

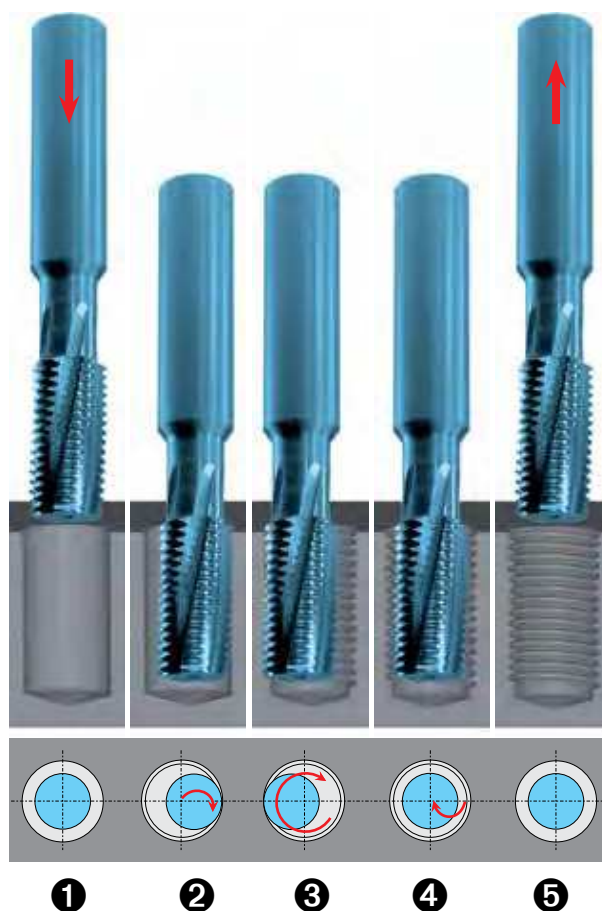
Technical Information

Universal thread milling cutter Type TMU SP - 1 milling cycle

Machine example

Coating:	bright
Thread:	M24
Pitch:	1.5 mm
Thread depth:	24 mm / M16x1.5

Tool material:	Cast Aluminum
Cutting speed:	220 m/min
Feed per tooth:	0.15 mm
Cutting time:	1.7 s



Programming example:

CNC Code:	Plain text
N10 M6T1	Tool call
N20 G90 G54 G00 X0.000Y0.000	Work offset
❶ N30 Z2.000 S3199 M3 D1	Positioning centered on start position above tapping size hole and spindle speed call-up
N40 G00 Z-21.725	Rapid movement to thread milling start position centered in tapping size hole
N50 G91	Switch to incremental
N60 G42 G01 X0.000Y4.975 F1000	Cutter radius compensation on
❷ N70 G02 X0.000Y10.975 I0.000 J-5.488 Z-0.263 F87	180° entry cycle, start of thread milling
❸ N80 G02 X0.000Y0.000 I0.000 J6.000 Z-1.750 F175	360° thread milling cycle with axial movement of the thread pitch in Z-direction
❹ N90 G02 X0.000Y10.975 I0.000 J5.488 Z-0.263 F350	180° withdrawal cycle to the thread center, end of thread milling
N100 G40 G01 X0.000Y-4.975 F1000	Cutter radius compensation off
N110 G90	Switch to absolute
❺ N120 G80 G53 G00 Z2.000	Withdrawal from hole to start position centered above tapping size hole
N130 M30 M95	End