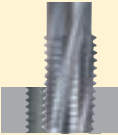
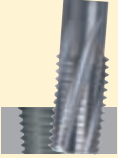
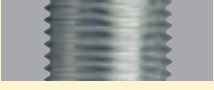
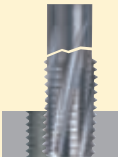



Application problems with new thread milling cutters

Problem	Possible causes	Solution
1 Thread produced is too large or too small 	<ul style="list-style-type: none"> Incorrect radius in CNC program and therefore milling of incorrect circle 	<ul style="list-style-type: none"> Correct milling radius until thread is dimensionally correct
2 Thread not cylindrical 	<ul style="list-style-type: none"> Feed rate too high Synchronous milling path with long threads 	<ul style="list-style-type: none"> Reduce feed rate Modify milling direction to opposite direction
3 Thread surface not according to requirements, chatter marks 	<ul style="list-style-type: none"> Cutting speed too high Insufficient tool or workpiece clamping 	<ul style="list-style-type: none"> Adjust cutting speed Check tool and workpiece clamping
4 Tool breakage 	<ul style="list-style-type: none"> CNC program error Cutting rates too high 	<ul style="list-style-type: none"> Check CNC program Adjust cutting rates
5 Tool life insufficient	<ul style="list-style-type: none"> Cutting rates too high Tool applied uncoated Insufficient lubrication and chip evacuation 	<ul style="list-style-type: none"> Adjust cutting rates Apply coated tool Improve lubrication, coolant delivery via the spindle
6 Tool breakage with drill/milling cutter 	<ul style="list-style-type: none"> Chip problems when drilling Feed rates too high when drilling 	<ul style="list-style-type: none"> Apply tool with IC Incorporate pecking cycles