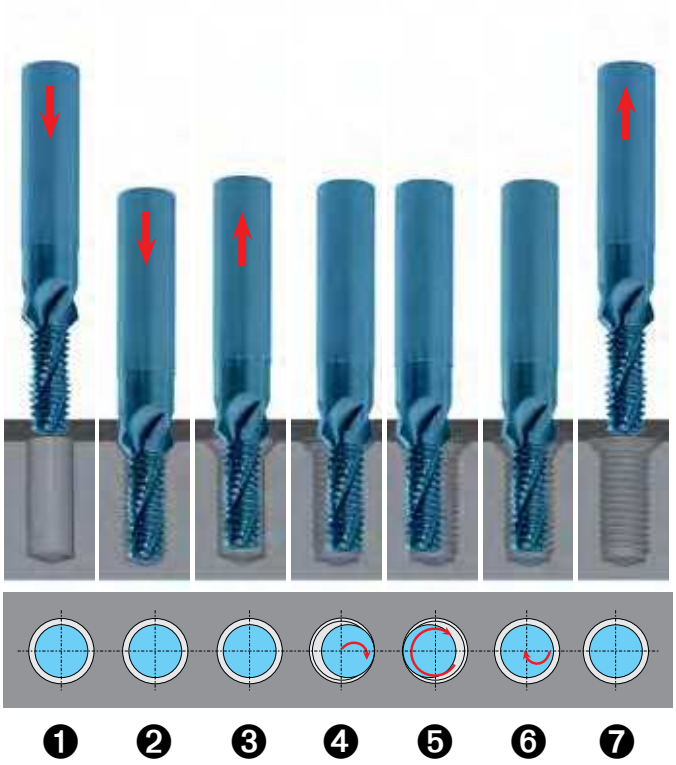
Technical Information

Thread milling cutters with countersinking step
Type TMC SP

Machine example

Coating:	TiCN
Thread:	M16
Pitch:	1.5 mm
Thread depth:	40 mm / M16x1.5

Tool material:	5120 Alloyed Steel
Cutting speed:	100 m/min
Feed per tooth:	0.06 mm
Cutting time:	6.4 s



Programming example:

	CNC Code:	Plain text
	N10 M6T1	Tool call
	N20 G90 G54 G00 X0.000Y0.000	Work offset
❶	N30 Z2.000 S497 M3 D1	Positioning centered on start position above tapping size hole and spindle speed call-up
	N40 G00 X0.000Y0.000 Z-41.300	Rapid movement to countersinking start position
❷	N50 G01 X0.000Y0.000 Z-43.200 F119	Countersinking of 90° chamfer
❸	N60 G00 Z-38.050 S2487	Rapid movement to thread milling start position centered in tapping size hole
	N70 G91	Switch to incremental
	N80 G42 G01 X0.000Y6.400 F1000	Cutter radius compensation on
❹	N90 G02 X0.000Y-14.400 I0.000 J-7.200 Z-0.225 F60	180° entry cycle, start of thread milling
❺	N100 G02 X0.000Y0.000 I0.000 J8.000 Z-1.500 F119	360° thread milling cycle with axial movement of the thread pitch in Z-direction
❻	N110 G02 X0.000Y14.400 I0.000 J7.200 Z-0.225 F239	180° withdrawal cycle to the thread center, end of thread milling
	N120 G40 G01 X0.000Y-6.400 F1000	Cutter radius compensation off
	N130 G90	Switch to absolute
❼	N140 G80 G53 G00 Z2.000	Withdrawal from hole to start position centered above tapping size hole
	N150 M30 M95	End