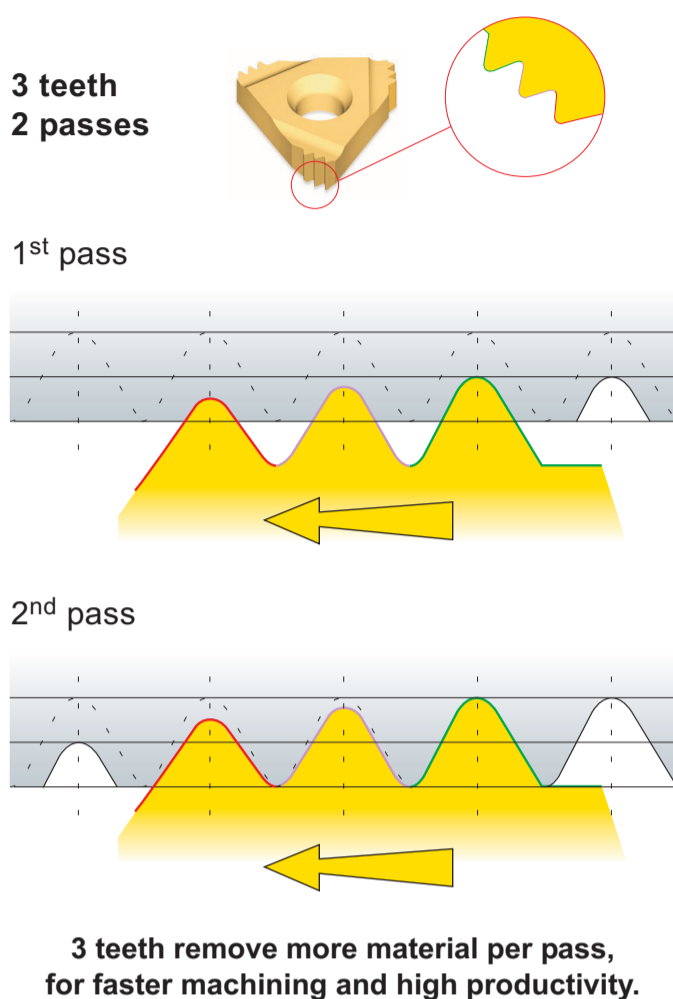
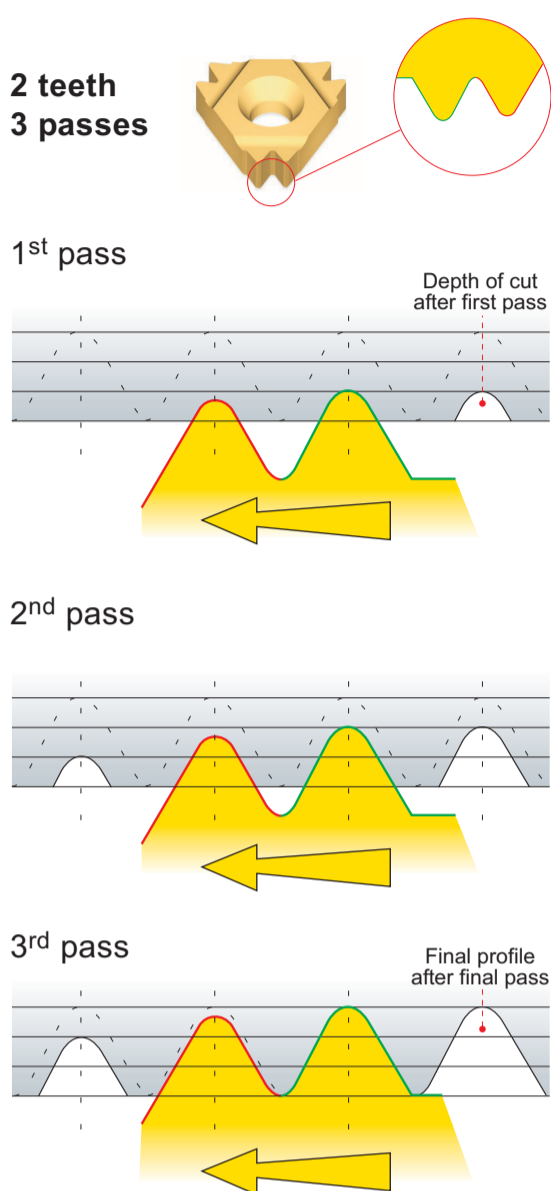


Tip 1 How do Multi-tooth inserts work?

Multi-tooth inserts have a series of teeth on the corner or face of the insert - each tooth successively larger than the previous one. The first teeth are for roughing and semi-finishing, and they remove the most material. The last tooth

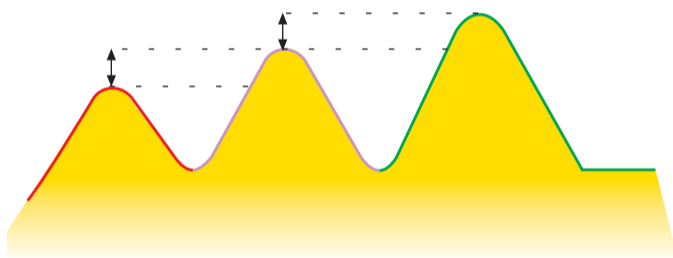
is designed to finish the thread to the desired dimensions, according to the thread standard. Since there are multiple teeth, more material is removed per pass, and fewer passes are needed to machine the thread.



Tip 2 What is the difference between Multi-tooth and improved Multi+ inserts?

VARGUS improved the Multi-tooth inserts and introduced Multi+, a new line of threading inserts for high volume production. The redesigned Multi+ inserts feature better tooth geometry to optimize the distribution of cutting forces. As a result, Multi+ inserts provide:

- Increased productivity
- Reduced cycle time
- Better surface finish
- Longer tool life!



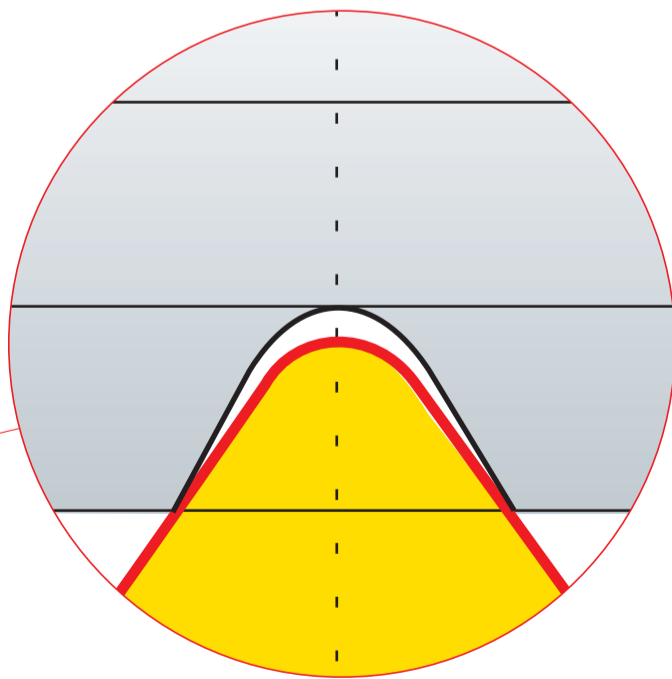
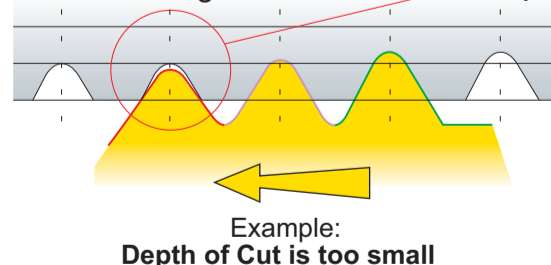
For best performance, use the cutting conditions provided in the Multi+ catalog or VARDEX TT Gen software*, both available from: www.vargus.com

Tip 3 For optimal operation, use the Depth of Cut recommended for your applications

If the Depth of Cut per pass is **too large**, the first tooth will be overloaded, resulting in high wear and reduced tool life. In extreme cases, the tooth may even break.

If the depth of cut is **too small**, in effect the first tooth does not cut at all. As a result, the number of passes must be increased and you don't achieve the full benefit from multi-tooth inserts.

For the correct Depth of Cut and optimal distribution of cutting forces, see the Multi+ catalog or VARDEX TT Gen*.



*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

