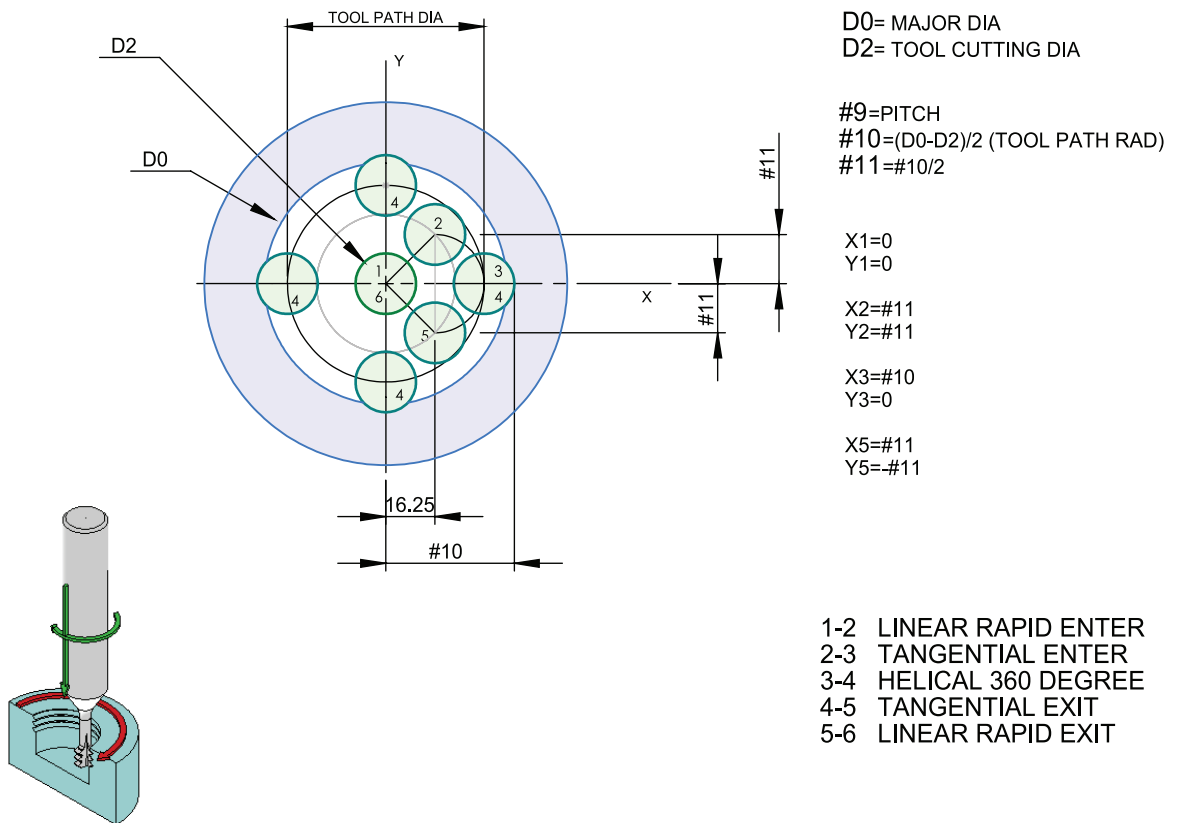


# CNC THREAD MILLING PROGRAM



## PARAMETRIC CNC PROGRAM SAMPLE

*INTERNAL RIGHT HAND THREAD CONVENTIONAL MILLING FROM TOP TP BOTTOM*

```

program no..... O0010 ( TMM CONVENTIONAL MILLING)
go to origi x0 y0 ..... G90 G00 G54 G17 G94 X0 Y0 S.....
tool length compensation on..... G43 H10 Z30.0 M08
go to origin point z0..... G90 G01 Z0 F1000
tool diameter compensation on..... G91 G42 D50 X(#11) Y(#11) Z0
tangential arc enter..... G02 X(#11) Y-(#11) Z-(#9/8) I0 J-(#11) F.....
one helical interpolation..... G02 X0 Y0 Z-(#9) I-(#10) J0 F.....
tangential arc exit..... G02X-(#11) Y-(#11) Z-(#9/8)
tool diameter compensation off ,go to origin point x0 y0 z-(pitch)..... G01G40X(-#11) Y#(11) Z0 F1000
tool length compensation off..... G90 G49 G00 Z30.0
end program ..... M30
    
```