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Specifications

"JN" Landex

- Landex die heads are revolving tools for automatic screw and other machines that have "live spindles"
- Ideal for high production machines where die head space is limited
- Available in sizes 1/2" to 2" (12 to 15 mm)
- Opened and closed by a yoke
- For straight and tapered threading applications from #4 to 3-3/4" maximum oversize (3 to 96 mm)

Specs/Dimensions



Specifications

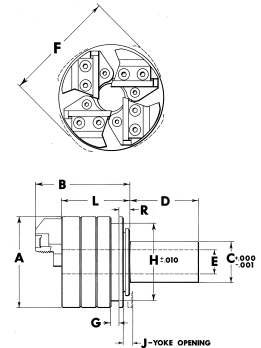
	1/2" 4JN	13/16" 13JN	1-1/4" 10JN	2" 16JN
Range—Inches	#4 to 1/2	#4 to 13/16	1/4 to 1-1/4	3/8 to 2
Range—mm	3 to 12	3 to 20	6 to 33**	9 to 52**
Range—Pipe Sizes	1/8 to 1/4	1/8 to 1/2	1/8 to 3/4	1/4 to 2
Coarsest Pitch—Thrds per in.*	12	9	7	4-1/2
Coarsest Pitch—mm*	2.0	2.5	3.5	5.0
Weight—Lbs.	4-1/2	10-3/4	26-1/4	60
Weight—Kgms.	2.04	4.88	11.91	27.22

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

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

Dimensions

Dimensions	1/2" 4JN		13/16" 13JN		1-1/4" 10JN		2" 16JN	
	Inches	mm	Inches	mm	Inches	mm	Inches	mm
A	2-15/16	74.6	3-15/16	100.0	5-1/8	130.2	6-15/16	176.2
††B	3-3/4	95.3	4-11/32	110.3	5-17/64	133.8	6-27/32	173.8
C*	1	25.4	1-1/2	38.1	1-3/4	44.4	2-3/4	69.8
C**	7/8	22.2	1-1/4	31.8	1-3/4	44.4	2-5/8	66.7
C***	1/2	12.7	5/8	15.9	1-1/4	31.8	1-1/2	38.1
C****	5/8	15.9	—	—	1-1/2	38.1	2	50.8
D	2	50.8	2-1/2	63.5	3-1/4	82.5	3-1/2	88.9
E	21/32	16.7	15/16	23.8	1-5/16	33.3	2-1/16	52.4
†††F	2-15/16	74.6	4	101.6	5-1/8	130.2	7-3/16	182.6
G	3/8	9.5	1/2	12.7	7/16	11.1	5/8	15.9
H	2-1/16	52.4	2-15/16	74.6	4-3/8	111.1	5-15/16	150.8
J	5/16	7.9	21/64	8.3	15/32	11.9	17/32	13.5
L	2-11/16	68.3	3-15/64	82.2	3-3/4	95.3	4-29/32	124.6
R	1/2	12.7	1/2	12.7	17/32	13.5	25/32	13.5



* Std. hollow. ** Min. hollow. *** Min. Solid. **** Std. Solid.

† Max. diameter with holders open cutting largest dia.

†† "B" and "F" are based on using std. max. range U.N.C. Holders. For correct dimension when using oversize or any other holder, please contact Landis Engineering Dept.

1/2 4JN LANDEX - 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	LNSOB116218A	LOD051855	—	—
	UNC	3-1/2°	5/8 x 1-1/8	LNSOB060037A	LOC060052	LNSOB060038A	LOC060053
No. 4 to No. 12	UNF	3-1/2°	5/8 x 1-1/8	LNSOB060037B	LOC051855	—	—
	UNF	2-1/3°	5/8 x 1-1/8	LNSOB060039B	LOC060052	LNSOB060040B	LOC060053
3/16 to 1/2	WHIT	3-1/2°	5/8 x 1-1/8	LNSOB060037C	LOC060052	LNSOB060038C	LOC060053
1/4 to 5/8	BSF	2-3/4°	5/8 x 1-1/8	LNSOB060041D	LOC060052	LNSOB060042D	LOC060053
4 to 12 mm	METRIC COARSE	3-1/2°	5/8 x 1-1/8	LNSOB060037E	LOC060054	LNSOB060038E	LNSOC060055
4 to 12 mm	METRIC FINE	2°	5/8 x 1-1/8	LNSOB060043F	LOC060054	LNSOB116221F	LOC060055
1/8 to 1/4	PIPE	2°	5/8 x 1-1/8	LNSOB060043I	LOC060056	LNSOB116221I	LNSOC060057

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.





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13/16 JN LANDEX – 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	3-1/4°	3/4 x 1-5/8	LNSOB116230A	L0D060118	–	–
1/4 to 13/16	UNC	3-1/4°	3/4 x 1-5/8	LNSOB060105A	L0D060118	LNSOB060106A	L0D060119
No. 4 to No. 12	UNF	3-1/2°	3/4 x 1-5/8	LNSOB116264B	L0D060118	–	–
1/4 to 7/8	UNF	2-1/4°	3/4 x 1-5/8	LNSOB060107B	L0D060118	LNSOB060108B	L0D060119
1/4 to 13/16	WHIT	3-1/4°	3/4 x 1-5/8	LNSOB060105C	L0D060118	LNSOB060106C	L0D060119
1/4 to 7/8	BSF	2-1/2°	3/4 x 1-5/8	LNSOB060109D	L0D060118	LNSOB060110D	L0D060119
6 to 22 mm	METRIC COARSE	3-1/4°	3/4 x 1-5/8	LNSOB060105E	L0D060120	LNSOB060106E	LNSOD060121
6 to 22 mm	METRIC FINE	1-3/4°	3/4 x 1-5/8	LNSOB060111F	L0D060120	LNSOB060112F	LNSOD060121
1/8 to 1/2	PIPE	1-3/4°	3/4 x 1-5/8	LNSOB060111I	L0D060122	LNSOB060112I	LNSOD060123

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1-1/4 10JN LANDEX – 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	LNSOB060404A	LOC060179	LNSOB060405A	LOC060180
13/16 to 1-1/4	UNC	2-1/2°	15/16 x 2-1/8	LNSOB060406A	LOC060179	LNSOB060407A	LOC060180
1/4 to 7/16	UNF	2-1/2°	15/16 x 2-1/8	LNSOB060408B	LOC060179	LNSOB060409B	LOC060180
1/2 to 3/4	UNF	1-3/4°	15/16 x 2-1/8	LNSOB060410B	LOC060179	LNSOB060411B	LOC060180
7/8 to 1-1/4	UNF	1-1/2°	15/16 x 2-1/8	LNSOB060412B	LOC060179	LNSOB060413B	LOC060180
1/4 to 3/4	WHIT	3-1/4°	15/16 x 2-1/8	LNSOB060404C	LOC060179	LNSOB060405C	LOC060180
13/16 to 1-1/4	WHIT	2-1/2°	15/16 x 2-1/8	LNSOB060406C	LOC060179	LNSOB060407C	LOC060180
1/4 to 3/4	BSF	2-1/2°	15/16 x 2-1/8	LNSOB060408D	LOC060179	LNSOB060409D	LOC060180
13/16 to 1-1/4	BSF	2°	15/16 x 2-1/8	LNSOB060414D	LOC060179	LNSOB060415D	LOC060180
6 to 18 mm	METRIC COARSE	3-1/4°	15/16 x 2-1/8	LNSOB060404E	LOC060181	LNSOB060405E	LNSOC060182
20 to 33 mm	METRIC COARSE	2-1/2°	15/16 x 2-1/8	LNSOB060406E	LOC060181	LNSOB060407E	LNSOC060182
6 to 18 mm	METRIC FINE	2°	15/16 x 2-1/8	LNSOB060418F	LOC060181	LNSOB060409F	LNSOC060182
20 to 33 mm	METRIC FINE	1-1/2°	15/16 x 2-1/8	LNSOB060412F	LOC060181	LNSOB060413F	LNSOC060182
1/8 to 3/8	TAPER PIPE	2°	15/16 x 2-1/8	LNSOB060416G	LOC060185	LNSOB060513G	LNSOC060186
1/2 to 3/4	TAPER PIPE	1-1/4°	15/16 x 2-1/8	LNSOB060417G	LOC060185	–	–
1/8 to 3/8	STR. PIPE	2°	15/16 x 2-1/8	LNSOB060418H	LOC060183	LNSOB060409H	LNSOC060184
1/2 to 3/4	STR. PIPE	1-1/4°	15/16 x 2-1/8	LNSOB060419H	LOC060183	LNSOB060409H	LNSOC060184



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Enlarge Chaser Holders

Range Inch – (mm)	Chaser Size	Thrds Per In. – (mm)	Maximum Thread Length** Inch – (mm)
1/2" – 4JN			
3/4 to 1 – (20 to 24 mm)	5/8 x 1-1/8	14 – (1.75 mm)	7/8 – (22 mm)
1 to 1-1/4" (24 to 31 mm)	5/8 x 1-1/8	14 – (1.75 mm)	1-5/16 – (33 mm)
13/16 – 13JN			
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 – 10JN			
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 (56 to 72 mm)	15/16 x 2-1/8	12 – (2.5 mm)	1-3/16 or 2-5/8" - (30 or 67 mm*)
2 – 16JN			
2-1/8 to 3 (54 to 76 mm)	15/16 x 2-1/8	8 – (3 mm)	1-5/16 to 2-1/8" - (33 or 54 mm**††)
3-1/8 to 3-3/4 (80 to 96 mm)	15/16 x 2-1/8	8 – (3 mm)	1-5/16 to 2-3/16" - (33 or 56* mm)

* Requires special built-up chaser holders.

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

† 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 enlarge 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.

†† 2-1/8" (54 mm) on 2-1/8" to 2-3/4" diameter and 1-15/16" (49 mm) on 2-7/8" and 3" diameters.

2" 16JN LANDEX – Standard Chaser HoldersK

RANGE	THREAD FORM	HELIX ANGLE	CHASER SIZE	RIGHT-HAND HOLDER PART NO.	GAGE PART NO.	LEFT-HAND HOLDER PART NO.	GAGE PART NO.
3/8 to 1-1/4	UNC	2-3/4°	15/16 x 2-1/8	LNS050634A	L015658	LNSOC022173A	L016105
1-3/8 to 2	UNC	2-1/4°	1-1/4 x 2-3/4	LNS050635A	L015659	LNSOC022174A	LNS16106
1/2 to 5/8	UNF	2°	15/16 x 2-1/8	LNSOC003626B	L015658	LNSOC069520B	L016105
3/4 to 1-1/4	UNF	1-1/2°	15/16 x 2-1/8	LNSOC009770B	L015658	LNSOC030263B	L016105
1-3/8 to 1-1/2	UNF	1-1/4°	15/16 x 2-1/8	LNSOC003051B	L016095	LNSOC039514B	LNS016096
3/8 to 1-1/4	WHIT	2-3/4°	15/16 x 2-1/8	LNS050634C	L015658	LNSOC022173C	L016105
1-3/8 to 2	WHIT	2-1/4°	1-1/4 x 2-3/4	LNS050635C	L015659	LNSOC022174C	LNS016106
1/2 to 11/16	BSF	2-1/4°	15/16 x 2-1/8	LNSOC003625D	L015658	–	–
3/4 to 1-1/4	BSF	2°	15/16 x 2-1/8	LNSOC003626D	L015658	–	–
1-3/8 to 2	BSF	1-3/4°	15/16 x 2-1/8	LNSOC003627D	L016095	–	–
9 to 33 mm	METRIC COARSE	2-3/4°	15/16 x 2-1/8	LNS050634E	L016301	LNSOC022173E	LNS016302
36 to 52 mm	METRIC COARSE	2-1/4°	1-1/4 x 2-3/4	LNS050635E	L0015484	LNSOC022174E	LNS016304
9 to 14 mm	METRIC FINE	2°	15/16 x 2-1/8	LNSOC003626F	L016301	–	–
16 to 33 mm	METRIC FINE	1-1/2°	15/16 x 2-1/8	LNSOC009770F	L016301	–	–
36 to 52 mm	METRIC FINE	3/4°	15/16 x 2-1/8	LNSOC111947F	LNS017582	–	–
1/4 to 3/4	TAPER PIPE	1-3/4°	15/16 x 2-1/8	LNS019826G	L016099	–	–
1 to 2***	TAPER PIPE	1°	1-1/4 x 2-3/4	LNS019827G	L016100	–	–
1 to 1-1/4*†	TAPER PIPE	1°	1-1/4 x 2-3/4	LNS019827G1	L016100	–	–
1-1/2 to 2*†	TAPER PIPE	1°	1-1/4 x 2-3/4	LNS019827G2	L016100	–	–
1/4 to 3/4	STR. PIPE	1-3/4°	15/16 x 2-1/8	LNSOC009063H	L0007109	–	–
1 to 2	STR. PIPE	1°	15/16 x 2-1/8	LNSOC098476H	L0013394	–	–

* Except where noted, chaser holders normally are turned to 7-3/16" diameter based on the maximum threading diameter of the holders in the open position. Holders can be turned to 6-15/16" diameter (the O.D. of the head) if required. However, this can affect capacity and could possibly require two sets of holders to allow full range to be obtained.

** When these holders are turned to the 6-15/16" diameter of the head, two sets are required:

One for 1" to 1-1/4" pipe and one for 1-1/2" to 2" pipe

† Holders turned to 6-15/16" diameter based on the maximum threading diameter of holders in the open position.

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