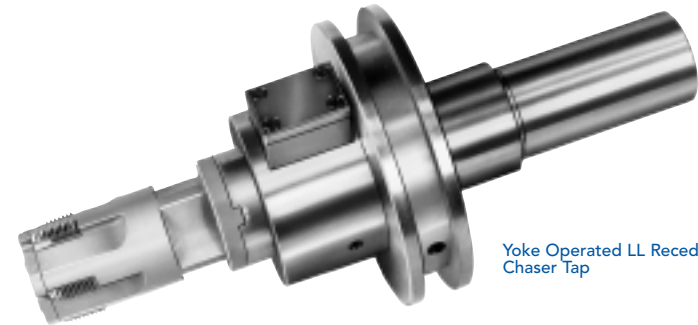




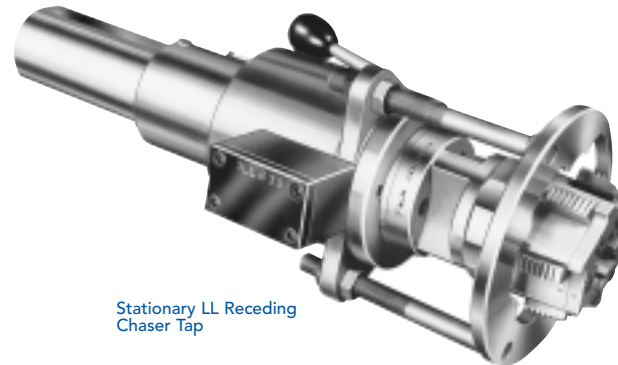
LL Receding Chaser Collapsible Taps

Landis Solutions LLC
360 South Church Street
Waynesboro, PA 17268-2610
Toll Free:
USA: +1.800.358.3500
Fax: +1.888.718.2922
Canada: +1.888.828.6340
e-mail: info@Landis-Solutions.com

- A receding chaser type tap primarily intended to produce longer length American Petroleum Institute (API) threads. Can also be used to cut NPT and BSTP taper pipe as well as straight threads.
- Four bodies with twenty-six standard tap heads allow 1" to 12" nominal pipe sizes to be tapped.
- Leadscrew or positive feed is required.
- As the tap moves forward, the chasers recede into the tap head at the rate needed to produce the desired taper. The taper rate is controlled by a precise receding mechanism acting in consort with the leadscrew.
- Usually supplied with a receding lever to produce 3/4" taper per foot. Other receding levers are available to cut 0 to 2" taper per foot or straight threads.
- Normally supplied for right-hand tapping, the LL can also be supplied with tap heads and chasers for left-hand work.
- The standard stationary tap can be converted to a revolving tap by removing the setup handle and setting up the tap with a yoke. See the illustration for other types of possible applications.



Yoke Operated LL Receding Chaser Tap



Stationary LL Receding Chaser Tap



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SPECIFICATIONS

BODY NUMBER	SIZE OF HEAD	CHASERS PER SET	PIPE SIZE	**STANDARD CAPACITY		**COARSEST PITCH		††THREAD LENGTH		WEIGHT	
				INCHES	MM	THREADS	MM	††INCHES	††MM	LBS	KILOGRAMS
2 LL	1"	3	1"	1-1/4 to 1-3/8	34	11	2.0	1-1/2	38.1	*22	*9.98
	1-1/4"	4	1-1/4"	1-5/8 to 1-7/8	42 to 48	11	2.0	1-1/2	38.1	2-1/2	1.13
	1-1/2"	4	1-1/2"	1-7/8 to 2-5/16	48 to 59	11	2.0	1-1/2	38.1	3-1/4	1.47
	2"	5	2"	2-5/16 to 2-3/4	59 to 70	10	2.5	2-1/2	63.5	3-1/2	1.59
	2-1/2"	5	2-1/2"	2-3/4 to 3-1/4	70 to 83	8	3.0	2-1/2	63.5	4-1/2	2.04
3 LL	1-1/4"	4	1-1/4"	1-5/8 to 1-7/8	42 to 48	11	2.0	1-1/2	38.1	3-1/4	1.47
	1-1/2"	4	1-1/2"	1-7/8 to 2-5/16	48 to 59	11	2.0	1-1/2	38.1	5	2.27
	2"	5	2"	2-5/16 to 2-3/4	59 to 70	10	2.5	2-1/2	63.5	5-1/2	2.49
	2-1/2"	5	2-1/2"	2-3/4 to 3-1/4	70 to 83	8	3.0	2-1/2	63.5	6	2.72
	3"	6	3"	3-1/4 to 3-3/4	83 to 95	8	3.0	3-1/2	88.9	6-1/4	2.83
	3-1/2"	6	3-1/2"	3-3/4 to 4-1/4	95 to 108	8	3.0	3-1/2	88.9	7-1/4	3.29
	4"	6	4"	4-1/4 to 4-3/4	108 to 121	6	4.0	3-1/2	88.9	10-1/2	4.76
4 LL	2-1/2"	5	2-1/2"	2-3/4 to 3-1/4	70 to 83	8	3.0	2-1/2	63.5	*7	*3.17
	3"	6	3"	3-1/4 to 3-3/4	83 to 95	8	3.0	3-1/2	88.9	8	3.63
	3-1/2"	6	3-1/2"	3-3/4 to 4-1/4	95 to 108	8	3.0	3-1/2	88.9	9	4.08
	4"	6	4"	4-1/4 to 4-3/4	108 to 121	6	4.0	4-1/2	114.3	14	6.35
	4-1/2"	6	4-1/2"	4-3/4 to 5-1/2	121 to 140	6	4.0	4-1/2	114.3	16	7.26
	5"	6	5"	5-1/2 to 6-5/8	140 to 165	6	4.0	4-1/2	114.3	20	9.08
6 LL	6"	6	6"	6-1/2 to 8	165 to 203	6	4.0	4-1/2	114.3	28	12.61
	7"	6	7"	7-1/2 to 9	190 to 229	6	4.0	4-1/2	114.3	37	16.79
	8"	8	8"	8-1/2 to 10	216 to 254	6	4.0	4-1/2	114.3	44	19.97
	9"	8	9"	9-1/2 to 11-1/4	241 to 286	6	4.0	4-1/2	114.3	56	25.42
	10"	10	10"	10-1/2 to 12-1/4	267 to 311	6	4.0	4-1/2	114.3	65	29.51
	11"	10	11"	11-1/2 to 13-1/4	292 to 337	6	4.0	4-1/2	114.3	72	32.68
	12"	11	12"	12-1/2 to 13-3/8	318 to 340	6	4.0	4-1/2	114.3	88	39.95

*Weight of Tap Body. Additional weights shown pertain to individual Tap Heads.

**These specifications apply to steel and are subject to modification for other materials.

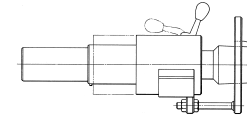
†Special taps can be supplied for thread lengths greater than those listed.

†† Based on tapping up to and including 3/4" taper per foot with R.H. tap heads. If taper is increased, thread length decreases. L.H. threads require L.H. tap heads. Consult factory for left-hand thread lengths.

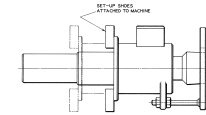
‡Special size Tap Heads for this Body. Price differs from standard type.

Ordering Instructions

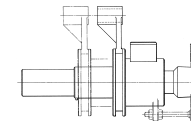
All orders or inquiries should specify the style of tap required, whether stationary or rotary type, and the size and style of shank. The major diameter of the thread at the large end, the pitch, form and amount of taper per foot of the thread should be given. The material to be tapped should be specified and information should be given as to whether standard chasers for "open hole" work or overhang chasers for "bottoming" work are required. If overhang chasers are ordered, a sketch should be submitted showing the relief at the bottom of the thread. Also specify whether tap will be fed manually or mechanically.



LL Tap Arranged For Stationary Usage. With This Type Application The Tap is Set-Up With A Lever



This Version Is Arranged For Rotary Application With Set-Up Accomplished By Shoes Contacting A Set-Up Flange



A Typical Rotary, Yoke Operated Application Supplied For Bar Automatics Or Other Jobs Having Constant Workpiece Location



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DIMENSIONS

BODY No.	SIZE OF HEAD	DIA. OF NOSE	CHASER TO CAP FACE	LENGTH OF TAP	LENGTH OF HEAD	DIA. TRIP RING	DIA. OF COLLAR	DIA.* OF SHANK		LENGTH OF SHANK	SWING OF CAM COLLAR	HEAD FLANGE AND BODY DIA.	WIDTH OF YOKE GROOVE	DIA. OF YOKE GROOVE	DIA. OF YOKE COLLAR
								Std.	Min.						
	A	N	D	E	B	C	F	G	H	J	K	L	M		
2 LL	1"	1"	.188	9-1/2"	3-7/16"										
	1-1/4"	1-27/64"	.192	9-7/8"	3-13/16"										
	1-1/2"	1-43/64"	.192	9-7/8"	3-13/16"	5-5/16"	3-11/16"	2"	1-1/2"	4"	2-13/16"	2-3/8"	.750	5-1/8"	6-1/8"
	2"	2-7/64"	.250	10-5/16"	4-1/4"										
3 LL	2-1/2"	2-1/2"	.250												
	3-1/4"	1-27/64"	.192	11-15/16"	4"										
	3-1/2"	1-43/64"	.250												
	2"	2-7/64"	.250			6-1/8"	4-5/16"	2-1/2"	1-3/4"	5"	3-7/8"	3"	.750	5-1/8"	6-1/8"
	2-1/2"	2-1/2"	.250												
	3"	3"	.312	12-11/16"	4-3/4"										
4 LL	3-1/2"	3-1/2"	.312												
	4"	4"	.312	16-1/2"	5-1/2"										
	3-1/2"	3-1/2"	.312	16-9/16"	5-9/16"	7-1/4"									
	4-1/2"	4-1/2"	.500	14-3/4"	3-3/4"		5-11/16"	3-1/2"	2-1/2"	5"	5-5/16"	4"	1.000	6-1/2"	7-3/4"
	4-1/2"	4-1/2"	.500	14-11/16"	3-11/16"										
6 LL	5"	5-1/4"	.500												
	6"	5-7/8"	.500	14-15/16"	3-15/16"										
	6"	5-7/8"	.500	15-13/16"	3-15/16"	11-1/2"									
	7"	6-7/8"	.500												
	8"	7-7/8"	.500												
	9"	8-7/8"	.500												
	10"	10"	.625	15-15/16"	4-1/16"		7-7/8"	4-1/4"	3"	6-1/2"	6	1.000	8-5/8"	9-1/4"	
	11"	11"	.625												
12"	12"	.625													

§Special size Tap Heads for this Body. Price differs from standard type.

*For shank diameters other than listed, please contact the LANDIS Tap Engineering Department.

**Sizes available: 2 LL-No. 5, 3 LL-No. 5, 4 LL-No. 5 or 6, 6 LL-No. 6

