



Thread Milling Programme Generator Instructions

All dimensions must be entered in millimetres. In the example below, 1/2" BSP = 20.955mm O.D.

From top 3 dropdown menus:

- Select programming language.
- Select operation type, i.e. thread milling, but can be thread milling and chamfering for example.
- Select thread form, in this instance BSP.

Alter text in red, for 1/2" BSP dimension:

- Thread Diameter 20.955mm
- Pitch 14TPI
- Thread length is depth of thread required
- Safety distance is distance from rapid plane to work piece.

Select material to be cut, for example Low Carbon Steel.

Suitable tools will be shown in the next dropdown menu, for BSP only one, but multiple tools will be shown where applicable. Select the tool required and the programme and parameters will be generated.

Other parameters can be altered in the dotted boxes, for example more than one pass, but it's advisable not to alter anything else unless you have had special tools made.

Programing of Thread Milling

Internal Thread Milling in Machining Center

Fanuc

Thread Milling


BSP(G) - Whitworth Pipe Thread

D = Thread Diameter (mm)	20.955
P = Pitch (TPI)	14
L = Thread Length (mm)	10.00
S = Safety Distance (mm)	3.0

Steel, Low Carbon, < 0,25% C, < 400 N/mm2

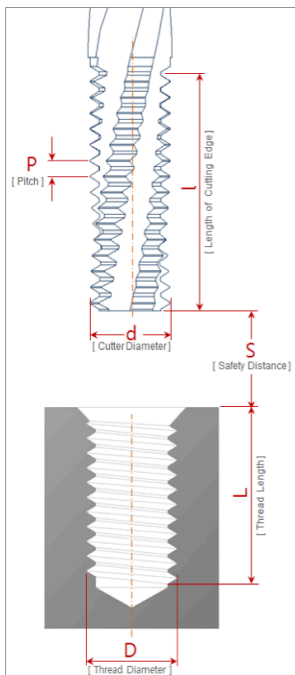
G16159C43.5 14BSP H 1835230320

Number of Passes, Axial	1
Number of Passes, Radial (max 2)	1
d = Cutter Diameter (mm)	15.9
l = Length of Cutting Edge (mm)	43.5
z = Number of Flutes	5
V = Cutting Speed (m/min)	100
Fz = feed/tooth (mm/tooth)	0.070
N = Spindle Speed (rpm)	2,002
FD = feed at Thread Diameter (mm/min)	701
Fd = feed in Center of Mill (mm/min)	169
T = Time to Mill the Thread (seconds)	10



English

UNIT : METRIC



CNC program for Fanuc

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G90 G00 G57 X0. Y0. M3 S2002
G43 H10 Z3. M8
G91 G00 Z-13.454
G41 G01 D10 X0. Y-9.389 F51
G03 X10.568 Y9.389 Z0.454 R9.455
G03 X0. Y0. Z1.814 I-10.568 J0. F169
G03 X-10.568 Y9.389 Z0.454 R9.455
G00 G40 X0. Y-9.389
G00 Z10.732
G90 G00 Z200. M9
M5
M30
          
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