

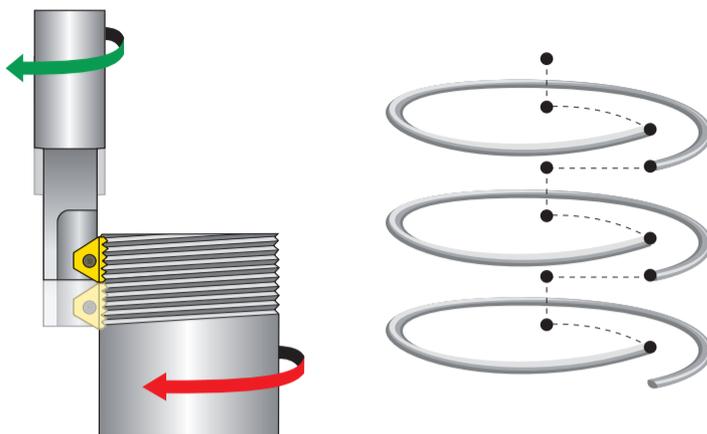
Tip 1

When thread milling a long thread, use the Axial Divided tool movement method

Advantages: If the thread is considerably longer than the insert, the tool must complete several revolutions to form the full thread length. With the Axial Divided method, each time the tool orbits, the insert mills a section of thread equal to the maximum length of the insert. So you save valuable machining time!

Axial Divide Step by Step:

- 1st revolution - create a thread equal in length to the insert
- Move the tool to the center of the hole
- Move up axially the length of the insert, less 1 pitch for overlapping
- Re-enter the material and continue each revolution as above until the thread is completed



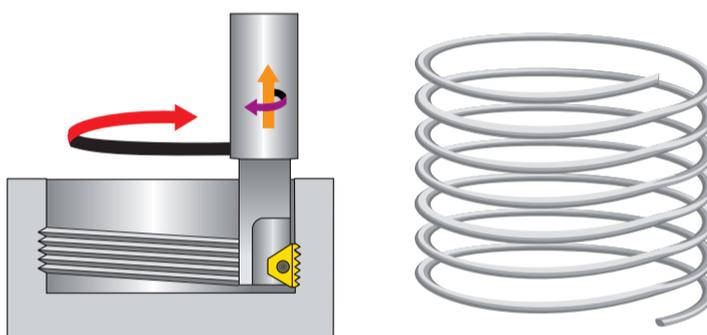
Tip 2

When thread milling a thread that is only 2 pitches longer than the insert, use the Continuous Cutting Path method

Advantages: Cycle time is shorter as the tool remains in the material continuously, without returning to the center, and advances one pitch per revolution

Continuous Cutting Path Step by Step:

- 1st revolution - create a thread equal in length to the insert
- 2nd revolution - continue cutting while advancing 1 pitch
- Repeat the second step until the thread is complete



Tip 3

Threading very small holes? Use MilliPro thread mills in continuous path method

Advantages:

- **Longer tool life!** Repeatedly stopping and starting cutting increases the risk of thermal shock and tool breakage. When the thread mill is in constant contact with the part, the temperature and load remains constant and tool life is extended
- **Faster machining time!** Time is wasted each time a thread mill leaves and returns to the part. Therefore, when machining small - diameter parts and the cutter has a small number of teeth, the cycle will be completed faster in one continuous motion



TM GEN CNC software provides both Continuous Cutting Path and Axial Divided tool movement options. And it automatically shows you the difference in machining time!

For tool selection and cutting data in Thread Turning applications use our **TT Gen**.
For the best Thread Milling CNC Programming, use **VARDEX TM Gen** software utilities.
For free copies, go to www.vargus.com



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