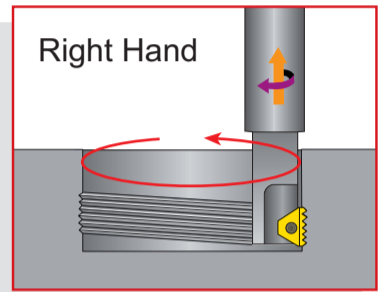
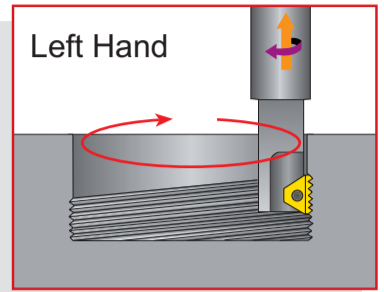
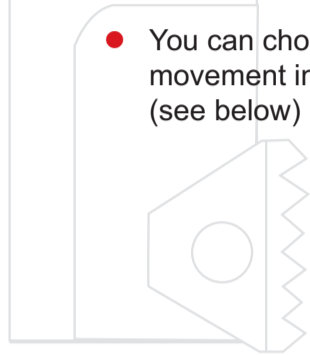


**Tip 1**

**Use the same Thread Milling tools to make both Left-hand and Right-hand threads**

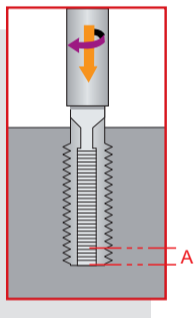
- By simply reversing the tool cutting direction, you can generate left or right-hand threads with the same holder and insert. The direction of the tool rotation around itself remains the same.
- You can choose the best tool and generate the correct tool movement in your CNC program using the Vargus TM Gen. (see below)



**Tip 2**

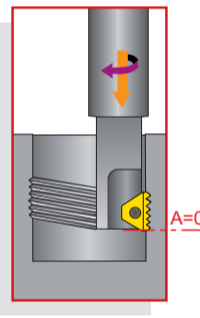
**Control the thread length more easily when thread milling**

**Problem: Uncontrolled thread length**



When threading short, blind holes with a tap, it is difficult to control the exact thread length. When the tap reaches the end of the thread it stops and reverses direction. During the short time it takes for the machine to fully stop, the tap has moved forward an uncontrolled length (A). In blind holes this often causes taps to break.

**Solution: Use a Thread Milling tool**



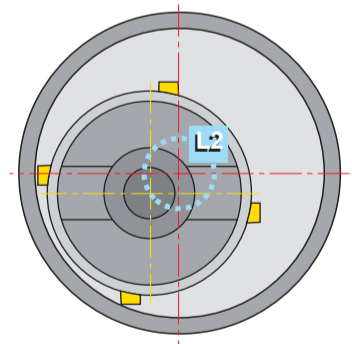
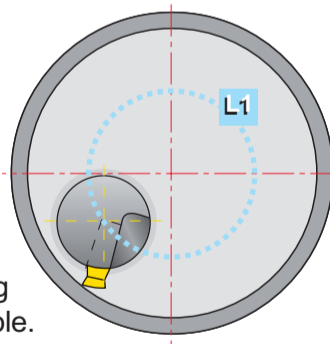
- Using thread milling, you can control the exact point at which the tools stops, even while the tool continues to rotate. This enable you to determine the exact desired thread length.

**Tip 3**

**Use the largest possible Thread Mill tool for long threads**

What are the advantages?

- Shorter movements – larger tools need to travel shorter distances ( $L1 > L2$ ), minimizing machining time.
- Larger tools have more flutes and cutting edges, thus faster feed rates are possible.
- Larger tools have better rigidity, thus obtain better thread quality and longer tool life.



**For the best Thread Milling CNC Programming, use VARDEX TM Gen software utilities. Ask for your free CD today.**



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