

Tangential (Landis type) Die heads



F TYPE LANDMATIC

Landis are the most commonly used tangential die heads. They are preferred for threading tube as the chasers cut at a tangent to the workpiece thus imparting little or no crushing pressure, unlike Coventry type die heads which cut radially. Another advantage is that they have no front plate so threads can be cut very close to a shoulder. If one chaser is chipped it can be reground alone, whereas with Coventry type chasers the whole set would have to be reground.

Landis die heads are very much more expensive than Coventry.

There is a large range of Landis die heads but their use has declined. The F type Landmatic seems to be the most popular so the information given is based on that head. Please refer to our pdf extracts from the Landis handbook. If you do not find the information required please contact us.

Tangential Chasers

The following table lists the chaser sections that we stock and Landis die heads that they can be used in. The list is not exhaustive, other chaser sections and die heads exist. For more information please enquire. We can produce chasers to any section.

CHASER SECTION	DIE HEAD APPLICABLE
5/8x1.1/8	LANDMATIC 5/8" A, F, H, HH, DX, EXX, 5EX LANCO 3/8" R LANDEX 1/2" J, JX, JN
3/4x1.5/8	LANDMATIC 7/8" A, F, H LANCO 9/16" R, 5/8" V, VVV LANDEX 13/16" J, JX, JN, 7/8 L, LL, LLL
15/16x2.1/8	LANDMATIC 1.1/4" A, F, H, 2" A, F (3-33mm blocks)* LANCO 3/4" R, 7/8" V, 7VN2 LANDEX 1.1/4" L, J, JX, JN, 2" JX, JN (3-33mm blocks)*
1.1/4x2.3/4	LANDMATIC 2" A, F (36 - 52mm blocks)* LANCO 1" R LANDEX 2" J, JX, JN (36 - 52mm blocks)*
1.7/64x4	LANCO 1.1/2" R, 2" R, 2.1/2" R, 4"R (selected blocks)*
1.3/64x3	LANDMATIC 2" H (4.5 - 33mm blocks)* LANCO 1" V, 1.1/2" R, 2" R, 2.1/2" R (selected blocks)*
1.3/64x4	LANCO 1" V, 1.1/2" R, 2" R, 2.1/2" R (selected blocks)*
1.1/2x5	LANCO 2" R, 2.1/2" R, 4" R (selected blocks)*

* Some die heads have different chaser blocks to cover parts of the capacity range. Different chaser sections are required for the different blocks. If in doubt please enquire.