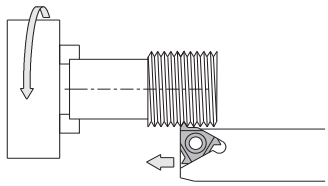
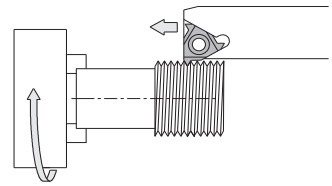
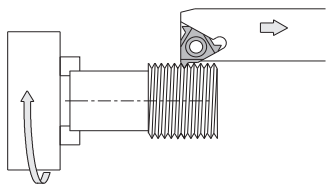
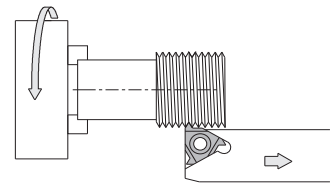
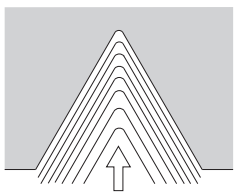
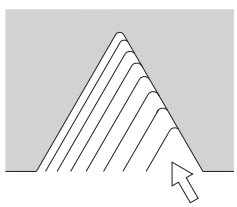
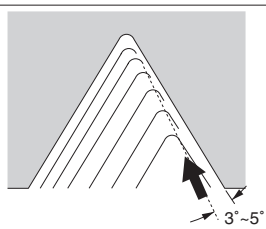
Internal threading tool holder and the method of cutting “External Thread”

External Threading

R-hand Thread			L-hand Thread		
Toolholder	L-hand		Toolholder	R-hand	
Insert	L-hand		Insert	R-hand	
The direction of spindle revolution	M03		The direction of spindle revolution	M04	
Toolholder	R-hand		Toolholder	L-hand	
Insert	R-hand		Insert	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 most common threading method. 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.
 Flank Infeed	• Suitable for large pitch size threading. • The wear on the right side edge of the figure (no ap) tends to become greater. • Chips flow to one side.
 Flank Compound Infeed	• Revised compound methods of the above flank infeed method. • No “No ap.” condition. • Chips flow to one side. • This method is recommended to threading by 2-thread insert.