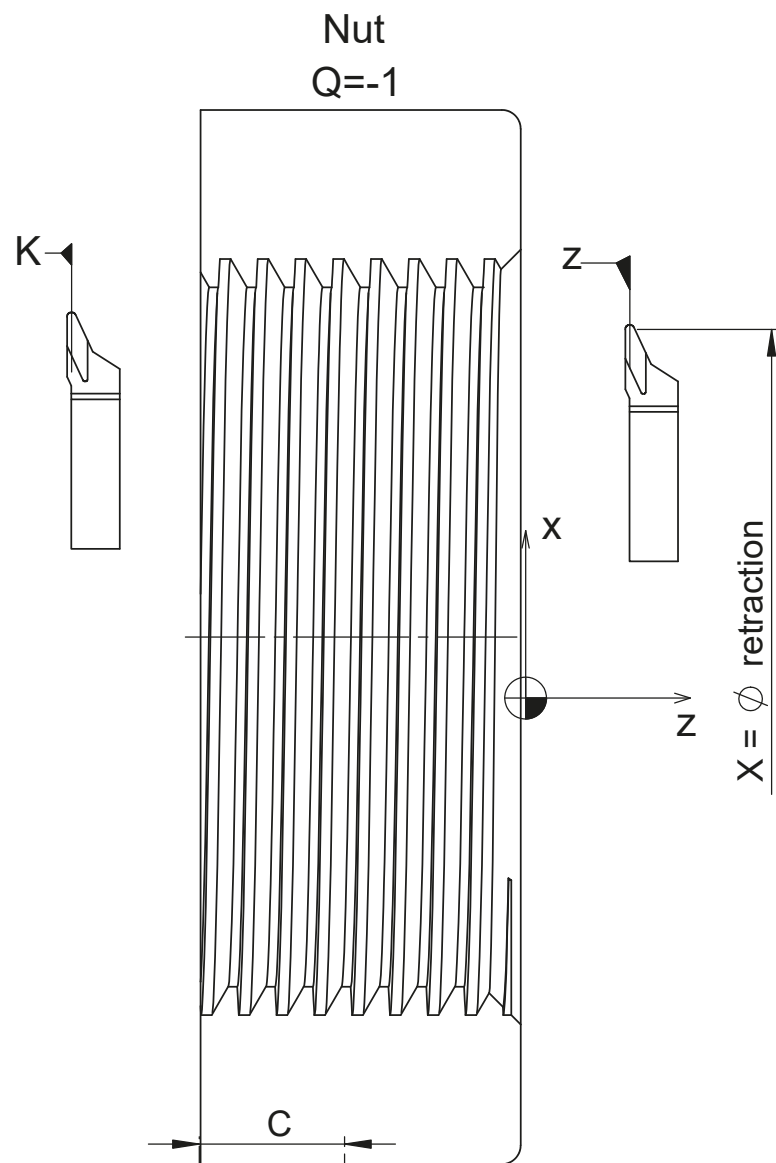
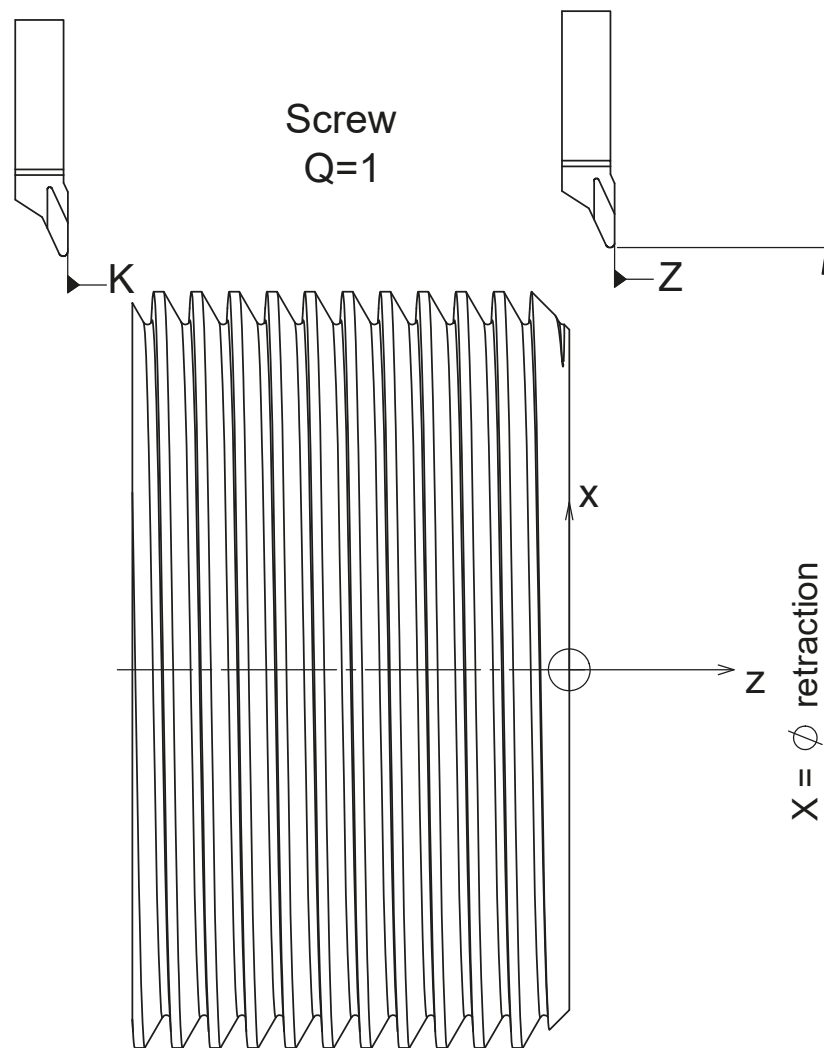




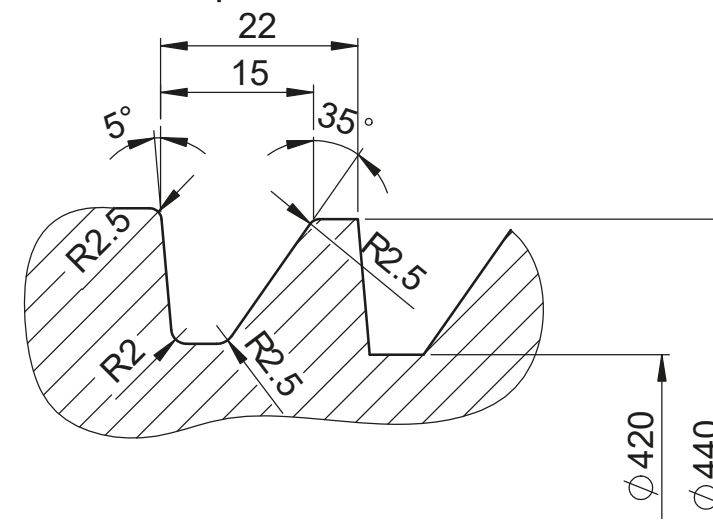
Screw
Q=1



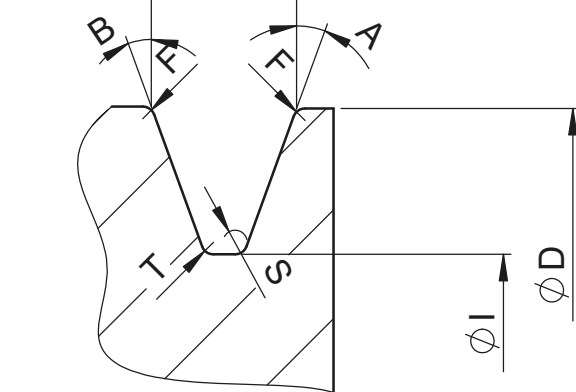
Parameters list

D= CREST DIAMETER
I= ROOT DIAMETER
R= TOOL NOSE RADIUS
U= DIAMETRAL CUTTING DEPTH
W= THREAD PITCH
Z= Z COORDINATE STARTING POINT
J= TAPERED
K= Z COORDINATE FINISHING POINT
X= X CLEARANCE COORDINATE
A= FLANK ANGLE SIDE 1
B= FLANK ANGLE SIDE 2
C= LENGTH THREAD GROOVE AT CREST DIAMETER
E= FLAT STROKE TOOL WIDTH ONLY FOR FINISHING WHERE A TOOL WITH A FLAT STROKE IS USED
F= EXTERNAL CORNER RADIUS SIDE 1 AND SIDE 2
S= FLOOR RADIUS SIDE 1
T= FLOOR RADIUS SIDE 2
Q= -1=INTERNAL THREAD 1= EXTERNAL THREAD
H= MACHINING OPERATION 1=ROUGHING 2=FINISHING
M= % TOOL NOSE ENGAGEMENT INS./PROFILE PEAK HEIGHT (Rp)
Y= SIDE ALLOWANCE (ONLY FOR ROUGHING)
V= FLOOR ALLOWANCE (ONLY FOR ROUGHING)

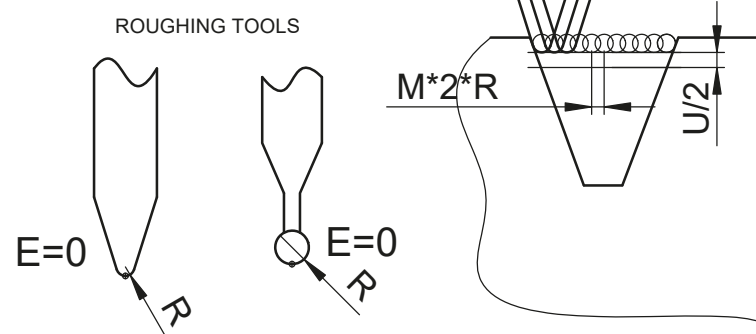
Example:



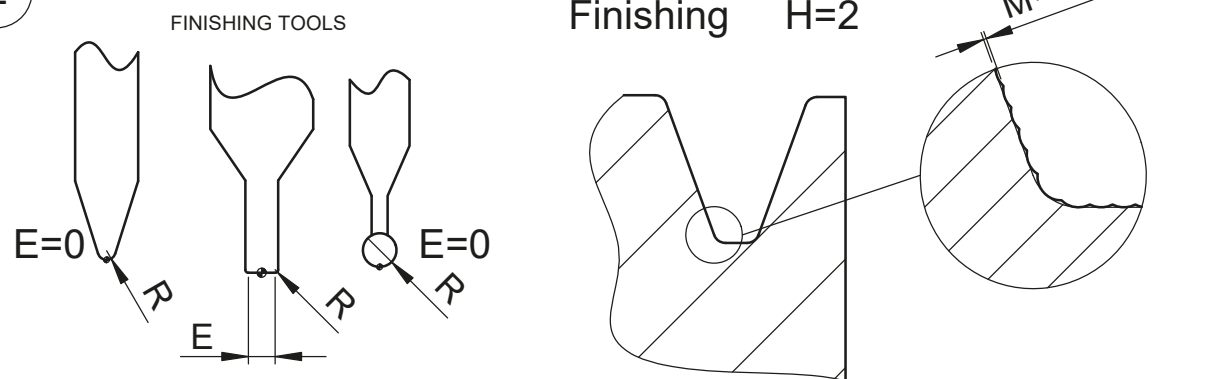
(ROUGHING)
G65P8027D440I420A35B5C15R1.2U0.3W22Z25K100Q1H1M0.7X460S2.5T2F2.5Y0.3V0.1
(FINISHING)
G65P8027D440I420A35B5C15R1.2W22Z25K100Q1H2M0.02X460S2.5T2F2.5



Roughing H=1



Finishing H=2



							Scala:		Materiale:	
							Non-quoted chamfers 0.5 mm General tolerances: UNI ISO 2768-m			
					Date	Name	Dis. N°:			
				Drawn by:		Ing.P.Zanetti				
				Checked by:						
				Particolare:						
				Large diameter thread						
MOD	DESCRIPTION	DATE	NAME							