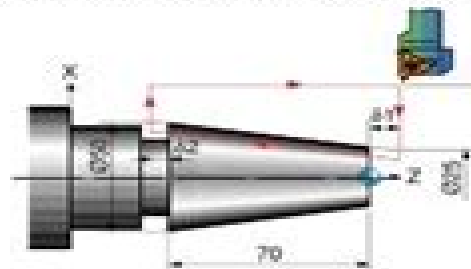


Example 1) STRAIGHT lead

G32 X(w) Z(w) F : Because it is taper, it is applied to both axis at the same time.



Lead of screw : 3mm

Δ1 : 5mm

Δ2 : 1.5mm

Depth of cut : 1mm(2cut two times)

(ABSOLUTE)

G50 S800 T0100 :

G97 S800 M03 :

G00 X90.0 Z5.0 T0101 :

X22.026 :

G32 X49.562 Z-71.5 F3.0 :

G00 X90.0 :

Z5.0 :

X21.052 :

G32 X48.588 Z-71.5 :

G00 X90.0 :

Z5.0 :

X150.0 Z150.0 T0100 :

M30 :

(INCREMENTAL)

G50 S800 T0100 :

G97 S800 M03 :

G00 X90.0 Z5.0 T0101 :

U-67.974 :

G32 U27.321 W-76.5 F3.0 :

G00 U40.438 :

W76.5 :

U-68.948 :

G32 U27.321 W-76.5 :

G00 X90.0 :

W76.5 :

X150.0 Z150.0 T0100 :

M30 :

Reference)

Values of incomplete thread Δ1 and Δ2.

$$\Delta 1 = \frac{3.6 \times L \times n}{1800}$$

L = Lead of thread
n = Rotating time of main spindle

$$\Delta 2 = \frac{L \times n}{1800}$$

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PT Brinkman



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Machinery Buyers' Guide ,1999 **Thomas Register of American Manufacturers** ,2003 Vols for 1970 71 includes manufacturers catalogs **Containerisation International** ,2000 **Operator's Organizational, Direct Support, and General Support Maintenance Manual Including Repair Parts and Special Tools List (including Depot Maintenance Repair Parts and Special Tools): Operation, installation, and reference data** ,1988 OPERATOR, UNIT AND DIRECT SUPPORT MAINTENANCE MANUAL (INCLUDING REPAIR PARTS AND SPECIAL TOOLS LIST)..., TECHNICAL MANUAL... TM 9-6115-667-1 ,2004* **Operator and Unit Maintenance Manual (including Repair Parts and Special Tools List)** ... ,1988 Organizational Maintenance Manual ,1987 **Basic Maintenance Manual** ,1944

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