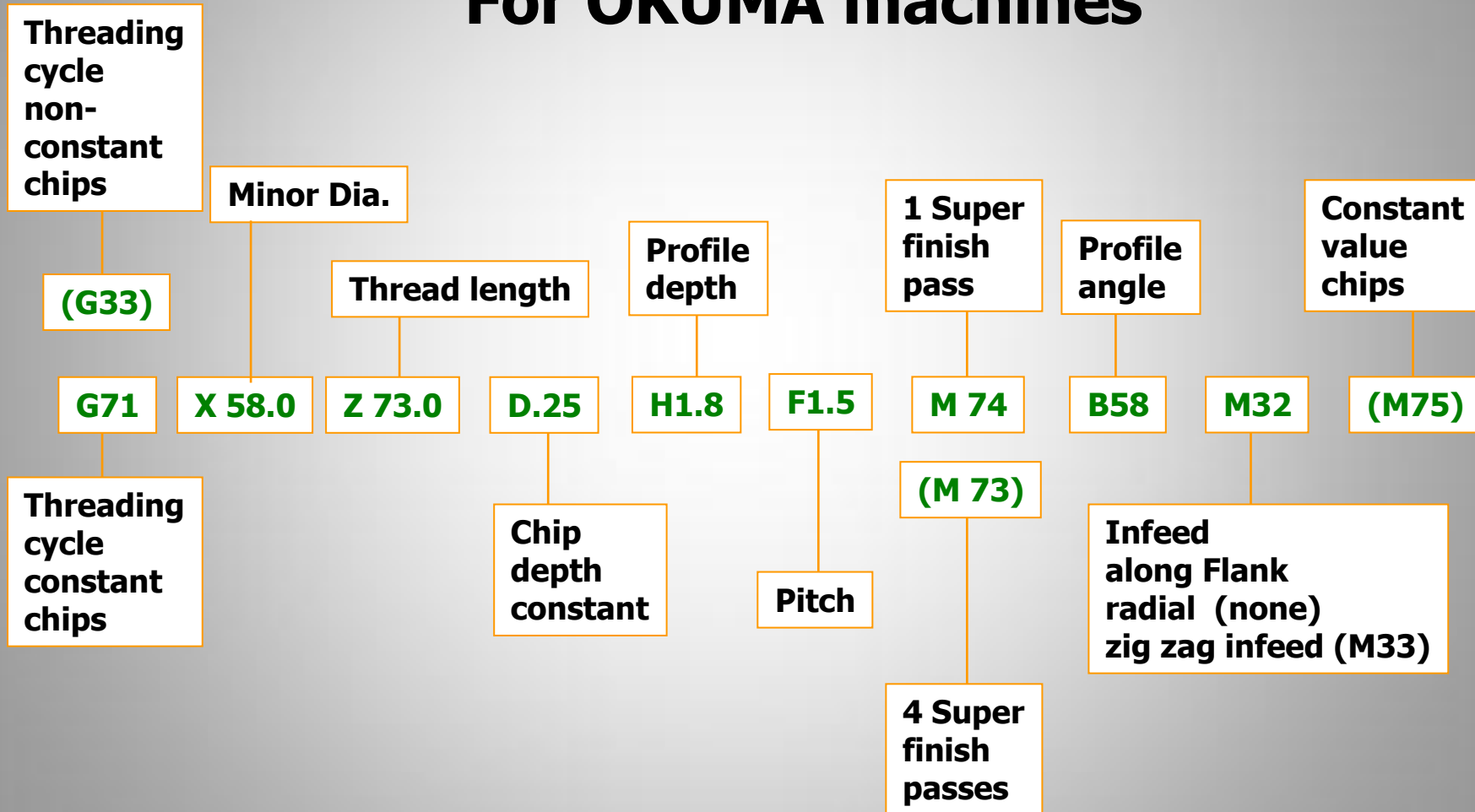


Parallel Threading cycle subroutine For OKUMA machines



Conical Threading cycle subroutine For OKUMA machines

Threading cycle non-constant chips

Minor Dia.

Thread length

Taper Angle

(G33)

A 1.783

Profile depth

1 Super finish pass

Profile angle

Constant value chips

G71

X 58.0

Z 73.0

I 2.273

D.25

H1.8

F1.5

M 74

B58

M32

(M75)

Threading cycle constant chips

Difference In Radius Between Start And End Point

Chip depth constant

Pitch

(M 73)

4 Super finish passes

Infeed along Flank radial (none)
zig zag infeed (M33)