

NAME \_\_\_\_\_ COMPANY \_\_\_\_\_ PHONE \_\_\_\_\_

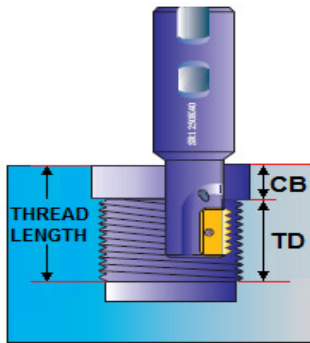
DIST. \_\_\_\_\_ SALESMAN \_\_\_\_\_ PHONE \_\_\_\_\_

APPLICATION: PITCH \_\_\_\_\_ DIA \_\_\_\_\_ THREAD LENGTH \_\_\_\_\_

INTERNAL  MATERIAL \_\_\_\_\_ HARDNES \_\_\_\_\_ Rc

COOLANT  BLIND HOLE  NUMBER OF STARTS \_\_\_\_\_

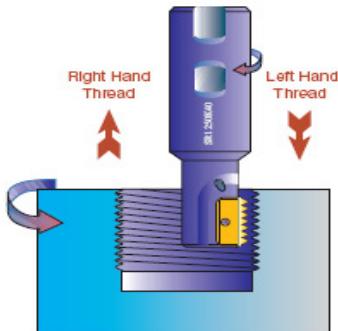
OTHER \_\_\_\_\_



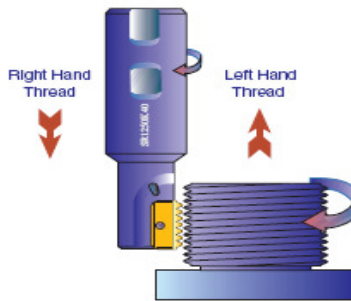
### Thread Length

When calculating the thread length (TL) the counter bore (CB) and chamfer depths need to be added to the Thread Depth (TD)

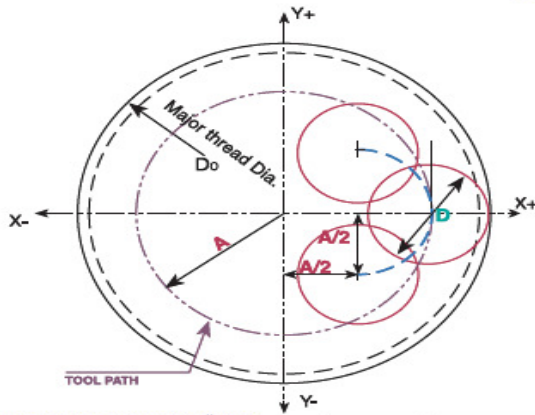
### Internal Thread



### External Thread



## Thread Milling CNC Program for Internal Threading



Right hand thread (climb milling) from bottom up.  
 Program is based on tool center.  
 This method of programming needs no tool radius compensation value other than an offset for wear.

$A = \frac{D_0 - D}{2}$	A = Radius of tool path. D <sub>0</sub> = Major thread dia. D = Cutting dia.
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