolving Spindles Component Parts Breakdown

DRF

Diameter Capacity

Diehead Size	No. of Chasers	Straight Threads Inches	Shank Diameter	EDP No.
DRF 13/16	5	.438 - .812	1.500	7022
DRF 1	5	.438 - 1.000	1.500	7023
DRF 1 5/8	5	.500 - 1.625	2.750	7024
DRF 2 3/8	5	1.000 - 2.375	3.000	7025



Part #	Description	13/16"		1"		1-5/8"		2-3/8"	
		Unit Req'd	EDP No.	Unit Req'd	EDP No.	Unit Req'd	EDP No.	Unit Req'd	EDP No.
DRF-1A	Body assembly	1	2914	1	2905	1	2923	1	2934
DRF-2A	Cup assembly	1	2915	1	2906	1	2924	1	2935
DRF-3A	Adjusting plate assembly	1	2913	1	2907	1	2921	1	2933
DRF-4	Retaining screw	1	3028	1	3087	1	3028	1	3032
DRF-5	Stop pin in DRF-3A	1	3029	1	3029	1	3029	1	3029
DRF-9	Chaser spring	5	3233	5	3233	5	3244	5	3244
DRF-9HD	Chaser spring HD	5	3227	5	3227	5	3240	5	3240
DRF-15	Adjusting screw DRF-2A	2	3030	2	3027	2	3031	2	3033
DRF-28	Guide pin DRF-3A	1	3099	1	3100	1	3157	1	3157
DRF-44	Adjusting plate screw	1	3037	1	3037	1	3037	1	3037
DRF-54	Chaser locking screw	1	3044	1	3163	1	3044	1	3032
DRF-54N	Chaser locking screw	1	3229	1	3234	1	3229	1	3241
DRF-56	Spring plunger/DRF-9	5	3080	5	3080	5	3046	5	3046
DRF-57	Spring plunger screw	5	3045	5	3045	5	3045	5	3045
DRF-60	Pin in block	5	3247	5	3247	5	3252	5	3255
DRF-61	Chaser screw	5	**	5	**	5	**	5	**
DRF-63	Serrated bushing	5	**	5	**	5	**	5	**
DRF-71	Spring/DRF-73	1	3228	1	3228	1	3246	1	3254
DRF-72	Retaining screw/DRF-73	1	3201	1	3201	1	3201	1	3201
DRF-73	Die cup retaining plunger	1	3153	1	3153	1	3153	1	3153
DRF-74A	Float bushing assembly	1	2908	1	2908	1	2922	1	2922

** See Pages 19 & 20

Circular Chasers

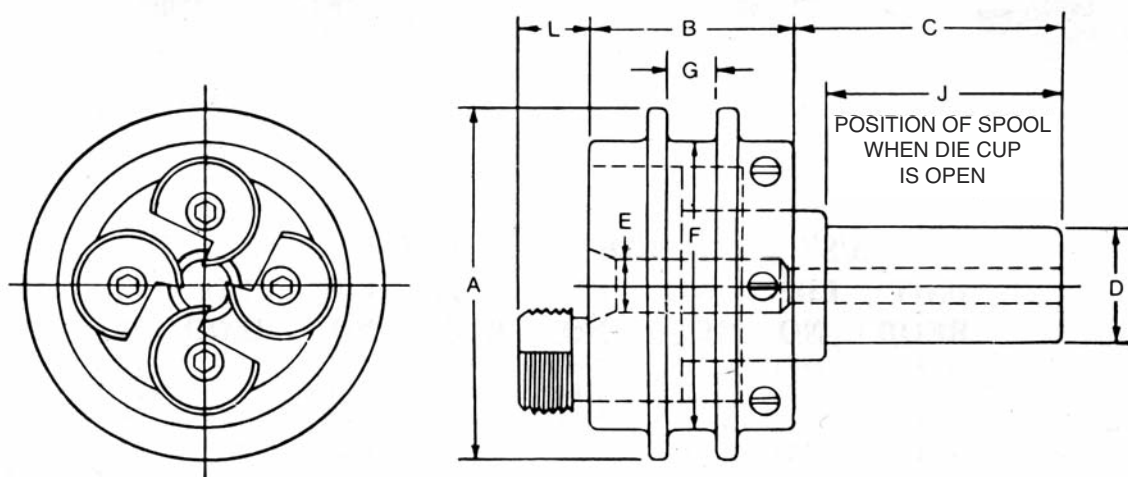
DRD

For Limited Length Clearance

For use on Davenport automatics, rotary transfer and other machines with limited clearance. This diehead meets the need for a short bodied, revolving tool that has all the features incorporated in RSVP dieheads. The simplicity of the heads three main parts assures longer life and economy of operation with sustained accuracy. RSVP Tooling's exclusive modular shank dieheads provide the ability to choose the specific shank adapter suitable for your machine or for use in multiple machines. The shank adapter option also minimizes cost associated with shank replacement due to common wear and use.



DRD Diehead Overview



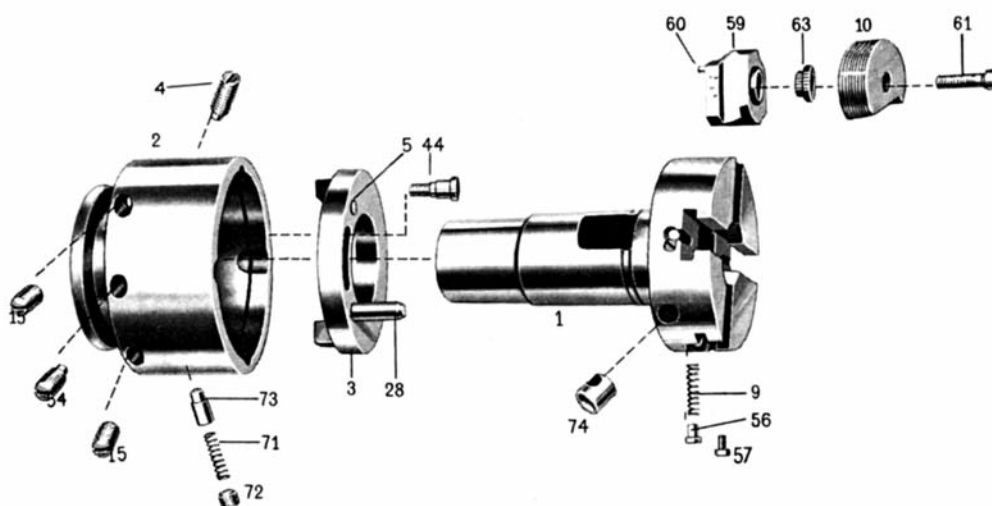
Dimension Size of Diehead	A	B	C	D	E	F	G	J	L
DRD 5/16	2 1/2	1 5/16	1 3/4	3/4	3/8	1 15/16	3/8	1 9/16	3/8
DRD 3/8	3 1/8	1 23/32	1 21/32	3/4	9/16	2 5/8	3/8	1 3/4	51/64
DRD 9/16	3 3/8	1 7/8	1 31/32	3/4	5/8	2 7/8	3/8	1 3/4	25/32

For Limited Length Clearance Component Parts Breakdown

DRD

Diameter Capacity

Diehead Size	No. of Chasers	Straight Threads Inches	Shank Diameter	EDP No.
DRD 5/16	4	.056-.312	.750	7009
DRD 3/8	4	.188-.375	.750	7010
DRD 9/16	4	.250-.562	.750	7011



*** (DRD 4 chaser diehead same as DR 4 chaser diehead) ***

Part #	Description	5/16"		3/8"		9/16"	
		Unit Req'd	EDP No.	Unit Req'd	EDP No.	Unit Req'd	EDP No.
DRD-1A	Body assembly	1	2996	1	2998	1	3000
DRD-2A	Cup assembly	1	2997	1	2999	1	3001
DRD-3A	Adjusting plate assembly	1	2962	1	2959	1	2952
DRD-5	Stop pin in DRD-3A	1	3021	1	3025	1	3025
DRD-9	Chaser spring	4	3218	4	3226	4	3233
DRD-9HD	Chaser spring HD	4	3195	4	3233	4	3227
DRD-15	Adj screw in DRD-2A	2	3019	2	3026	2	3022
DRD-28	Guide pin	1	3174	1	3171	1	3164
DRD-44	Adjusting plate screw	1	3037	1	3037	1	30377
DRD-54	Chaser locking screw	1	3146	1	3043	1	3042
DRD-56	Spring plunger for DRD-9	4	3073	4	3080	4	3080
DRD-57	Spring plunger screw	4	3045	4	3045	4	3045
DRD-60	Pin in block	4	3071	4	3247	4	3247
DRD-61	Chaser screw	4	**	4	**	4	**
DRD-63	Serrated bushing	4	**	4	**	4	**
DRD-71	Spring for DRD-73	2	3143	2	3197	2	3220
DRD-72	Retaining screw for DRD-73	2	3147	2	3263	2	3152
DRD-73	Die cup retaining plunger	2	3165	2	3161	2	3261
DRD-74A	Float bushing assembly	1	2953	1	2953	1	2953

** See Pages 19 & 20

Circular Chasers

DS

Self Opening Stationary Dieheads

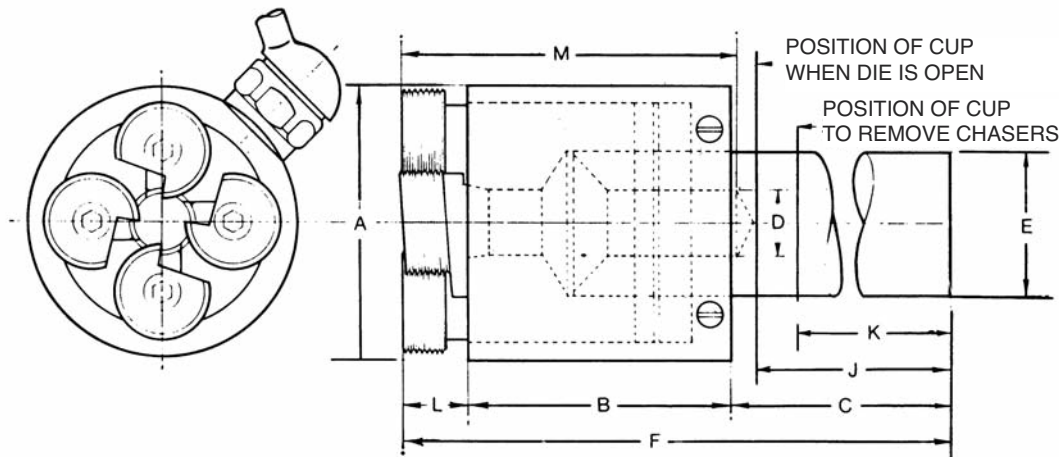
The style DS diehead is specially designed for use on turret and capstan lathes. It is quickly adaptable for straight, taper, right hand and left hand threads or hollow milling.

The head is specially suitable for close to shoulder threads as the chasers move back from the shoulder immediately when the diehead opens.

The head is equipped with a lateral compensating float. Chasers and chaser blocks may be released simply by pulling up the handle and sliding back the cup unit. Chasers are interchangeable with DR, DBS and DRD heads of the same capacity.



DS Diehead Overview



**Dimension
Size of
Diehead**

		A	B	C	D	+E	*F	J	K	*L	M
3/8	IN.	2 5/8	2 1/8	3 11/16	9/16	1	6 37/64	3 15/32	3	5 1/64	2 25/32
9/16	IN.	2 7/8	2 27/32	3 25/32	5/8	1 1/2	7 31/64	3 17/32	3	25/32	3 21/32
13/16	IN.	3 5/8	3 3/16	4 5/8	7/8	1 1/2	8 37/64	4 9/32	3 3/4	25/32	3 29/32
1	IN.	4 1/16	3 11/32	4 5/8	1 1/16	1 1/2	8 47/64	4 9/32	3 3/4	25/32	4 1/16
1 5/8	IN.	4 7/8	3 27/32	5 25/32	1 11/16	2 1/8	10 39/64	5 13/32	4 3/4	63/64	4 19/32

Dimensions F and L increase as follows: Add 3/16 in. on die sizes 13/16 in. and lin. For 11 pitch or coarser.

Add 1/8 in. on die sizes 1 5/8 in. for 10 pitch or coarser.

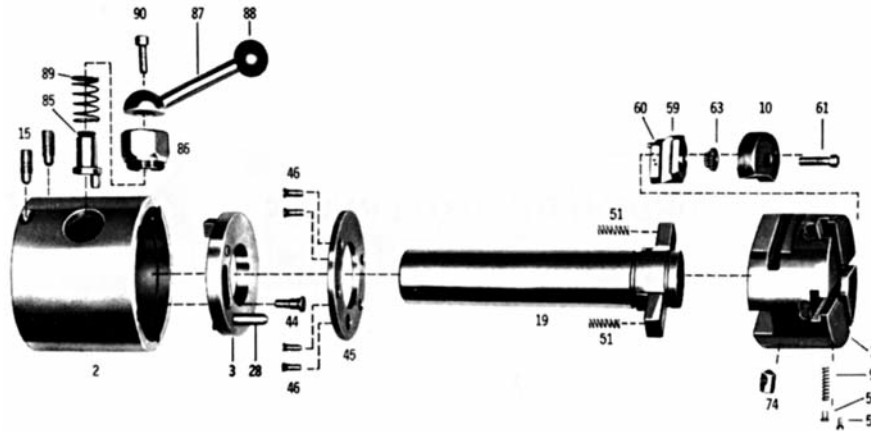
+ Dimension E can be modified to special order.

Self Opening for Stationary Spindles Component Parts Breakdown

DS

Diameter Capacity

Diehead Size	No. of Chasers	Straight Threads Inches	Shank Diameter	EDP No.
DS 3/8	4	.188-.375	1.000	7012
DS 9/16	4	.250-.562	1.500	7013
DS 13/16	4	.250-.812	1.500	7014
DS 1	4	.375-1.000	1.500	7015
DS 1-5/8	4	.500-1.625	1.500	7016



Part#	Description	3/8"		9/16"		13/16"		1"		1-5/8"	
		Unit Req'd	EDP No.	Unit Req'd	EDP No.	Unit Req'd	EDP No.	Unit Req'd	EDP No.	Unit Req'd	EDP No.
DS-1A	Body assembly	1	2983	1	2980	1	2963	1	2972	1	2925
DS-2A	Cup assembly	1	2984	1	2981	1	2964	1	2973	1	2926
DS-3A	Adjusting plate assembly	1	2985	1	2982	1	2965	1	2968	1	2927
DS-5	Stop pin	1	3025	1	3025	1	3029	1	3029	1	3029
DS-9	Chaser spring	4	3226	4	3233	4	3239	4	3244	4	3244
DS-9HD	Chaser spring HD	4	3233	4	3227	4	3250	4	3240	4	3240
DS-15	Adjusting screw in DS-2	2	3026	2	3022	2	3030	2	3027	2	3031
DS-19	Shank	1	3064	1	3053	1	3061	1	3057	1	3155
DS-28	Guide pin DS-3A	1	3173	1	3170	1	3102	1	3102	1	3172
DS-44	Adjusting plate screw	1	3036	1	3036	1	3037	1	3037	1	3037
DS-45	Spring plate	1	3065	1	3054	1	3062	1	3058	1	3067
DS-46	Spring plate screw	4	3038	4	3039	4	3039	4	3039	4	3040
DS-51	Shank pull back spring	2	3041	2	3232	2	3238	2	3238	2	3243
DS-56	Spring plunger for DS-9	4	3080	4	3080	4	3080	4	3046	4	3046
DS-57	Spring plunger screw	4	3045	4	3045	4	3045	4	3045	4	3045
DS-60	Pin in block	4	3247	4	3247	4	3247	4	3252	4	3255
DS-61	Chaser screw	4	**	4	**	4	**	4	**	4	**
DS-63	Serrated bushing	4	**	4	**	4	**	4	**	4	**
DS-74A	Float bushing assembly	1	2953	1	2953	1	2908	1	2908	1	2922
DS-85	Reset cam only	1	3169	1	3108	1	3110	1	3110	1	3112
DS-85A	Reset cam assembly	1	2901	1	2902	1	2903	1	2903	1	2904
DS-86	Cam holder	1	3107	1	3109	1	3111	1	3111	1	3113
DS-87	Reset handle	1	3168	1	3168	1	3166	1	3166	1	3149
DS-87S	Straight line closing lever	-	-	-	-	1	3017	1	3017	1	3016
DS-88	Handle ball	1	3096	1	3096	1	3096	1	3096	1	3097
DS-R9	Reset cam spring	1	3105	1	3104	1	3106	1	3106	1	3103
DS-90	Handle screw	1	3248	1	3248	1	3257	1	3257	1	3258

** See Pages 19 & 20



Circular Chasers

DSF

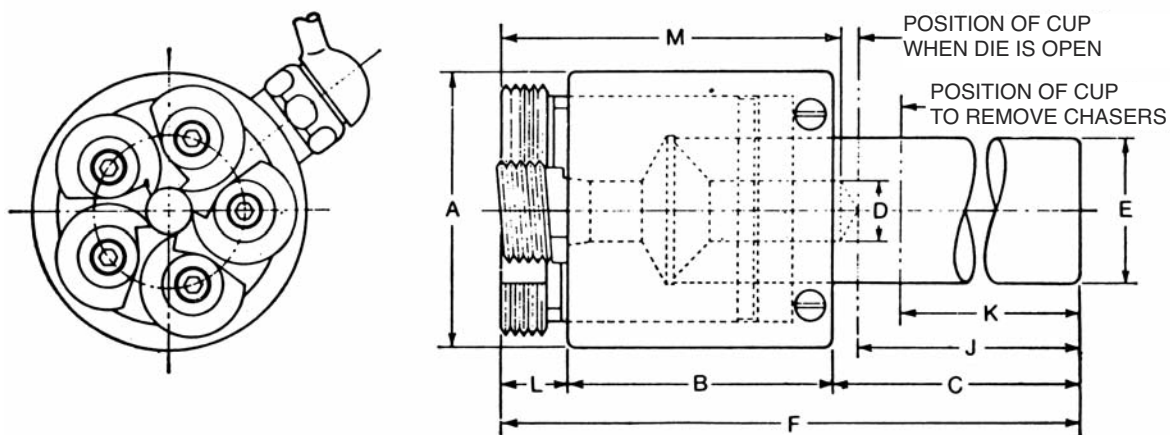
For Stationary Dieheads

The style DSF is a 5-chaser diehead specially designed for use on turret and capstan lathes. It is quickly adaptable for straight, taper, right hand and left hand threads. The head is specially suitable for close to shoulder threads as the chasers move back from the shoulder immediately the dieheads opens.

The head is equipped with a lateral compensating float. Chasers and chaser blocks may be released simply by pulling up the handle and sliding back the cup unit. Chasers are interchangeable with DRF heads of the same capacity.



DSF Diehead Overview



**Dimension
Size of
Diehead**

		A	B	C	D	E	*F	J	+K	▼L	M
1	IN	4 1/16	3 11/32	4 5/8	1 1/16	1 1/2	8 47/64	4 9/32	3 3/4	25/32	4 1/16
1 5/8	IN	4 7/8	3 27/32	5 25/32	1 11/16	2 1/8▼	10 39/64	5 13/32	4 3/4	25/32	4 19/32
2 3/8	IN	6	3 27/32	7 1/32	2 7/16	3 1/4	12 1/16	6 21/32	6	63/64	4 5/8

* Dimensions F and L increase as follows: Add 3/16 in. on diehead sizes 1 5/8 in. for 11 pitch or coarser; add 3/8 in. on diehead sizes 2 3/8 in. and larger for 10 pitch or coarser.

+ Dimension K is standard length of shank.

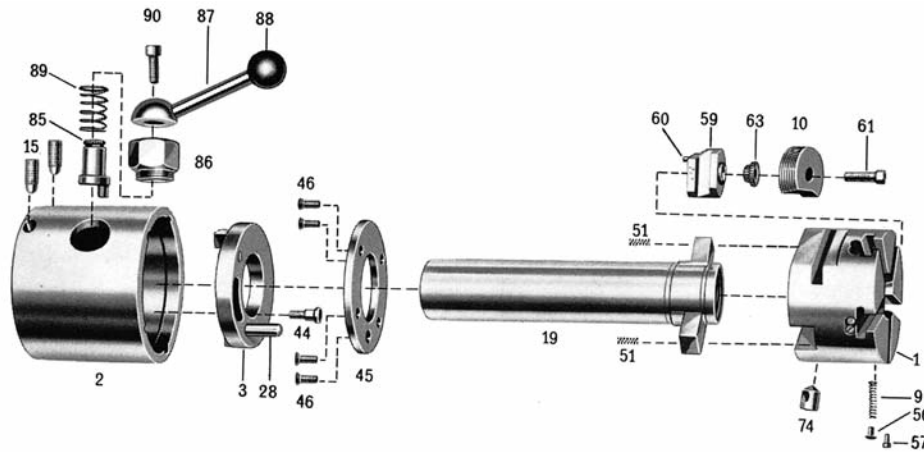
▼ Also supplied with 1 1/2 in. shank is standard

Self Opening for Stationary Spindles Component Parts Breakdown

DSF

Diameter Capacity

Diehead Size	No. of Chasers	Straight Threads Inches	Shank Diameter	EDP No.
DSF 1	5	.438-1.000	1.500	7026
DSF 1 5/8	5	.500-1.625	1.500	7027
DSF 2 3/8	5	1.00-2.375	3.250	7028



Part#	Description	1"		1-5/8"		2-3/8"	
		Unit Reqd	EDP No.	Unit Reqd	EDP No.	Unit Reqd	EDP No.
DSF-1A	Body assembly	1	2966	1	2942	1	2948
DSF-2A	Cup assembly	1	2967	1	2943	1	2949
DSF-3A	Adjusting plate assembly	1	2968	1	2927	1	2946
DSF-5	Stop pin	1	3029	1	3029	1	3029
DSF-9	Chaser spring	5	3233	5	3244	5	3244
DSF-9HD	Chaser spring heavy duty	5	3277	5	3240	5	3240
DSF-15	Adjusting screw in DSF-2A	2	3027	2	3031	2	3033
DSF-19	Shank	1	3057	1	3155	1	3059
DSF-19	Shank (2 3/4 Diameter)	-	-	1	3066	-	-
DSF-28	Guide pin	1	3102	1	3172	1	3172
DSF-44	Adjusting plate screw	1	3037	1	3037	1	30377
DSF-45	Spring plate	1	3058	1	3067	1	3060
DSF-46	Spring plate screw	4	3039	4	3040	4	3040
DSF-51	Shank pull back spring	2	3238	2	3243	2	3249
DSF-56	Spring plunger for DSF-9	5	3080	5	3046	5	3046
DSF-57	Spring plunger screw	5	3045	5	3045	5	3045
DSF-60	Pin in block	5	3247	5	3252	5	3255
DSF-61	Chaser screw	5	**	5	**	5	**
DSF-63	Serrated bushing	5	**	5	**	5	**
DSF-74A	Float bushing assembly	1	2908	1	2922	1	2922
DSF-85	Reset cam only	1	3110	1	3112	1	3112
DSF-85A	Reset cam assembly	1	2903	1	2904	1	2947
DSF-86	Cam holder	1	3111	1	3113	1	3113
DSF-87	Reset handle	1	3166	1	3149	1	3114
DSF-87S	Straight line spring lever	1	3017	1	3016	1	3016
DSF-88	Handle ball	1	3096	1	3097	1	3097
DSF-89	Reset cam spring	1	3106	1	3103	1	3103
DSF-90	Handle screw	1	3257	1	3258	1	3258

** See Pages 19 & 20



Circular Chasers

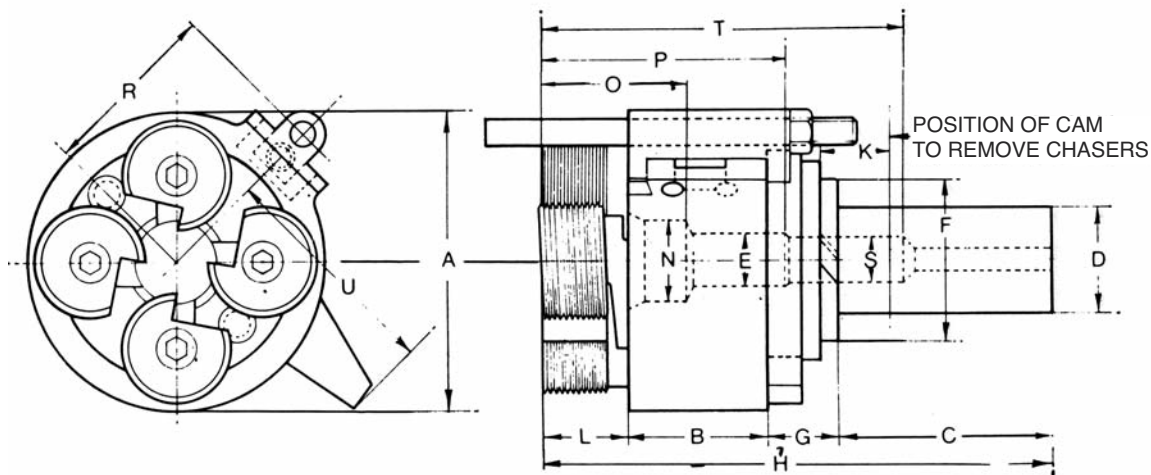
DBS

For Single Spindle Automatic Screw Machines

The style DBS diehead has been specially developed for use with single-spindle automatic screw machines. The outstanding success of this head is due to its rugged simplicity and its power to maintain precision under the most severe production conditions. Two adjusting screws provide simultaneous diameter adjustment, eliminating individual chaser adjustment. Close to shoulder threading is a feature of design. Right hand and left hand threads cut with the same set of chasers, different chaser blocks only being necessary.



DBS Diehead Overview



Dimension Size of Diehead		A	B	C	D	E	F	G	H	K
1/4	IN.	1 5/8	1 7/8	1 3/4*	5/8	-	7/8	15/32	3 15/32*	13/32
3/8	IN.	2 5/8	1 13/32	1 13/16	3/4	13/32	1 3/8	3/8	4 41/64	19/32
9/16	IN.	2 7/8	1 13/32	2 1/16	1	19/32	1 9/16	2 1/32	4 29/32	11/16

Chart Continued

Dimension Size of Diehead		L	N	O	P	R	S	T	U
1/4	IN.	3/8	27/64	21/32	-	1 7/64	9/32	2 5/32	1 13/32
3/8	IN.	25/32	11/16	1 23/64	1 27/64	1 43/64	17/64	3 19/64	2 1/16
9/16	IN.	25/32	25/32	1 23/64	2 23/64	1 3/4	33/64	3 31/64	2 5/32

* A short shank can be supplied on the 1/4 DBS diehead in which case dimensions are c 1 in.

H 223/32 in. and T 11/2 in.



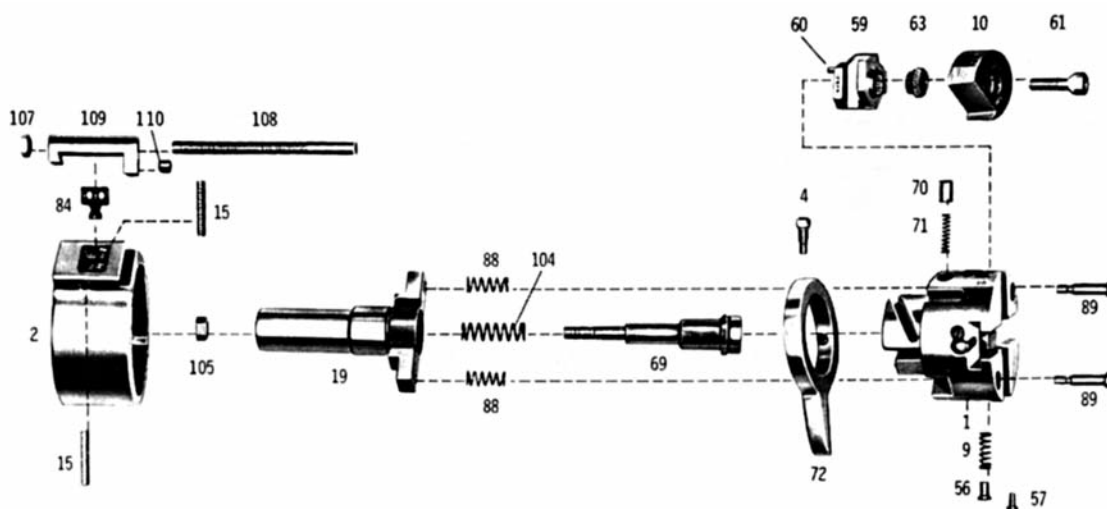
Circular Chasers

For Single Spindle Automatic Screw Machines Component Parts Breakdown

DBS

Diameter Capacity

Diehead Size	No. of Chasers	Straight Threads Inches	Shank Diameter	EDP No.
DBS 3/8	4	.188-.375	.750	7017
DBS 9/16	4	.250-.562	1.000	7018



Part #	Description	3/8"		9/16"	
		Unit Reqd	EDP No.	Unit Reqd	EDP No.
DBS-1A	Body assembly	1	2993	1	3002
DBS-2A	Cup assembly	1	2994	1	3003
DBS-4	Retaining screw	1	3130	1	3130
DBS-9	Chaser spring	4	3226	4	3233
DBS-9HD	Chaser spring HD	4	3233	4	3227
DBS-15	Adjusting screw	2	3242	2	3242
DBS-19	Shank	1	3128	1	3131
DBS-56	Spring plunger/DBS-9	4	3080	4	3080
DBS-57	Spring plunger screw	4	3045	4	3045
DBS-60	Pin in block	4	3247	4	3247
DBS-61	Chaser screw	4	**	4	**
DBS-63	Serrated bushing	4	**	4	**
DBS-69	Shank bushing	1	3129	1	3132
DBS-70	Cup retaining plunger	1	3141	1	3141
DBS-71	Spring/retaining plunger	1	3142	1	3142
DBS-72A	Resetting ring assembly	1	2995	1	3004
DBS-84	Adjusting block	1	3148	1	3148
DBS-87	Resetting ring pin	2	3256	2	3133
DBS-88	Compensating float spring	2	3081	2	3140
DBS-89	Screw for float spring	2	3138	2	3137
DBS-104	Shank tension spring	1	3139	1	3134
DBS-105	Shank nut	1	3176	1	3177
DBS-107	Lock nut for trip rod	1	3253	1	3253
DBS-108	Trip rod	1	3119	1	3119
DBS-109	Stop bracket	1	3160	1	3160
DBS-110	Lock screw/stop bracket	1	3235	1	3225

** See Pages 19 & 20

Circular Chasers

RSVP Tooling, Inc.



Circular Chasers

DRSA

Solid Adjustable (Non-Opening) Circular Chaser Diehead

*** THREADING DONE IN ONE PASS ***

Replaces acorn and insert style non-opening, solid adjustable heads

The introduction of this extra light thread cutting diehead is for use on machines with reversing spindles, ie. rotary transfer and CNC machining centers used in the same fashion as a rigid tapping system.

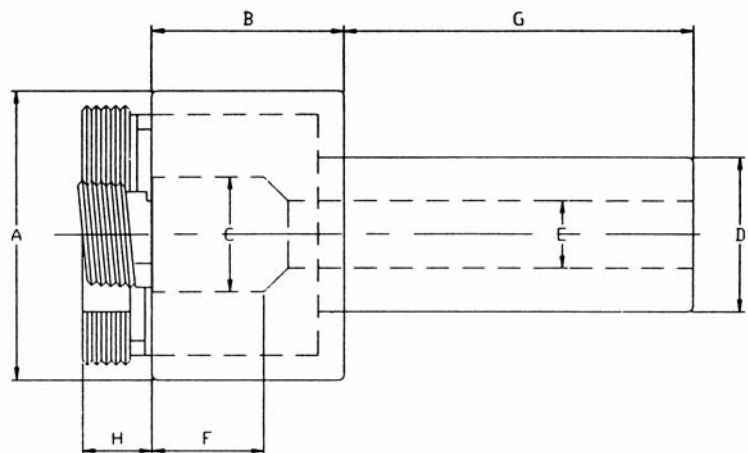
Because RSVP dieheads feature externally mounted chasers, threading right up to shoulders is possible, while access for coolant is excellent.

Also, with the units presetting system, chasers can be removed for grinding over 100 times and then set to the correct center height and rake angle to suit a wide range of materials. Threads from 1/4" up to 1-5/8". RSVP Tooling's exclusive modular shank dieheads provide the ability to choose the specific shank adapter suitable for your machine or for use in multiple machines. The shank adapter option also minimizes cost associated with shank replacement due to common wear and use.

DRSA Diehead Overview



DRSA Coolant Induced Diehead



Dimensions

4 Chaser DRSA

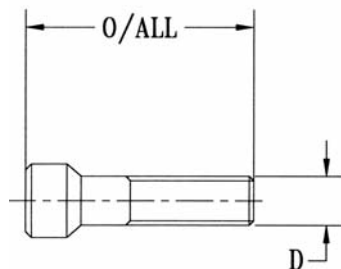
Head Size	EDP#	A	B	C	D	E	F	G	H	Thread Range
9/16	9927	2.875	1.470	0.625	1.000	0.500	0.750	1.500	0.781	1/4" - 9/16"
13/16	9928	3.625	1.625	0.875	1.500	0.500	1.000	2.000	0.781	5/16" - 13/16"
1	9929	4.062	1.810	1.062	1.500	0.500	1.000	2.000	0.781	3/8" - 1"

5 Chaser DRFSA

Head Size	EDP#	A	B	C	D	E	F	G	H	Thread Range
13/16	9930	3.625	1.625	0.875	1.500	0.500	1.000	2.000	0.781	7/16" - 13/16"
1	9931	4.062	1.810	1.062	1.500	0.500	1.000	2.000	0.781	7-16" - 1"

Circular Chasers

DR6I - Chaser Screw Component Parts



Diehead 4 Per Set	Chaser Length	Screw Diameter	OAL	EDP# Left Hand	EDP# Right Hand
1/4 & 5/16	1/4 & 3/8	6-32	5/8	3196	3219
	1/4	8-32	1/2	3186	3211
3/8 & 9/16	9/16	12-28	15/16	3185	3210
	3/4	12-28	1 7/32	3189	3214
13/16 & 1" & 1 1/16	9/16	1/4-28	1 5/32	3184	3209
	3/4	1/4-28	1 3/8	3187	3212
	7/8 & 1"	1/4-28	1 9/16	3181	3206
1 5/8 & 2"	5/8	3/8-24	1 3/16	3178	3202
	7/8	3/8-24	1 7/16	3179	3203
	1 1/8	3/8-24	1 11/16	3188	3213
1 5/8 & 2" Heavy Duty	5/8	5/16-24	1 7/16	3190	3215
	7/8	5/16-24	1 11/16	3191	3216
	1 1/8	5/16-24	1 15/16	3192	3204
2 3/8	3/4	3/8-24	1 7/16	3179	3203
	1"	3/8-24	1 11/16	3188	3213
	1 1/8 & 1 1/4	3/8-24	1 15/16	3180	3205

Diehead 5 Per Set	Chaser length	Screw Diameter	OAL	EDP# Left Hand	EDP# Right Hand
13/16 & 1"	9-16	12-28	15/16	3185	3210
	3/4	12-28	1 7/32	3189	3214
1 5/8	9/16	1/4-28	1 5/32	3184	3209
	3/4	1/4-28	1 3/8	3187	3212
	7/8 & 1"	1/4-28	1 9/16	3181	3206
	1 1/8	1/4-28	1 25/32	3183	3208
2 3/8	5/8	3/8-24	1 3/16	3178	3202
	7/8	3/8-24	1 7/16	3179	3203
	1 1/8	3/8-24	1 11/16	3188	3213

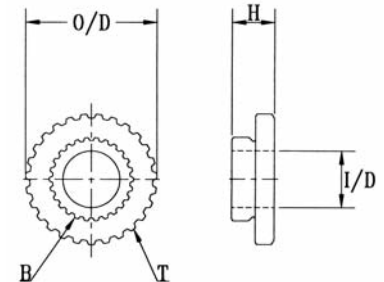
Circular Chasers

Component Parts

Serrated Bushing Chart - DR63

4 Chaser Style

EDP No.	Diehead	Number of Teeth		OD	ID	H
		(Bottom) B	(Top) T			
3145	1/4"-5/16"	30	29	1/4"	9/64"	5/32"
3055	3/8"-9/16"	20	19	1/2"	7/32"	9/32"
3069	13/16" - 1"-1 1/16"	23	22	5/8"	1/4"	9/32"
3056	1 5/8"-2"	27	26	7/8"	3/8"	9/32"
3098	1 5/8"-2" HD	25	26	3/4"	5/16"	9/32"
3072	2 3/8"	27	26	15/16"	3/8"	7/16"



5 Chaser Style

EDP No.	Diehead	Number of Teeth		OD	ID	H
		(Bottom) B	(Top) T			
3055	13/16" - 1"-1 1/16"	20	19	1/2"	7/32"	9/32"
3069	1 5/8"	23	22	5/8"	1/4"	9/32"
3056	2 3/8"	27	26	7/8"	3/8"	9/32"

*Made from HSS- Not powdered metal

Special Services-Price Upon Request

NYLOX Screws - Replace conventional screws with NYLOX screws to prevent dieheads from prematurely opening.

Black Oxidizing Diehead Bodies - Increase tool life, combat oxidation from setting in during machine's idle time.

Keeper Key Slots - Prevent tool pull out; let us modify your diehead shanks.

Single Replacement Circular Chasers and Blocks - There may come a time when you need just one chaser or block to complete a set. Let us know, we can complete that set and have it running again.

Special Diehead Shanks - The shanks can be manufactured to any configuration to suit your needs.

Premium Grade Materials - S-390 and ASD23 grade materials will increase your cutting and chaser tool life at a fraction of the cost.

Refurbish and Repair Dieheads - All repairs done by our factory trained personnel. If the repair estimate is too costly, or beyond repair, you may trade in your old diehead for a credit on the purchase of a new diehead.

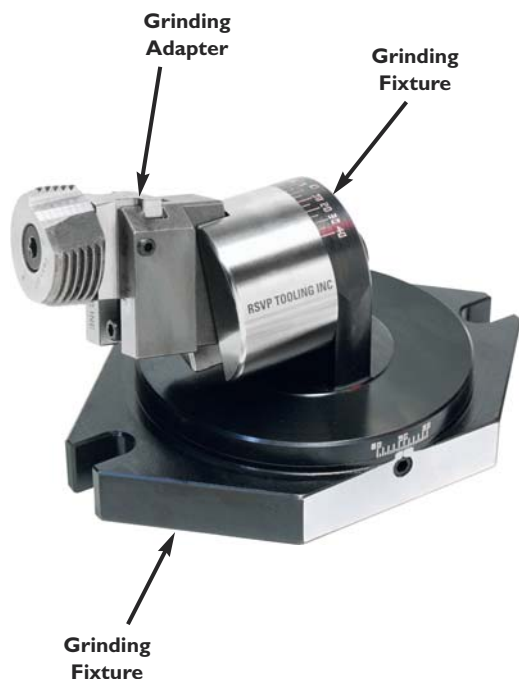
Tin Coating & Black Oxide Chasers for longer tool life

Re-Grind Diehead Cup Cams



Circular Chasers

Circular Chaser Accessories



Grinding Equipment Accessories

The grinding fixture holds the grinding adapter complete with chaser and block assembly for grinding. The Base is provided with bolt slots and removable tenons for fixture direct to the grinding machine table or to a magnetic chuck. The body swivels to give the required face angle and the adapter holder rotates to give the required hook angle. One size of grinding fixture is common to all.

EDP Number FI

Grinding Adapter

The adapter is used in conjunction with the grinding fixture and holds the chaser at a 12 degree angle for grinding the chip clearance angle.

EDP Number

- A1** 1/4" and 5/16" in dieheads
- A2** 3/8" dieheads
- A3** 9/16" (4 chaser diehead) and 1" (5 chaser diehead)
- A4** 13/16", 1", 1-1/16" (4 chaser diehead) and 1-5/8" (5 chaser diehead)
- A5** 1-5/8" and 2" (4 chaser diehead) and 2-3/8" DRF (5 chaser diehead)



Micrometer Setting Gauge

This gauge is designed so that the chaser block (with the chaser mounted on it) can be checked both before and after grinding. The same gauge is used for checking both right hand and left hand chasers as well as hollow milling cutters within the size range of the gauge.

EDP Number

- M1** 1/4" and 5/16" dieheads
- M2** 3/8" dieheads
- M3** 9/16" (4 chaser diehead) and 1" (5 chaser diehead)
- M4** 13/16", 1", 1-1/16" (4 chaser diehead) and 1-5/8" (5 chaser diehead)
- M5** 1-5/8" and 2" (4 chaser diehead) and 2-3/8" DRF (5 chaser diehead)



Pull Back Wrenches (Brass)

EDP Number

- P1** 1/4" and 5/16" dieheads
- P2** 3/8" dieheads
- P3** 9/16" (4 chaser diehead) and 1" (5 chaser head)
- P4** 13/16", 1", 1-1/16" (4 chaser diehead) and 1-5/8" in (5 chaser diehead)
- P5** 1-5/8" and 2" (4 chaser diehead) and 2-3/8" (5 chaser diehead)

Circular Chasers

Circular Chasers & Blocks (Standard 4 Per Set)

5/16" 4 Per Set Dieheads			UN
Circular Chasers		T.P.I./Form	Blocks EDP#
25 Chamfer EDP#	45 Chamfer EDP#		
4001	5001	2-56/UNC	6001
4002	5002	2-64/UNF	6002
4003	5003	3-48/UNC	6003
4004	5004	3-56/UNF	6004
4005	5005	4-40/UNC	6005
4006	5006	4-48/UNF	6006
4007	5007	5-40/UNC	6007
4008	5008	5-44/UNF	6008
4009	5009	6-32/UNC	6009
4010	5010	6-40/UNF	6010
4011	5011	8-32/UNC	6011
4012	5012	8-36/UNF	6012
4013	5013	10-24/UNC	6013
4014	5014	10-32/UNF	6014
4015	5015	12-24/UNC	6015
4016	5016	12-28/UNF	6016
4017	5017	1/4-20/UNC	6017
4018	5018	1/4-28/UNF	6018
4019	5019	5/16-18/UNC	6019
4020	5020	5/16-24/UNF	6020

Pipe

Circular Chasers		Dia./Form	Blocks EDP#
25 Chamfer EDP#	45 Chamfer EDP#		
4021	5021	1/8 NPT/ANPT	6021
4022	5022	1/8 NPTF	6022

9/16" 4 Per Set Dieheads			UN
Circular Chasers		T.P.I./Form	Blocks EDP#
25 Chamfer EDP#	45 Chamfer EDP#		
4037	5037	1/4-20/UNC	6037
4038	5038	1/4-28/UNF	6038
4039	5039	5/16-18/UNC	6039
4040	5040	5/16-24/UNF	6040
4041	5041	3/8-16/UNC	6041
4042	5042	3/8-24/UNF	6042
4043	5043	7/16-14/UNC	6043
4044	5044	7/16-20/UNF	6044
4045	5045	1/2-13/UNC	6045
4046	5046	1/2-20/UNF	6046
4047	5047	9/16-12/UNC	6047
4048	5048	9/16-18/UNF	6048

Pipe

Circular Chasers		Dia./Form	Blocks EDP#
25 Chamfer EDP#	45 Chamfer EDP#		
4049	5049	1/8-NPT/ANPT	6049
4050	5050	1/8-NPTF	6050
4051	5051	1/4-NPT/ANPT	6051
4052	5052	1/4-NPTF	6052
4053	5053	3/8-NPTF/ANPT	6053
4054	5054	3/8-NPTF	6054
4055	5055	1/2-NPT/ANPT	6055
4056	5056	1/2-NPTF	6056

3/8" 4 Per Set Dieheads			UN
Circular Chasers		T.P.I./Form	Blocks EDP#
25 Chamfer EDP#	45 Chamfer EDP#		
4023	5023	8-32/UNC	6023
4024	5024	8-36/UNF	6024
4025	5025	10-24/UNC	6025
4026	5026	10-32/UNF	6026
4027	5027	12-24/UNC	6027
4028	5028	12-28/UNF	6028
4029	5029	1/4-20/UNC	6029
4030	5030	1/4-28/UNF	6030
4031	5031	5/16-18/UNC	6031
4032	5032	5/16-24/UNF	6032
4033	5033	3/8-16/UNC	6033
4034	5034	3/8-24/UNF	6034

Pipe

Circular Chasers		Dia./Form	Blocks EDP#
25 Chamfer EDP#	45 Chamfer EDP#		
4035	5035	1/8 NPT/ANPT	6035
4036	5036	1/8 NPTF	6036

13/16" 4 Per Set Dieheads			UN
Circular Chasers		T.P.I./Form	Blocks EDP#
25 Chamfer EDP#	45 Chamfer EDP#		
4057	5057	1/4-20/UNC	6057
4058	5058	1/4-28/UNF	6058
4059	5059	5/16-18/UNC	6059
4060	5060	5/16-24/UNF	6060
4061	5061	3/8-16/UNC	6061
4062	5062	3/8-24/UNF	6062
4063	5063	7/16-14/UNC	6063
4064	5064	7/16-20/UNF	6064
4065	5065	1/2-13/UNC	6065
4066	5066	1/2-20/UNF	6066
4067	5067	9/16-12/UNC	6067
4068	5068	9/16-18/UNF	6068
4069	5069	5/8-11/UNC	6069
4070	5070	5/8-18/UNF	6070
4071	5071	3/4-10/UNC	6071
4072	5072	3/4-16/UNF	6072

Pipe

Circular Chasers		Dia./Form	Blocks EDP#
25 Chamfer EDP#	45 Chamfer EDP#		
4073	5073	1/8 NPT/ANPT	6073
4074	5074	1/8 NPTF	6074
4075	5075	1/4 NPT/ANPT	6075
4076	5076	1/4 NPTF	6076
4077	5077	3/8 NPT/ANPT	6077
4078	5078	3/8 NPTF	6078
4079	5079	1/2 NPT/ANPT	6079
4080	5080	1/2 NPTF	6080

Continued On The Next Page



Circular Chasers

1" 4 Per Set Dieheads		UN	
Circular Chasers		T.P.I./Form	Blocks EDP#
25 Chamfer EDP#	45 Chamfer EDP#		
4081	5081	7/16-14/UNC	6081
4082	5082	7/16-20/UNF	6082
4083	5083	1/2-13/UNC	6083
4084	5084	1/2-20/UNF	6084
4085	5085	9/16-12/UNC	6085
4086	5086	9/16-18/UNF	6086
4087	5087	5/8-11/UNC	6087
4088	5088	5/8-18/UNF	6088
4089	5089	3/4-10/UNC	6089
4090	5090	3/4-16/UNF	6090
4091	5091	7/8-9/UNC	6091
4092	5092	7/8-14/UNF	6092
4093	5093	1-8/UNC	6093
4094	5094	1-12/UNF	6094

Pipe

Circular Chasers		Dia./Form	Blocks EDP#
25 Chamfer EDP#	45 Chamfer EDP#		
4095	5095	1/8 NPT/ANPT	6095
4096	5096	1/8 NPTF	6096
4097	5097	1/4 NPT/ANPT	6097
4098	5098	1/4 NPTF	6098
4099	5099	3/8 NPT/ANPT	6099
4100	5100	3/8 NPTF	6100
4101	5101	1/2 NPT/ANPT	6101
4102	5102	1/2 NPTF	6102
4103	5103	3/4 NPT/ANPT	6103
4104	5104	3/4 NPTF	6104

1-5/8" 4 Per Set Dieheads		UN	
Circular Chasers		T.P.I./Form	Blocks EDP#
25 Chamfer EDP#	45 Chamfer EDP#		
4149	5149	1/2-13/UNC	6149
4150	5150	1/2-20/UNF	6150
4151	5151	9/16-12/UNC	6151
4152	5152	9/16-18/UNF	6152
4153	5153	5/8-11/UNC	6153
4154	5154	5/8-18/UNF	6154
4155	5155	3/4-10/UNC	6155
4156	5156	3/4-16/UNF	6156
4157	5157	7/8-9/UNC	6157
4158	5158	7/8-14/UNF	6158
4159	5159	1-8/UNC	6159
4160	5160	1-12/UNF	6160
4161	5161	1 1/8-7/UNC	6161
4162	5162	1 1/8-12/UNF	6162
4163	5163	1 1/4-7/UNC	6163
4164	5164	1 1/4-12/UNF	6164
4165	5165	1 3/8-12/UNF	6165
4166	5166	1 1/2-12/UNF	6166

Pipe

Circular Chasers		Dia./Form	Blocks EDP#
25 Chamfer EDP#	45 Chamfer EDP#		
4167	5167	1/4 NPT/ANPT	6167
4168	5168	1/4 NPTF	6168
4169	5169	3/8 NPT/ANPT	6169
4170	5170	3/8 NPTF	6170
4171	5171	1/2 NPT/ANPT	6171
4172	5172	1/2 NPTF	6172
4173	5173	3/4 NPT/ANPT	6173
4174	5174	3/4 NPTF	6174
4175	5175	1 NPT/ANPT	6175
4176	5176	1 NPTF	6176
4177	5177	1 1/4 NPT/ANPT	6177
4178	5178	1 1/4 NPTF	6178

1 1/16" 4 Per Set Dieheads		UN	
Circular Chasers		T.P.I./Form	Blocks EDP#
25 Chamfer EDP#	45 Chamfer EDP#		
4127	5127	1/2-13/UNC	6127
4128	5128	1/2-20/UNF	6128
4129	5129	9/16-12/UNC	6129
4130	5130	9/16-18/UNF	6130
4131	5131	5/8-11/UNC	6131
4132	5132	5/8-18/UNF	6132
4133	5133	3/4-10/UNC	6133
4134	5134	3/4-16/UNF	6134
4135	5135	7/8-9/UNC	6135
4136	5136	7/8-14/UNF	6136
4137	5137	1-8/UNC	6137
4138	5138	1-12/UNF	6138

Pipe

Circular Chasers		Dia./Form	Blocks EDP#
25 Chamfer EDP#	45 Chamfer EDP#		
4139	5139	1/8 NPT/ANPT	6139
4140	5140	1/8 NPTF	6140
4141	5141	1/4 NPT/ANPT	6141
4142	5142	1/4 NPTF	6142
4143	5143	3/8 NPT/ANPT	6143
4144	5144	3/8 NPTF	6144
4145	5145	1/2 NPT/ANPT	6145
4146	5146	1/2 NPTF	6146
4147	5147	3/4 NPT/ANPT	6147
4148	5148	3/4 NPTF	6148

2" 4 Per Set Dieheads		UN	
Circular Chasers		T.P.I./Form	Blocks EDP#
25 Chamfer EDP#	45 Chamfer EDP#		
4209	5209	3/4-10/UNC	6209
4210	5210	3/4-16/UNF	6210
4211	5211	7/8-9/UNC	6211
4212	5212	7/8-14/UNF	6212
4213	5213	1-8/UNC	6213
4214	5214	1-12/UNF	6214
4215	5215	1 1/8-7/UNC	6215
4216	5216	1 1/8-12/UNF	6216
4217	5217	1 1/4-7/UNC	6217
4218	5218	1 1/4-12/UNF	6218
4219	5219	1 3/8-12/UNF	6219
4220	5220	1 1/2-12/UNF	6220

Pipe

Circular Chasers		Dia./Form	Blocks EDP#
25 Chamfer EDP#	45 Chamfer EDP#		
4221	5221	1/2 NPT/ANPT	6221
4222	5222	1/2 NPTF	6222
4223	5223	3/4 NPT/ANPT	6223
4224	5224	3/4 NPTF	6224
4225	5225	1 NPT/ANPT	6225
4226	5226	1 NPTF	6226
4227	5227	1 1/4 NPT/ANPT	6227
4228	5228	1 1/4 NPTF	6228
4229	5229	1 1/2 NPT/ANPT	6229
4230	5230	1 1/2 NPTF	6230

Circular Chasers

Circular Chasers & Blocks (Standard 5 Per Set)

13/16" 5 Per Set Dieheads			UN
Circular Chasers		T.P.I./Form	Blocks EDP#
25 Chamfer EDP#	45 Chamfer EDP#		
4247	5247	7/16-14/UNC	6247
4248	5248	7/16-20/UNF	6248
4249	5249	1/2-13/UNC	6249
4250	5250	1/2-20/UNF	6250
4251	5251	9/16-12/UNC	6251
4252	5252	9/16-18/UNF	6252
4253	5253	5/8-11/UNC	6253
4254	5254	5/8-18/UNF	6254
4255	5255	3/4-10/UNC	6255
4256	5256	3/4-16/UNF	6256

Pipe

Circular Chasers		Dia./Form	Blocks EDP#
25 Chamfer EDP#	45 Chamfer EDP#		
4257	5257	1/8 NPT/ANPT	6257
4258	5258	1/8 NPTF	6258
4259	5259	1/4 NPT/ANPT	6259
4260	5260	1/4 NPTF	6260
4261	5261	3/8 NPT/ANPT	6261
4262	5262	3/8 NPTF	6262

1-5/8" 5 Per Set Dieheads			UN
Circular Chasers		T.P.I./Form	Blocks EDP#
25 Chamfer EDP#	45 Chamfer EDP#		
4179	5179	1/2-13/UNC	6179
4180	5180	1/2-20/UNF	6180
4181	5181	9/16-12/UNC	6181
4182	5182	9/16-18/UNF	6182
4183	5183	5/8-11/UNC	6183
4184	5184	5/8-18/UNF	6184
4185	5185	3/4-10/UNC	6185
4186	5186	3/4-16/UNF	6186
4187	5187	7/8-9/UNC	6187
4188	5188	7/8-14/UNF	6188
4189	5189	1-8/UNC	6189
4190	5190	1-12/UNF	6190
4191	5191	1-7/UNC	6191
4192	5192	1 1/8-12/UNF	6192
4193	5193	1 1/4-7/UNC	6193
4194	5194	1 1/4-12/UNF	6194
4195	5195	1 3/8-12/UNF	6195
4196	5196	1 1/2-12/UNF	6196

Pipe

Circular Chasers		Dia./Form	Blocks EDP#
25 Chamfer EDP#	45 Chamfer EDP#		
4197	5197	1/4 NPT/ANPT	6197
4198	5198	1/4 NPTF	6198
4199	5199	3/8 NPT/ANPT	6199
4200	5200	3/8 NPTF	6200
4201	5201	1/2 NPT/ANPT	6201
4202	5202	1/2 NPTF	6202
4203	5203	3/4 NPT/ANPT	6203
4204	5204	3/4 NPTF	6204
4205	5205	1 NPT/ANPT	6205
4206	5206	1 NPTF	6206
4207	5207	1 1/4 NPT/ANPT	6207
4208	5208	1 1/4 NPTF	6208

1" 5 Per Set Dieheads			UN
Circular Chasers		T.P.I./Form	Blocks EDP#
25 Chamfer EDP#	45 Chamfer EDP#		
4105	5105	7/16-14/UNC	6105
4106	5106	7/16-20/UNF	6106
4107	5107	1/2-13/UNC	6107
4108	5108	1/2-20/UNF	6108
4109	5109	9/16-12/UNC	6109
4110	5110	9/16-18/UNF	6110
4111	5111	5/8-11/UNC	6111
4112	5112	5/8-18/UNF	6112
4113	5113	3/4-10/UNC	6113
4114	5114	3/4-16/UNF	6114
4115	5115	7/8-9/UNC	6115
4116	5116	7/8-14/UNF	6116
4117	5117	1-8/UNC	6117
4118	5118	1-12/UNF	6118

Pipe

Circular Chasers		Dia./Form	Blocks EDP#
25 Chamfer EDP#	45 Chamfer EDP#		
4119	5119	1/4 NPT/ANPT	6119
4120	5120	1/4 NPTF	6120
4121	5121	3/8 NPT/ANPT	6121
4122	5122	3/8 NPTF	6122
4123	5123	1/2 NPT/ANPT	6123
4124	5124	1/2 NPTF	6124
4125	5125	3/4 NPT/ANPT	6125
4126	5126	3/4 NPTF	6126

2-3/8" 5 Per Set Dieheads			UN
Circular Chasers		T.P.I./Form	Blocks EDP#
25 Chamfer EDP#	45 Chamfer EDP#		
4231	5231	1-8/UNC	6231
4232	5232	1-12/UNF	6232
4233	5233	1 1/8-7/UNC	6233
4234	5234	1 1/2-12/UNF	6234
4235	5235	1 1/4-7/UNC	6235
4236	5236	1 1/4-12/UNF	6236
4237	5237	1 3/8-12/UNF	6237
4238	5238	1 1/2-12/UNF	6238

Pipe

Circular Chasers		Dia./Form	Blocks EDP#
25 Chamfer EDP#	45 Chamfer EDP#		
4239	5239	1 NPT/ANPT	6239
4240	5240	1 NPTF	6240
4241	5241	1 1/4 NPT/ANPT	6241
4242	5242	1 1/4 NPTF	6242
4243	5243	1 1/2 NPT/ANPT	6243
4244	5244	1 1/2 NPTF	6244
4245	5245	2 NPT/ANPT	6245
4246	5246	2 NPTF	6246

Circular Chasers

Special Circular Chaser & Blocks

Override Capacities

Standard threading diameters of circular chaser dieheads may be increased (subject to factory approval) as shown in the chart below. Override pipe threads can also be cut when diameters and length of threads are within the limits shown.

However, specifying standard equipment whenever possible avoids delay and extra expense. An additional set-up charge is made for chasers over standard rated capacity even though thread form, pitch and diameter are standard

Style of Diehead & Rated Capacity	Override Diameter (inches)	Coarsest Pitch	Maximum Threading Length (Override)	
			Standard Head (inches)	Reboring Die Body (inches)
DBS-1/4	5/16	18	5/8	
	13/32	18	5/8	
DR-DRD-5/16	11/32	18	Full length	
	15/32	20	9/16	
DBS-3/8	1/4	20	3-1/4	
	3/8	16	2-3/8	
	5/8	18	1-5/16	
DR-DRD-DS-3/8	1/2	13	Full length	
	9/16	18	3/4	Full length
	5/8	18	15/16	1-1/4
DBS-9/16	1/2	13	3-7/16	
	9/16	18	2-5/16	
	3/4	16	1-5/16	
	7/8	18	3/4	
	1	18	9/16	
DR-DRD-DS-9/16	5/8	11	15/16	Full length
	3/4	16	3/4	1-1/8
	7/8	18	3/4	
	1	18	9/16	
DR-DS-13/16	7/8	9	1	Full length
	1	14	3/4	1-1/4
DRF-DSF	1-3/16	16	3/4	
	1-1/16	12	3/4	4-3/8
DR-DS-1	1-1/8	12	3/4	1-1/4
	1-3/16	12	3/4	1-1/4
	1-1/4	12	3/4	
	1-5/16	12	3/4	
	1-3/8	12	3/4	
	1-1/2	16	3/4	
	1-5/8	16	3/4	

Style of Diehead & Rated Capacity	Override Diameter (inches)	Coarsest Pitch	Maximum Threading Length (Override)	
			Standard Head (inches)	Reboring Die Body (inches)
DR-1-1/16	1-1/8	12	3/4	1-1/2
	1-3/16	12	3/4	1-1/2
	1-1/4	12	3/4	
	1-3/8	12	3/4	
	1-1/2	16	3/4	
DR-DS-1-5/8	1-11/16	12	7/8	4-3/8
	1-3/4	12	7/8	
DRF-DSF	1-7/8	12	7/8	
	2	12	7/8	
DR-2	1-3/4	12	7/8	4-3/8
	1-7/8	12	7/8	1-1/2
	2	12	7/8	1-1/2
	2-1/8	12	7/8	
	2-1/4	12	7/8	
	2-3/8	16	7/8	
DR-DS-2-3/8	2-1/2	8	1-1/8	5-1/2
	2-5/8	10	1-1/8	
	2-3/4	10	1-1/8	
	2-7/8	10	1-1/8	
	3	10	1-1/8	
DRF-DSF-3-1/2	3-3/4	10	4-1/2	
	3-7/8	10	1-1/8	4-1/2
	4	12	1-1/8	
	4-1/8	12	1-1/8	
	4-1/4	12	1-1/8	
DR-DS-4-7/8	5	6	5-1/8	
	5-1/8	8	1-1/8	
	5-1/4	8	1-1/8	
	5-3/8	10	1-1/8	
	5-1/2	10	1-1/8	

Note: Larger override thread diameter than those indicated will be considered upon application.

Thread Forms

BSPP
Metric
NGO
NH
NPS

NPSL
NPSH
NPSM
UNIFIED
UNJ

Whitworth
60 DEG Stub
Full Acme
STUB ACME
Trapezoidal

BSPT
NGT
NPT
NPTF

Left Handed
Double Lead

Special Chamfers

Modified Truncations

Chasers made with premium material or coated

Single replacement chasers or blocks

Hollow mill cutters

