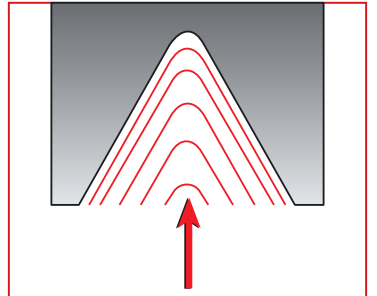


## Tip 1

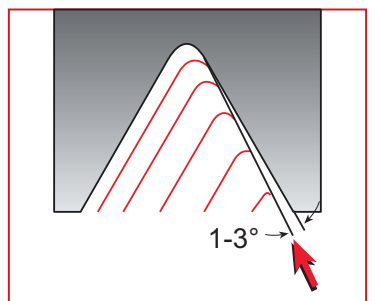
Use **FLANK INFEEED** to reduce load and chattering

- The flank infeed method **reduces machine load and chatter** by minimizing the contact area with the workpiece. Therefore it is recommended when:
  - thread pitch is greater than 1.5mm (16TPI);
  - threading Trapeze and Acme profiles, both with large contact areas and load.
- The flank infeed method **provides excellent chip control** as chips flow away from, not toward the tool. This prevents chip tangling, especially in internal applications.
- Try the **modified flank infeed method** by approaching the material with an angle of 1-3 degrees for better surface quality and reduced wear.

Radial Infeed



Flank Infeed (modified)



## Tip 2

Use the correct Anvil for an optimal cut

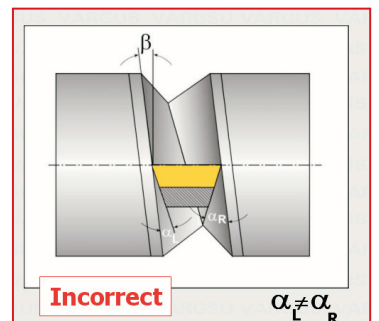
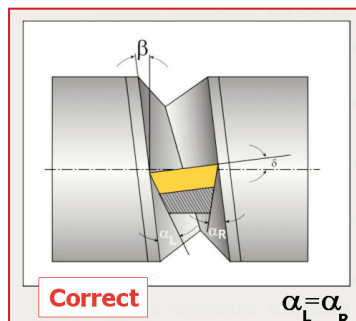
The Anvil should always match the thread helix angle

Use the correct anvil to achieve:

- equal flank clearance;
- equal load on both sides of insert profile.

The result:

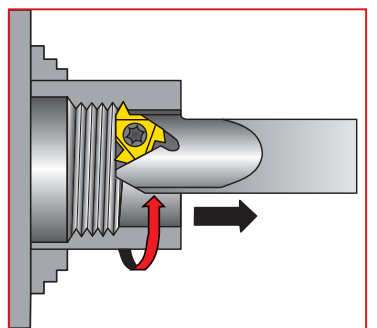
- optimal distribution of cutting load;
- longer tool life.



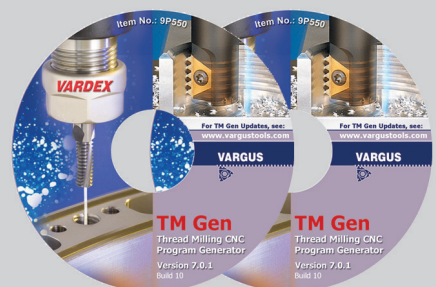
## Tip 3

Machine **outwards, from chuck to tail**, when machining internal threads

Chip flow problems are common when machining internal threads. Entangled chips cause reduced tool life, poor surface finish and even tool breakage. Therefore, when machining internal threads, machine outward - toward the hole opening.



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