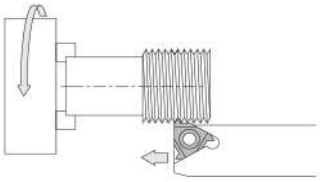
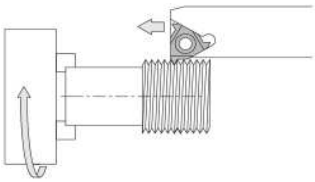
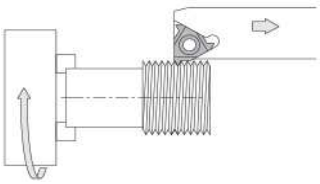
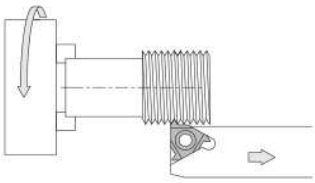
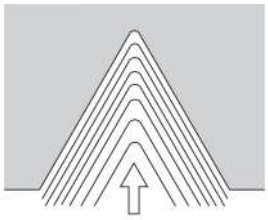
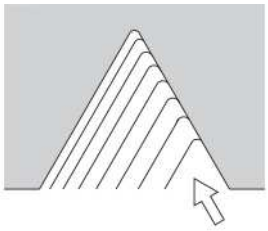
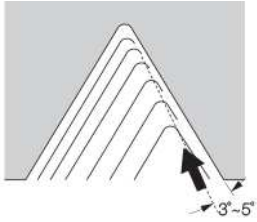
Internal threading tool holder and the method of cutting "External Thread"

External Threading			
Right-Hand Thread		Left-Hand Thread	
Toolholder	(L) L-hand	Toolholder	(R) R-hand
Insert	(L) L-hand	Insert	(R) R-hand
The direction of spindle revolution	M03	The direction of spindle revolution	M04
			
Toolholder	(R) R-hand	Toolholder	(L) L-hand
Insert	(R) R-hand	Insert	(L) L-hand
The direction of spindle revolution	M04	The direction of spindle revolution	M03
			

• Use Inserts with Partial Profile.

Infeed Methods

Infeed Methods	Features
 Radial Infeed	• The cutting edge moves toward the center of the workpiece every pass. • Suitable for relatively small pitch size threading. • V-shape chips are generated and chip control may be difficult depending on workpiece material. • Chips prevent coolant from reaching tool tip causing poor tool life.
 Flank Infeed	• Used for large pitch size threading. • No DOC on right side of the figure causes insert wear and on materials that work harden will cause hardening of this surface. • Chips flow to one side.
 Flank Compound Infeed	• Recommended method to reduce work hardening and improve insert life. • 3-5 degrees for steel and up to 12 degrees for stainless materials. • Chips flow to one side allowing coolant to reach insert tip. • This method is recommended to threading by 2-thread insert.