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

Specifications

<table>
<thead>
<tr>
<th>Dimensions</th>
<th>5/8˝ SF</th>
<th>7/8˝ 7F</th>
<th>1 1/4˝ 10F</th>
<th>2˝ 16F</th>
<th>3˝ 24A</th>
<th>4˝ 32A</th>
</tr>
</thead>
<tbody>
<tr>
<td>Range — inches</td>
<td>#4 to 5/8</td>
<td>#4 to 7/8</td>
<td>1/4 to 1/4</td>
<td>3/16 to 2</td>
<td>3/16 to 3</td>
<td>1 to 4</td>
</tr>
<tr>
<td>Range — mm</td>
<td>3 to 16</td>
<td>3 to 22</td>
<td>6 to 35</td>
<td>8 to 48</td>
<td>8 to 76</td>
<td>8 to 100</td>
</tr>
<tr>
<td>Range — Pipe Sides</td>
<td>1/16 and 1/32</td>
<td>1/16 to 1/2</td>
<td>1/16 to 3/4</td>
<td>1/4 to 2</td>
<td>1/2 to 3</td>
<td>1 to 4</td>
</tr>
<tr>
<td>Coarsest Pitch/Teh, per ft.*</td>
<td>11</td>
<td>9</td>
<td>7</td>
<td>6.5</td>
<td>6</td>
<td>6</td>
</tr>
<tr>
<td>Coarsest Pitch — mm*</td>
<td>2.0</td>
<td>2.5</td>
<td>3.5</td>
<td>3.0</td>
<td>6.5</td>
<td>6.0</td>
</tr>
<tr>
<td>Maximum Thread Length — In.</td>
<td>2-3/4</td>
<td>2-7/8</td>
<td>4-1/2</td>
<td>5-1/8</td>
<td>5-3/4</td>
<td>7-19/32</td>
</tr>
<tr>
<td>Maximum Thread Length — mm</td>
<td>69.8</td>
<td>85.7</td>
<td>114.3</td>
<td>130.2</td>
<td>173.1</td>
<td>193.1</td>
</tr>
<tr>
<td>Weight — Lbs.</td>
<td>4-3/4</td>
<td>10-1/2</td>
<td>23-1/2</td>
<td>51-1/4</td>
<td>137</td>
<td>252</td>
</tr>
<tr>
<td>Weight — Kgs.</td>
<td>2.15</td>
<td>4.76</td>
<td>10.86</td>
<td>22.95</td>
<td>62.14</td>
<td>114.3</td>
</tr>
</tbody>
</table>

*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

<table>
<thead>
<tr>
<th>Dimensions</th>
<th>5/8˝ SF</th>
<th>7/8˝ 7F</th>
<th>1 1/4˝ 10F</th>
<th>2˝ 16F</th>
<th>3˝ 24A</th>
<th>4˝ 32A</th>
</tr>
</thead>
<tbody>
<tr>
<td>A</td>
<td>2-15/16</td>
<td>74.6</td>
<td>3-15/16</td>
<td>100</td>
<td>5-1/8</td>
<td>120</td>
</tr>
<tr>
<td>B*</td>
<td>3-11/32</td>
<td>80.6</td>
<td>3-3/4</td>
<td>95.2</td>
<td>4-57/64</td>
<td>124.2</td>
</tr>
<tr>
<td>C Std. Hollow</td>
<td>1</td>
<td>25.4</td>
<td>1-1/2</td>
<td>38.1</td>
<td>1-3/4</td>
<td>44.4</td>
</tr>
<tr>
<td>C Std. Solid</td>
<td>5/8</td>
<td>15.9</td>
<td>1</td>
<td>25.4</td>
<td>1-1/2</td>
<td>38.1</td>
</tr>
<tr>
<td>C Min. Hollow</td>
<td>7/8</td>
<td>22.2</td>
<td>1-1/4</td>
<td>31.8</td>
<td>1-3/4</td>
<td>44.4</td>
</tr>
<tr>
<td>C Min. Solid</td>
<td>1/2</td>
<td>12.7</td>
<td>5/8</td>
<td>19.1</td>
<td>1-1/2</td>
<td>38.1</td>
</tr>
<tr>
<td>D</td>
<td>2</td>
<td>50.8</td>
<td>2-1/2</td>
<td>63.5</td>
<td>3-1/4</td>
<td>79.5</td>
</tr>
<tr>
<td>E*</td>
<td>2-3/16</td>
<td>55.6</td>
<td>2-5/8</td>
<td>66.7</td>
<td>3-3/8</td>
<td>87.7</td>
</tr>
</tbody>
</table>

*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 4-13/16˝ (122.2 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.
### 5/8" SF LANDMATIC - Standard Chaser Holders

<table>
<thead>
<tr>
<th>RANGE</th>
<th>THREAD FORM</th>
<th>HELIX ANGLE</th>
<th>CHASER SIZE</th>
<th>HOLDER PART NO.</th>
<th>GAGE PART NO.</th>
<th>HOLDER PART NO.</th>
<th>GAGE PART NO.</th>
</tr>
</thead>
<tbody>
<tr>
<td>3/16 to 5/8</td>
<td>UNC</td>
<td>3-1/2°</td>
<td>5/8 x 1-1/8</td>
<td>LNS00800166A</td>
<td>L0D00800155</td>
<td>LNS00800167A</td>
<td>L0D00800157</td>
</tr>
<tr>
<td>No. 4 to No. 12</td>
<td>UNF</td>
<td>3-1/2°</td>
<td>5/8 x 1-1/8</td>
<td>LNS00800069B</td>
<td>L0D00800170</td>
<td>LNS00800065A</td>
<td>L0D00800157</td>
</tr>
<tr>
<td>1/4 x 5/8</td>
<td>UNF</td>
<td>2-1/3°</td>
<td>5/8 x 1-1/8</td>
<td>LNS00800171B</td>
<td>L0D00800172</td>
<td>LNS00800067B</td>
<td>L0D00800157</td>
</tr>
<tr>
<td>1-8 to 3/32</td>
<td>WHIT</td>
<td>4-1/4°</td>
<td>5/8 x 1-1/8</td>
<td>LNS00801016C</td>
<td>L0D00801155</td>
<td>LNS00801018C</td>
<td>L0D00801157</td>
</tr>
<tr>
<td>3/16 to 5/8</td>
<td>WHIT</td>
<td>3-1/2°</td>
<td>5/8 x 1-1/8</td>
<td>LNS00800069C</td>
<td>L0D00800173</td>
<td>LNS00800065C</td>
<td>L0D00800157</td>
</tr>
<tr>
<td>1/4 x 5/8</td>
<td>BSF</td>
<td>2-3/4°</td>
<td>5/8 x 1-1/8</td>
<td>LNS00800017D</td>
<td>L0D00800155</td>
<td>LNS00800017G</td>
<td>L0D00800157</td>
</tr>
<tr>
<td>1/4 to 7/8</td>
<td>METRIC Coarse</td>
<td>3-1/2°</td>
<td>5/8 x 1-1/8</td>
<td>LNS0080060014A</td>
<td>L0D00800170</td>
<td>LNS00800065S</td>
<td>L0D00800157</td>
</tr>
<tr>
<td>1/4 to 7/8</td>
<td>METRIC Fine</td>
<td>2-1/4°</td>
<td>5/8 x 1-1/8</td>
<td>LNS00800714F</td>
<td>L0D00800173</td>
<td>LNS00800015S</td>
<td>L0D00800157</td>
</tr>
<tr>
<td>1/8 to 1/4</td>
<td>PIPE</td>
<td>2-1/4°</td>
<td>5/8 x 1-1/8</td>
<td>LNS00800017J</td>
<td>L0D00800174</td>
<td>LNS00800015J</td>
<td>L0D00800157</td>
</tr>
</tbody>
</table>

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.

### 7/8" SF LANDMATIC - Standard Chaser Holders

<table>
<thead>
<tr>
<th>RANGE</th>
<th>THREAD FORM</th>
<th>HELIX ANGLE</th>
<th>CHASER SIZE</th>
<th>HOLDER PART NO.</th>
<th>GAGE PART NO.</th>
<th>HOLDER PART NO.</th>
<th>GAGE PART NO.</th>
</tr>
</thead>
<tbody>
<tr>
<td>No. 4 to No. 12</td>
<td>UNC</td>
<td>4-1/4°</td>
<td>3/4 x 1-5/8</td>
<td>LNS00800042A</td>
<td>L0D00800118</td>
<td>LNS00800015A</td>
<td>L0D00800119</td>
</tr>
<tr>
<td>1/4 x 7/8</td>
<td>UNF</td>
<td>3-1/4°</td>
<td>3/4 x 1-5/8</td>
<td>LNS00800124A</td>
<td>L0D00800118</td>
<td>LNS00800125A</td>
<td>L0D00800119</td>
</tr>
<tr>
<td>No. 4 to No. 12</td>
<td>UNF</td>
<td>3-1/2°</td>
<td>3/4 x 1-5/8</td>
<td>LNS00800015B</td>
<td>L0D00800170</td>
<td>LNS00800013B</td>
<td>L0D00800119</td>
</tr>
<tr>
<td>1/4 x 7/8</td>
<td>UNF</td>
<td>2-1/4°</td>
<td>3/4 x 1-5/8</td>
<td>LNS00800126B</td>
<td>L0D00800172</td>
<td>LNS00800017B</td>
<td>L0D00800119</td>
</tr>
<tr>
<td>1/8 to 3/32</td>
<td>WHIT</td>
<td>4-1/4°</td>
<td>3/8 x 1-5/8</td>
<td>LNS00800020C</td>
<td>L0D00800118</td>
<td>LNS00800026C</td>
<td>L0D00800119</td>
</tr>
<tr>
<td>1/4 to 7/8</td>
<td>WHIT</td>
<td>3-1/4°</td>
<td>3/8 x 1-5/8</td>
<td>LNS00800014C</td>
<td>L0D00800118</td>
<td>LNS00800017C</td>
<td>L0D00800119</td>
</tr>
<tr>
<td>1/4 x 7/8</td>
<td>BSF</td>
<td>2-3/4°</td>
<td>3/4 x 1-5/8</td>
<td>LNS00800139D</td>
<td>L0D00800118</td>
<td>LNS00800012B</td>
<td>L0D00800119</td>
</tr>
<tr>
<td>6 to 22 mm</td>
<td>METRIC Coarse</td>
<td>3-1/4°</td>
<td>3/4 x 1-5/8</td>
<td>LNS00800124E</td>
<td>L0D00800120</td>
<td>LNS008000125E</td>
<td>L0D00800121</td>
</tr>
<tr>
<td>6 to 22 mm</td>
<td>METRIC Fine</td>
<td>1-3/4°</td>
<td>3/4 x 1-5/8</td>
<td>LNS00800131F</td>
<td>L0D00800120</td>
<td>LNS008000131F</td>
<td>L0D00800121</td>
</tr>
<tr>
<td>1/8 to 1/2</td>
<td>PIPE</td>
<td>1-3/4°</td>
<td>3/4 x 1-5/8</td>
<td>LNS00800130H</td>
<td>L0D00800122</td>
<td>LNS008000130H</td>
<td>L0D00800123</td>
</tr>
</tbody>
</table>

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 Holders**

<table>
<thead>
<tr>
<th>RANGE</th>
<th>THREAD FORM</th>
<th>HELIX ANGLE</th>
<th>CHASER SIZE</th>
<th>HOLDER PART NO.</th>
<th>GAGE PART NO.</th>
<th>HOLDER PART NO.</th>
<th>GAGE PART NO.</th>
</tr>
</thead>
<tbody>
<tr>
<td>1/4 to 3/4</td>
<td>UNC</td>
<td>2.5°</td>
<td>15/16 x 2-1/8</td>
<td>LS0060420A</td>
<td>L006105</td>
<td>LNS0B060421A</td>
<td>L0C060180</td>
</tr>
<tr>
<td>1/2 to 2</td>
<td>UNC</td>
<td>2.5°</td>
<td>1-1/4 x 2-3/4</td>
<td>LNS015634A</td>
<td>L016105</td>
<td>LNS015634A</td>
<td>L0C060180</td>
</tr>
<tr>
<td>3/4 to 1-1/4</td>
<td>UNC</td>
<td>2.5°</td>
<td>15/16 x 2-1/8</td>
<td>LNS001634A</td>
<td>L006105</td>
<td>LNS001634A</td>
<td>L0C060180</td>
</tr>
<tr>
<td>1/2 to 5/8</td>
<td>UNF</td>
<td>2°</td>
<td>15/16 x 2-1/8</td>
<td>LNS015634B</td>
<td>L016105</td>
<td>LNS015634B</td>
<td>L0C060180</td>
</tr>
<tr>
<td>7/8 to 1-1/4</td>
<td>UNF</td>
<td>2°</td>
<td>15/16 x 2-1/8</td>
<td>LNS015634C</td>
<td>L016105</td>
<td>LNS015634C</td>
<td>L0C060180</td>
</tr>
<tr>
<td>1-1/2 to 2</td>
<td>BSF</td>
<td>1-1/4°</td>
<td>15/16 x 2-1/8</td>
<td>LNS015634D</td>
<td>L016105</td>
<td>LNS015634D</td>
<td>L0C060180</td>
</tr>
</tbody>
</table>

**2" 16F LANDMATIC – Standard Chaser Holders**

<table>
<thead>
<tr>
<th>RANGE</th>
<th>THREAD FORM</th>
<th>HELIX ANGLE</th>
<th>CHASER SIZE</th>
<th>HOLDER PART NO.</th>
<th>GAGE PART NO.</th>
<th>HOLDER PART NO.</th>
<th>GAGE PART NO.</th>
</tr>
</thead>
<tbody>
<tr>
<td>3/8 to 1-1/4</td>
<td>UNC</td>
<td>2-3/4°</td>
<td>15/16 x 2-1/8</td>
<td>LNS015634A</td>
<td>L016105</td>
<td>LNS015634A</td>
<td>L0C060180</td>
</tr>
<tr>
<td>1/2 to 1-1/4</td>
<td>UNC</td>
<td>2-3/4°</td>
<td>15/16 x 2-1/8</td>
<td>LNS015634B</td>
<td>L016105</td>
<td>LNS015634B</td>
<td>L0C060180</td>
</tr>
<tr>
<td>1-1/2 to 2</td>
<td>BSF</td>
<td>1-1/4°</td>
<td>15/16 x 2-1/8</td>
<td>LNS015634D</td>
<td>L016105</td>
<td>LNS015634D</td>
<td>L0C060180</td>
</tr>
</tbody>
</table>

*For 15 JMB Die Head*

N 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.
### 3" 24A LANDMATIC – Standard Chaser Holders

<table>
<thead>
<tr>
<th>RANGE</th>
<th>THREAD FORM</th>
<th>HELIX ANGLE</th>
<th>CHASER SIZE</th>
<th>HOLDER PART NO.</th>
<th>GAGE PART NO.</th>
<th>HOLDER PART NO.</th>
<th>GAGE PART NO.</th>
</tr>
</thead>
<tbody>
<tr>
<td>3/4 to 1-1/2</td>
<td>UNC</td>
<td>2°</td>
<td>1-3/64 or 1-7/64 x 4</td>
<td>LNS0B049446A</td>
<td>L0C048413</td>
<td>LNS0B050802A</td>
<td>LNS0C050217</td>
</tr>
<tr>
<td>1 to 1-1/2</td>
<td>UNC</td>
<td>2&quot;</td>
<td>1-3/4 x 4</td>
<td>LNS0B050160A</td>
<td>LNS0C050240</td>
<td></td>
<td></td>
</tr>
<tr>
<td>3/4 to 1-1/2</td>
<td>UNF</td>
<td>1-1/2&quot;</td>
<td>1-3/4 x 4</td>
<td>LNS0B050135B</td>
<td>LNS0C050281</td>
<td></td>
<td></td>
</tr>
<tr>
<td>1 to 1-1/2</td>
<td>UNF</td>
<td>1-1/4&quot;</td>
<td>1-3/4 x 4</td>
<td>LNS0B050135B</td>
<td>LNS0C050281</td>
<td></td>
<td></td>
</tr>
<tr>
<td>3/4 to 1-1/2</td>
<td>WHRT</td>
<td>2-1/2&quot;</td>
<td>1-3/4 or 1-1/4 x 4</td>
<td>LNS0B019446C</td>
<td>LNS0C050217</td>
<td></td>
<td></td>
</tr>
<tr>
<td>1 to 1-1/2</td>
<td>WHRT</td>
<td>2&quot;</td>
<td>1-1/2 x 4</td>
<td>LNS0B050160A</td>
<td>LNS0C050240</td>
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<td></td>
</tr>
<tr>
<td>3/4 to 1-1/2</td>
<td>BSF</td>
<td>1-3/4&quot;</td>
<td>1-3/4 x 4</td>
<td>LNS0B050135B</td>
<td>LNS0C050281</td>
<td></td>
<td></td>
</tr>
<tr>
<td>1 to 1-1/2</td>
<td>BSF</td>
<td>1-1/4&quot;</td>
<td>1-3/4 x 4</td>
<td>LNS0B050135B</td>
<td>LNS0C050281</td>
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<td></td>
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<tr>
<td>18 to 39 mm</td>
<td>METRIC COARSE</td>
<td>2-1/2&quot;</td>
<td>1-3/4 or 1-1/4 x 4</td>
<td>LNS0B019446E</td>
<td>LNS0C050240</td>
<td></td>
<td></td>
</tr>
<tr>
<td>42 to 76 mm</td>
<td>METRIC COARSE</td>
<td>2&quot;</td>
<td>1-3/4 x 4</td>
<td>LNS0B050160A</td>
<td>LNS0C050240</td>
<td></td>
<td></td>
</tr>
<tr>
<td>1/2 to 3-1/4</td>
<td>TAPER PIPE</td>
<td>1-3/4&quot;</td>
<td>1-3/4 x 4</td>
<td>LNS0B050170G</td>
<td>LNS0C050217</td>
<td></td>
<td></td>
</tr>
<tr>
<td>1 to 2</td>
<td>TAPER PIPE</td>
<td>1&quot;</td>
<td>1-3/4 x 4</td>
<td>LNS0B050170G</td>
<td>LNS0C050217</td>
<td></td>
<td></td>
</tr>
<tr>
<td>1/2 to 3-1/4</td>
<td>TAPER PIPE</td>
<td>3/4&quot;</td>
<td>1-7/8 x 4</td>
<td>LNS0B050171G</td>
<td>LNS0C050217</td>
<td></td>
<td></td>
</tr>
<tr>
<td>1/2 to 3/4</td>
<td>STR Pipe</td>
<td>1-3/4&quot;</td>
<td>1-3/4 x 4</td>
<td>LNS0B050172H</td>
<td>LNS0C050217</td>
<td></td>
<td></td>
</tr>
<tr>
<td>1 to 2</td>
<td>STR Pipe</td>
<td>3/4&quot;</td>
<td>1-3/4 x 4</td>
<td>LNS0B050172H</td>
<td>LNS0C050217</td>
<td></td>
<td></td>
</tr>
<tr>
<td>2-1/2 to 4</td>
<td>STR Pipe</td>
<td>3/4&quot;</td>
<td>1-3/4 x 4</td>
<td>LNS0B050172H</td>
<td>LNS0C050217</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

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.

### 4" 32A LANDMATIC – Standard Chaser Holders

<table>
<thead>
<tr>
<th>RANGE</th>
<th>THREAD FORM</th>
<th>HELIX ANGLE</th>
<th>CHASER SIZE</th>
<th>HOLDER PART NO.</th>
<th>GAGE PART NO.</th>
<th>HOLDER PART NO.</th>
<th>GAGE PART NO.</th>
</tr>
</thead>
<tbody>
<tr>
<td>1 to 1-1/2</td>
<td>UNC</td>
<td>2&quot;</td>
<td>1-3/4 x 4</td>
<td>LNS0B050160A</td>
<td>LNS0C050240</td>
<td>LNS0B050160A</td>
<td>LNS0C050240</td>
</tr>
<tr>
<td>1-6 to 3</td>
<td>UNC</td>
<td>2&quot;</td>
<td>1-3/4 x 4</td>
<td>LNS0B050160A</td>
<td>LNS0C050240</td>
<td>LNS0B050160A</td>
<td>LNS0C050240</td>
</tr>
<tr>
<td>1-6 to 3</td>
<td>UNF</td>
<td>1-1/4&quot;</td>
<td>1-3/4 x 4</td>
<td>LNS0B050135B</td>
<td>LNS0C050281</td>
<td>LNS0B050135B</td>
<td>LNS0C050281</td>
</tr>
<tr>
<td>1 to 1-1/2</td>
<td>UNF</td>
<td>1-3/4&quot;</td>
<td>1-3/4 x 4</td>
<td>LNS0B050135B</td>
<td>LNS0C050281</td>
<td>LNS0B050135B</td>
<td>LNS0C050281</td>
</tr>
<tr>
<td>1 to 1-1/2</td>
<td>WHRT</td>
<td>2-1/2&quot;</td>
<td>1-3/4 or 1-1/4 x 4</td>
<td>LNS0B019446C</td>
<td>LNS0C050217</td>
<td></td>
<td></td>
</tr>
<tr>
<td>1 to 1-1/2</td>
<td>WHRT</td>
<td>2&quot;</td>
<td>1-1/2 x 4</td>
<td>LNS0B050160A</td>
<td>LNS0C050240</td>
<td></td>
<td></td>
</tr>
<tr>
<td>3-1/4 to 2-3/4</td>
<td>BSF</td>
<td>1-1/4&quot;</td>
<td>1-3/4 or 1-1/4 x 4</td>
<td>LNS0B050135B</td>
<td>LNS0C050281</td>
<td></td>
<td></td>
</tr>
<tr>
<td>3 to 4</td>
<td>BSF</td>
<td>1-1/4&quot;</td>
<td>1-1/4 x 4</td>
<td>LNS0B050160A</td>
<td>LNS0C050240</td>
<td></td>
<td></td>
</tr>
<tr>
<td>25 to 38 mm</td>
<td>METRIC COARSE</td>
<td>2-1/2&quot;</td>
<td>1-3/4 or 1-1/4 x 4</td>
<td>LNS0B019446E</td>
<td>LNS0C050240</td>
<td></td>
<td></td>
</tr>
<tr>
<td>42 to 76 mm</td>
<td>METRIC COARSE</td>
<td>2&quot;</td>
<td>1-3/4 x 4</td>
<td>LNS0B050160A</td>
<td>LNS0C050240</td>
<td></td>
<td></td>
</tr>
<tr>
<td>1/2 to 3-1/4</td>
<td>TAPER PIPE</td>
<td>1-3/4&quot;</td>
<td>1-3/4 x 4</td>
<td>LNS0B050170G</td>
<td>LNS0C050217</td>
<td></td>
<td></td>
</tr>
<tr>
<td>1 to 2</td>
<td>TAPER PIPE</td>
<td>1&quot;</td>
<td>1-3/4 x 4</td>
<td>LNS0B050170G</td>
<td>LNS0C050217</td>
<td></td>
<td></td>
</tr>
<tr>
<td>1/2 to 3-1/4</td>
<td>TAPER PIPE</td>
<td>3/4&quot;</td>
<td>1-7/8 x 4</td>
<td>LNS0B050171G</td>
<td>LNS0C050217</td>
<td></td>
<td></td>
</tr>
<tr>
<td>1 to 2</td>
<td>STR Pipe</td>
<td>1&quot;</td>
<td>1-3/4 x 4</td>
<td>LNS0B050172H</td>
<td>LNS0C050217</td>
<td></td>
<td></td>
</tr>
<tr>
<td>1/2 to 3-1/4</td>
<td>STR Pipe</td>
<td>3/4&quot;</td>
<td>1-3/4 x 4</td>
<td>LNS0B050172H</td>
<td>LNS0C050217</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

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

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## Specifications

**“F” & “A” Landmatics**

### Oversize Chaser Holders

<table>
<thead>
<tr>
<th>Range</th>
<th>Chaser Size</th>
<th>Coarsest Pitch Thds. Per In.–(mm)</th>
<th>Maximum Thread Length**</th>
</tr>
</thead>
<tbody>
<tr>
<td>5/8” – 5F</td>
<td>5/8 x 1-1/8</td>
<td>14 – (1.75 mm)</td>
<td>7/8 – (22 mm)</td>
</tr>
<tr>
<td>3/4 to 1 – (18 to 24 mm)</td>
<td>5/8 x 1-1/8</td>
<td>14 – (1.75 mm)</td>
<td>1-5/16 – (32 mm)</td>
</tr>
<tr>
<td>1 to 1-1/4 – (24 to 34 mm)</td>
<td>5/8 x 1-1/8</td>
<td>14 – (1.75 mm)</td>
<td>13/16 – (20 mm)</td>
</tr>
<tr>
<td>15/16 to 1-1/2 – (24 to 39 mm)</td>
<td>3/4 x 1-5/8</td>
<td>14 – (1.75 mm)</td>
<td>1-1/8 – (24 mm)</td>
</tr>
<tr>
<td>1-3/16 to 2 – (36 to 51 mm)</td>
<td>3/4 x 1-5/8</td>
<td>14 – (1.75 mm)</td>
<td>2 – (51 mm)†</td>
</tr>
<tr>
<td>5/8” – 7F</td>
<td>15/16 x 2-1/8</td>
<td>12 – (3 mm)</td>
<td>1-3/16 or 2-1/8 – (30 or 32 mm)†</td>
</tr>
<tr>
<td>1-5/16 to 2 – (42 to 52 mm)</td>
<td>15/16 x 2-1/8</td>
<td>8 – (3 mm)</td>
<td>1-5/16 or 2-1/8 – (30 or 32 mm)†</td>
</tr>
<tr>
<td>1-1/4” – 10F</td>
<td>15/16 x 2-1/8</td>
<td>8 – (3 mm)</td>
<td>1-5/16 or 2-1/8 – (30 or 32 mm)†</td>
</tr>
<tr>
<td>1-5/16 to 2 – (33 to 52 mm)</td>
<td>15/16 x 2-1/8</td>
<td>8 – (3 mm)</td>
<td>1-5/16 or 2-1/8 – (30 or 32 mm)†</td>
</tr>
<tr>
<td>2” – 16F</td>
<td>15/16 x 2-1/8</td>
<td>6 – (4 mm)</td>
<td>1-7/8 or 2-1/8 – (48 or 56 mm)†</td>
</tr>
<tr>
<td>3-1/8 to 4-1/4 – (78 to 108 mm)</td>
<td>15/16 x 2-1/8</td>
<td>6 – (4 mm)</td>
<td>1-7/8 or 2-1/8 – (48 or 56 mm)†</td>
</tr>
<tr>
<td>2-1/8 to 2-3/4 – (52 to 72 mm)</td>
<td>15/16 x 2-1/8</td>
<td>6 – (4 mm)</td>
<td>1-7/8 or 2-1/8 – (48 or 56 mm)†</td>
</tr>
<tr>
<td>3-1/8 to 3-3/4 – (80 to 96 mm)</td>
<td>15/16 x 2-1/8</td>
<td>6 – (4 mm)</td>
<td>1-7/8 or 2-1/8 – (48 or 56 mm)†</td>
</tr>
<tr>
<td>3-1/8 to 4 – (74 to 100 mm)</td>
<td>1-3/64 or 1-7/64 x 4</td>
<td>6 – (4 mm)</td>
<td>1-7/8 or 2-1/8 – (48 or 56 mm)†</td>
</tr>
<tr>
<td>4-3/8 to 5-1/2 – (112 to 140 mm)</td>
<td>1-3/64 or 1-7/64 x 4</td>
<td>6 – (4 mm)</td>
<td>1-7/8 or 2-1/8 – (48 or 56 mm)†</td>
</tr>
<tr>
<td>4” – 32A</td>
<td>1-3/64 or 1-7/64 x 4</td>
<td>6 – (4 mm)</td>
<td>2-5/8 – (65 mm)</td>
</tr>
<tr>
<td>4-1/8 to 4-3/4* – (104 to 121 mm)</td>
<td>1-3/64 or 1-7/64 x 4</td>
<td>6 – (4 mm)</td>
<td>2-5/8 – (65 mm)</td>
</tr>
<tr>
<td>5 to 6-1/2 – (125 to 165 mm)</td>
<td>1-3/64 or 1-7/64 x 4</td>
<td>6 – (4 mm)</td>
<td>1-7/8 or 4-1/4”* – (48 or 108 mm)</td>
</tr>
</tbody>
</table>

*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 2-1/8˝ to 2-3/4˝ 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.

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