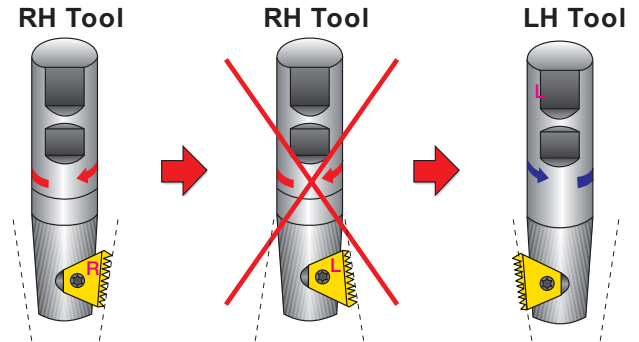


Tip 1

Use RH & LH TM toolholders correctly

- Since conical inserts are ground with the 1°47' conical angle, just switching the conical TM insert to the second cutting edge will give you the WRONG angle.
- To use the 2nd cutting edge, you must also switch from a RH to LH toolholder.
- In a RH toolholder, place the insert with the "R" mark on top; with the LH tool holder, place the "L" mark on top.

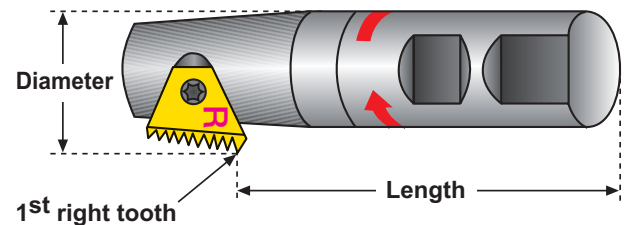


Tip 2

How to preset a conical tool when using the TM Gen CNC program

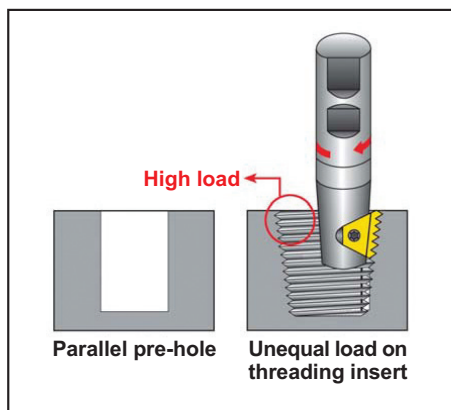
The coordinates of the CNC program generated by the TM Gen use the 1st tooth on the right of the insert as the reference point:

- Tool length should be measured at the 1st right tooth of the insert.
- Tool diameter should be measured at the 1st right tooth of the insert.

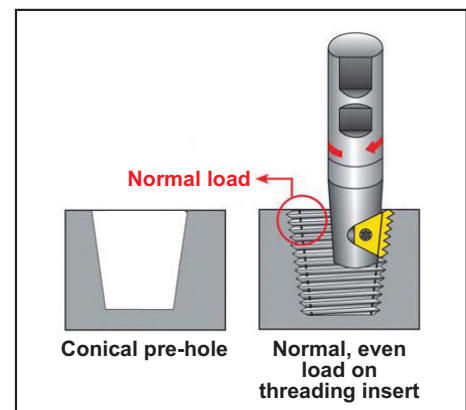


Tip 3

Reduce the cutting load with a conical pre-drilled hole



When a tapered thread is produced in a pre-drilled **parallel** hole, the TM insert absorbs high, unequal cutting forces. More material is removed at the upper end of the conical hole, and the unequal distribution causes premature wear of the insert.



With a **conical** pre-hole, the load on the threading insert is reduced and more evenly distributed, increasing tool life.

For tool selection and cutting data in Thread Turning applications use our **TT Gen**.
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