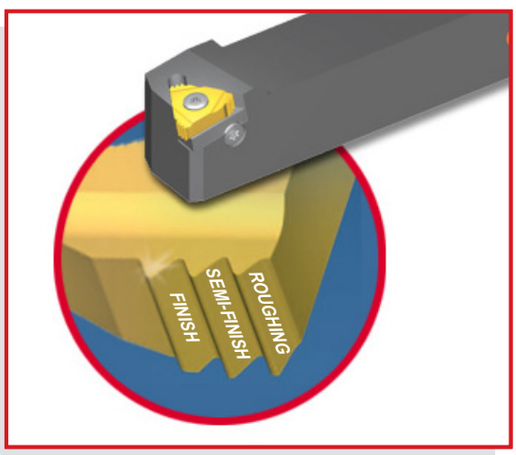
VARDEX Tips
Making Threading Easy
Thread Milling Tips
Issue 5, December 2005

Tip 1 — Increase productivity - Use a threading insert with multiple teeth in mass production

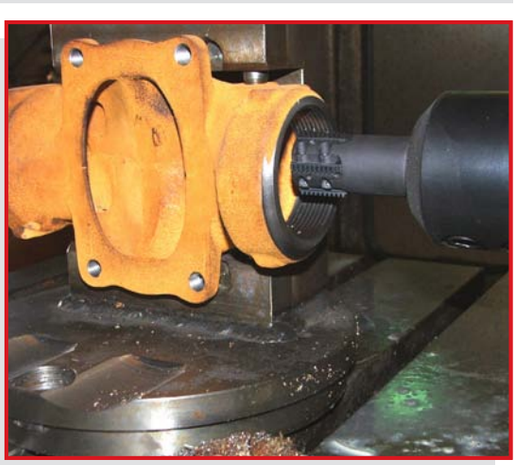
- The first teeth do the rough machining of the thread, leaving a minimal amount of material for the last tooth to complete the operation. This results in high productivity and long tool life.
- The multi-tooth design dramatically reduces the number of passes needed (standard number of passes for a single-tooth insert divided by the number of teeth), resulting in reduced machining time and INCREASED PRODUCTIVITY!!



Tip 2 — Use Thread Milling tools to machine threads on large and non-symmetrical components.

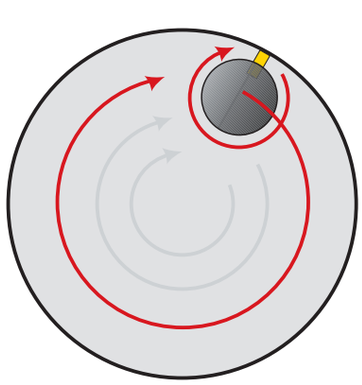
- Machining threads on non-symmetrical workpiece in turning machines requires complicated clamping and balancing to avoid machine vibration.

  On milling machines, it is the Thread Mill, not the workpiece, that rotates fast, eliminating the need to balance the workpiece.
- Even small milling machines have relatively large tables, making it possible to clamp large components.



Tip 3 — Save tooling costs! To machine a wide variety of thread diameters use just one thread mill instead of a large number of taps.

- When threading with taps, every different diameter requires a different tap. When there are a large number of holes to thread, this translates into lots of taps…
- In Thread Milling, the thread diameter is created by a circular movement around the component. Thus, by just changing the CNC program, many different thread diameters can be made using the same Thread Milling tool, SAVING TOOLING COSTS!!.



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

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