

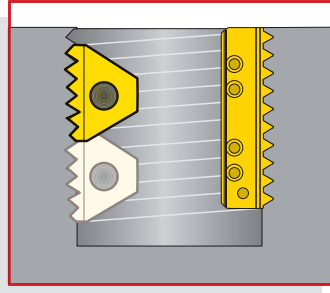
## Tip 1

Use the new MITM thread mills to reduce machining time

**Problem:**  
Machining time is too long in a mass-production threading operation.

- Multiple flute tool holders allow you to increase feed rates significantly as you increase the number of cutting edges.
- Use longer threading inserts to reduce the number of passes, especially when machining long threads.

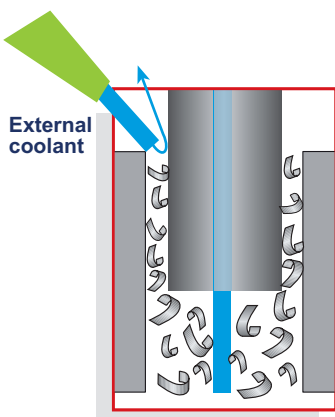
**Solution:**  
Use the new MITM thread mill with multiple flutes and longer inserts.



## Tip 2

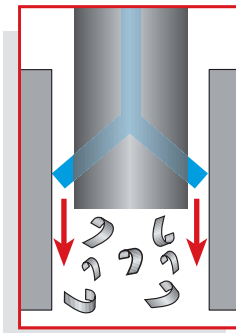
In thru-hole applications, use solid thread mills with radial coolant exits

**Problem:**  
Poor evacuation of chips when threading thru-holes reduces tool life.



Coolant thru-the-tool in axial direction

**Solution:**  
Use solid threadmilling tools with radial coolant through.



Coolant thru-the-tool in radial direction



- In thru-hole applications, the axial coolant flows out, having no effect on chip evacuation.

- Radial coolant shoots laterally, directly to the cutting area, effectively forcing the chips down and out of the hole.

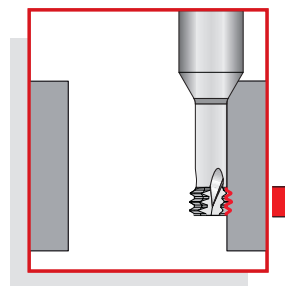
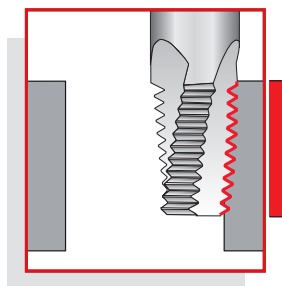
## Tip 3

Thread mills with fewer teeth reduce machine load

**Problem:**  
Machine load is too high when threading hard materials.

**Solution:**  
Use a tool with fewer teeth to reduce contact with workpiece.

- Requires less power and reduces the load on the tool
- Increases tool life
- Improves surface quality



For the best Thread Milling CNC Programming, use VARDEX TM Gen software utilities.

For a free copy of TM Gen software, go to [www.vargus.com](http://www.vargus.com)



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