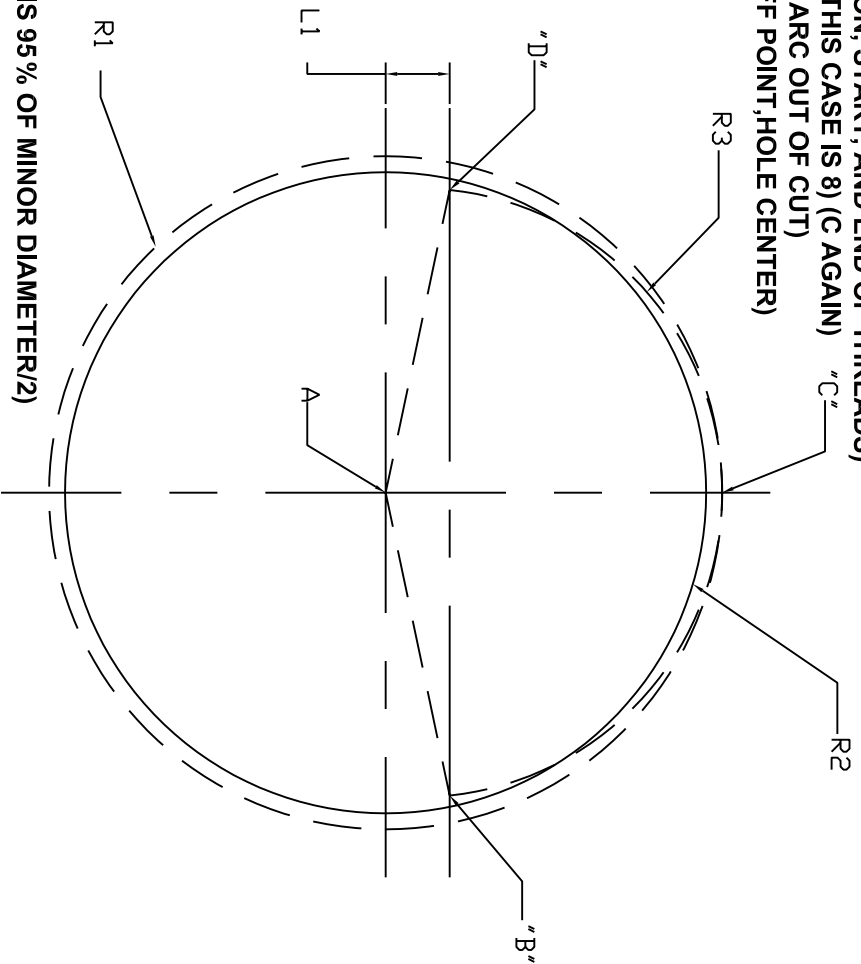


THREAD MILL PROGRAM EXAMPLE FOR A 1"-8 THREAD

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G00 X0.000 Y0.000 Z1.000 ("A" START POINT POSITION X,Y, & Z, HOLE CENTER)
Z0.100
G01 Z-1.000 F100(THREAD DEPTH)
G41 X0.4156(R3) Y0.0844(L1) D1 F5.0 ("B" COMP ON POINT)
G03 X0.000(A) Y0.500(C) R0.4156(R3) ("C" ARC ON, START, AND END OF THREADS)
G03 J-0.5000(-R1) Z-0.875 (J=R1, Z=1/ PITCH IN THIS CASE IS 8) (C AGAIN)
G03 X-0.4156(-R3) Y0.0844(L1) R0.4156(R3) ("D" ARC OUT OF CUT)
G01 G40 X0.000(A) Y0.000(A) F20 ("A" COMP OFF POINT, HOLE CENTER)
G00 Z1.000
  
```



R1=MAJOR DIAMETER OF THREAD/2
 R1=0.500 (1.000/2=0.500)

R2=MINOR DIAMETER OF THREAD/2
 R2=0.4375 (0.875/2=0.4375)

R3= RADIUS OF ARC ON AND ARC OFF WHICH IS 95% OF MINOR DIAMETER/2
 R3=0.4156 (0.875*0.95)/2=0.4156)

L1=THE DIFFERENCE BETWEEN R3 AND L1)
 L1=0.0844 (0.500-0.4156=0.0844)