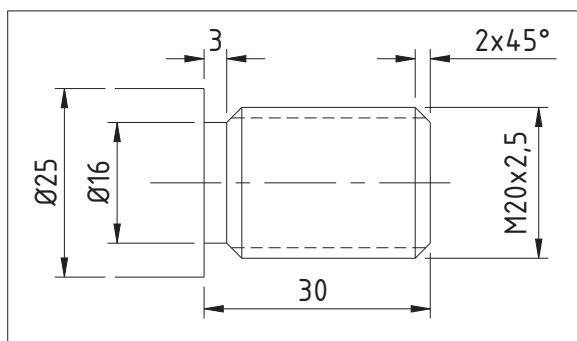


The objective of this questions and answers project is to test general knowledge of single point threading.

#	Question	Answer
1	Describe a pitch in threading:	
2	Describe a lead in threading:	
3	List the three different G-codes used for cutting a single point threading on a CNC lathe	a/ b/ c/
4	Which G-code is always used with threading? G84 G01 G96 G97 G31	
5	In the G76 threading cycle (one block input), describe the meaning of the following addresses:	K/ D/ F/ X/ A/
6	The threading feedrate is always equivalent to the ...	
7	Single point threading feedrate is normally programmed as:	a/ Feedrate per minute b/ Feedrate per revolution c/ Surface speed per minute d/ Maximum machine feedrate
8	Calculate the depth of thread for ... a/ External thread with 18 threads per inch b/ Internal thread with 1.25 mm pitch c/ External thread with 0.25 lead and two starts	a/ b/ c/

9	In the G76 threading cycle (two block input), describe the meaning of the following addresses:	<p>P in the second block ...</p> <p>R in the first block ...</p> <p>Q in the second block ...</p> <p>R in the second block ...</p> <p>The last two digits of P in the first block ...</p>
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10	Complete the program for the single point thread shown above - METRIC dimensions	Use the form below based on the illustration
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➡ Fill-in program data as per **Question 10**:

N38 T5000

N39 _____ S850 M03

N40 _____ M08

N41 G76 X_____ Z_____ I_____ K_____ D_____ F_____ A_____ P_____

N42 _____ X100.0 Z100.0 T0500

N43 M01 (CHECK THREAD)

CHALLENGE - Convert the above program to the two-block G76 input, using the same data.