

Although a single point threading is quite a common operation on CNC lathes, most threads are 'normal', with a single start. This threading project compares four different threading programs, using single and multiple start threads. All other operations have been completed in *Project 35-05*.

➡ To develop the part program, follow these conditions:

1. Develop or use program as described in *Project 35-05*
2. Write a program for single point threading with *one start* - use one-block G76 format
3. Write a program for single point threading with *two starts* - use one-block G76 format
4. Write a program for single point threading with *three starts* - use one-block G76 format
5. Write a program for single point threading with *four starts* - use one-block G76 format

