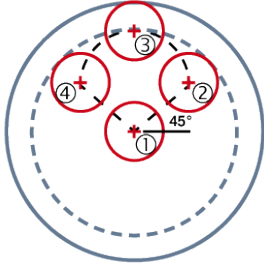


Series 180, 181, 180M, 181M, 182, 184, 185, 186, 186M, 187, 189

## Thread Mill

### Programming Example

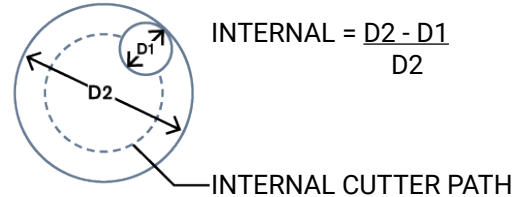


This example will produce an internal right hand thread

- Position to ① (centerline of thread)
- GO 1 to desired Z depth
- GO 1 to ②
- GO 3 to ③ (while Z moves up 1/8 pitch)
- GO 3 to ③ (while Z moves up 1 pitch)
- GO 3 to ④ (while Z moves up 1/8 pitch)
- GO 1 to ①
- Retract from hole

### Feed Rate Compensation

To obtain the correct feed rate for the centerline of the tool, multiply the desired feed rate at the cutting edge by the appropriate factor.



D1 = TOOL CUTTING DIAMETER

D2 = THREAD DIAMETER

## Recommended Speeds & Feeds

	SFM				Feed (Inches/Tooth)						
	Uncoated	TiALN	ALCrN	ZrN	3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"
<b>Aluminum</b>	400-800	-	-	600-1400	0.0005	0.0008	0.0012	0.0015	0.0020	0.0025	0.0030
<b>Brass</b>	200-400	-	-	400-800	0.0005	0.0008	0.0012	0.0015	0.0020	0.0025	0.0030
<b>Cast Iron</b>	150-250	200-400	220-440	-	0.0004	0.0005	0.0006	0.0007	0.0010	0.0015	0.0020
<b>Carbon Steel</b>	150-250	250-500	275-550	-	0.0004	0.0005	0.0006	0.0007	0.0010	0.0015	0.0020
<b>Stainless Steel</b>	100-150	150-400	165-440	-	0.0004	0.0005	0.0006	0.0007	0.0010	0.0015	0.0020
<b>High Temp Alloy</b>	50-100	80-150	90-165	-	0.0004	0.0006	0.0007	0.0008	0.0009	0.0010	0.0012
<b>Titanium</b>	50-125	80-250	90-275	-	0.0003	0.0004	0.0005	0.0006	0.0007	0.0008	0.0010