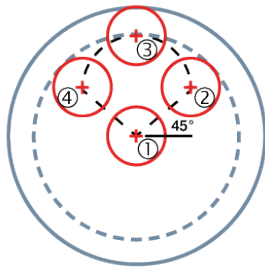


Thread Mill Programming Example

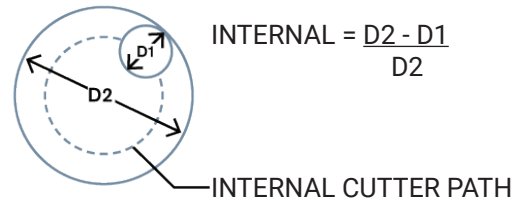


This example will produce an internal right hand thread

- 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"
Aluminum	400-800	-	-	600-1400	0.0005	0.0008	0.0012	0.0015	0.0020	0.0025	0.0030
Brass	200-400	-	-	400-800	0.0005	0.0008	0.0012	0.0015	0.0020	0.0025	0.0030
Cast Iron	150-250	200-400	220-440	-	0.0004	0.0005	0.0006	0.0007	0.0010	0.0015	0.0020
Carbon Steel	150-250	250-500	275-550	-	0.0004	0.0005	0.0006	0.0007	0.0010	0.0015	0.0020
Stainless Steel	100-150	150-400	165-440	-	0.0004	0.0005	0.0006	0.0007	0.0010	0.0015	0.0020
High Temp Alloy	50-100	80-150	90-165	-	0.0004	0.0006	0.0007	0.0008	0.0009	0.0010	0.0012
Titanium	50-125	80-250	90-275	-	0.0003	0.0004	0.0005	0.0006	0.0007	0.0008	0.0010