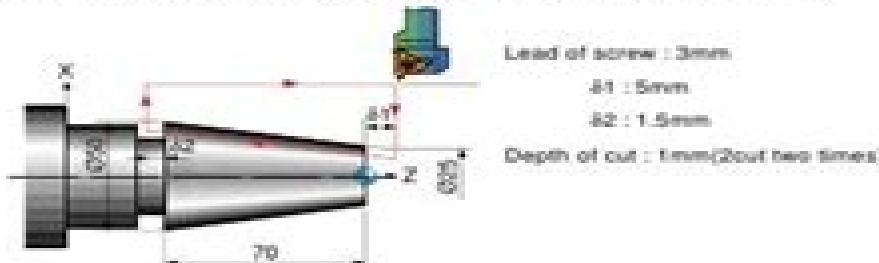


Example 1) STRAIGHT lead

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



(ABSOLUTE)

G50 S500 T0100 :

G97 S500 M03 :

G00 X90.0 Z5.0 T0101 :

X22.625 :

G32 X49.562 Z-71.5 F3.0 :

G00 X90.0 :

Z5.0 :

X21.652 :

G32 X48.588 Z-71.5 :

G00 X90.0 :

Z5.0 :

X150.0 Z150.0 T0100 :

M30 :

(INCREMENTAL)

G50 S500 T0100 :

G97 S500 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 $\delta 1$ and $\delta 2$.

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

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 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): Scheduled maintenance ,1988 Operator, Organizational, and Intermediate (direct Support and General Support) Maintenance Manual (including Repair Parts and Special Tools List) ,1976 Operator's, Organizational, Direct Support and General Support Maintenance Manual (including Repair Parts and Special Tools Lists) ,1985 Operator's and Organizational Maintenance Manual, Including Repair Parts and Special Tools List ,1990 TECHNICAL MANUAL, OPERATOR'S AND UNIT MAINTENANCE MANUAL, INCLUDING REPAIR PARTS AND SPECIAL TOOLS LIST FOR MODULAR GENERAL..., TM 10-8340-2 ,2002* Operator's, Organizational and Direct Support Maintenance Manual ,1980 Direct Support and General Support Maintenance Manual: Maintenance ,1980 Operator, organizational, direct support, and general support maintenance manual ,1986 Operator's, Organizational, and Direct Support Maintenance Manual Including Repair Parts and Special Tool Lists ,1986 Organizational Maintenance Manual ,1960 Operator, Organizational, and Direct Support Maintenance Manual (including Depot Maintenance Repair Parts and Special Tools List) ,1974 Operator and Aviation Unit Maintenance Manual Including Repair Parts and Special Tools List for Instrument Display System Line Test Set 476-853, NSN 4920-01-112-5906 ,1986

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