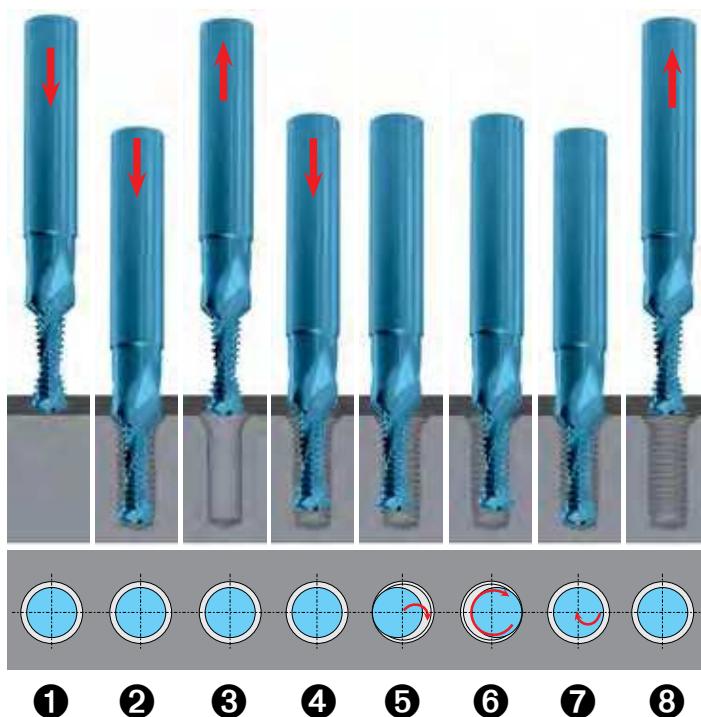


Technical Information

Drill/thread milling cutter Type DTMC SP

Machine example

Coating:	bright	Tool material:	Cast Iron
Thread:	M8	Cutting speed:	100 m/min
Pitch:	1.25 mm	Feed per tooth:	0.06 mm
Thread depth:	16 mm / 2 x D	Cutting time:	5.3 s



Programming example:

CNC Code:	Plain text
N10 M6 T1	Tool call
N20 G90 G54 G00 X0.000 Y0.000	Work offset
① N30 Z2.000 S5013 M3 D1	Positioning centered on start position above tapping size hole and spindle speed call-up
N40 G01 X0.000 Y0.000 Z-1.000 F251	Centering at half the feed rate
② N50 X0.000 Y0.000 Z-19.825 F501	Drilling the tapping size hole and countersinking 90° chamfer
③ N60 G00 X0.000 Y0.000 Z0.000 S5013	Withdrawal of tool from the hole for pecking
④ N70 Z-14.375	Rapid movement to thread milling start position centered in tapping size hole
N80 G91	Switch to incremental
N90 G42 G01 X0.000 Y3.175 F1000	Cutter radius compensation on
⑤ N100 G02 X0.000 Y-7.175 I0.000 J-3.588 Z-0.188 F62	180° entry cycle, start of thread milling
⑥ N110 G02 X0.000 Y0.000 I0.000 J4.000 Z-1.250 F124	360° thread milling cycle with axial movement of the thread pitch in Z-direction
⑦ N120 G02 X0.000 Y7.175 I0.000 J3.588 Z-0.188 F248	180° withdrawal cycle to the thread center, end of thread milling
N130 G40 G01 X0.000 Y-3.175 F1000	Cutter radius compensation off
N140 G90	Switch to absolute
⑧ N150 G80 G53 G00 Z2.000	Withdrawal from hole to start position centered above tapping size hole
N160 M30 M95	End