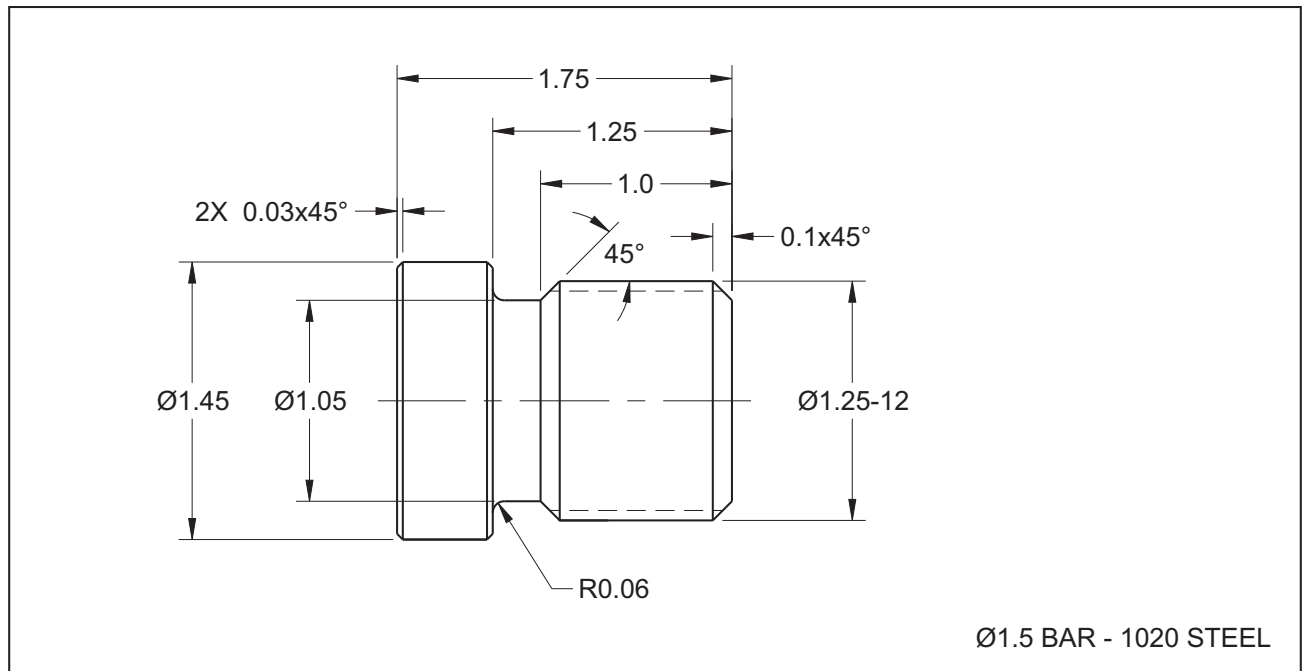


Simple Thread

Possibly the most common thread is a straight right hand thread ending in a recess. In this project, the objective is to exercise four methods of programming such a thread. Although some methods may be old and not commonly used, they sometimes offer benefits in special situations. This project aims at comparing all methods available.



➡ This complete this project, follow these instructions:

1. Program the thread only, using tool number 5 (complete program is optional)
2. Develop four threading programs:

```
O3851 ... use G32 threading method with five threading passes
O3852 ... use G92 threading method with five threading passes
O3853 ... use G76 threading method - one block style
O3854 ... use G76 threading method - two block style
```

 *Reference*

*Chapter 38 Thread Cutting Diameter and Depth
Block-By-Block Threading G32
Basic Threading Cycle G92
Multiple Repetitive Cycle G76*