
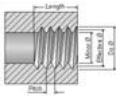


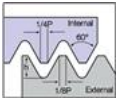





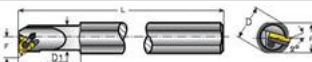







### Thread Turning Summary Report

Application Requested		Thread Data		Tooling	
				Holder	<b>AVR32-3C</b> 
External/Internal	<b>Internal</b>	Actual Pitch	<b>1.000 mm</b>	Insert	<b>3IR1.0ISO</b> 
Right/Left	<b>Right</b>	Taper	<b>No</b>		
Feed Direction	<b>Tail to Chuck</b>	Major Diameter (Do)	<b>40.000 mm</b>		
The Thread - Standard	<b>ISO</b> 	Effective diameter	<b>39.350 mm</b>	Anvil	<b>YI3-1N</b> 
		Minor Diameter (Di)	<b>38.917 mm</b>		
		Helix Angle	<b>0.4635°</b>		
Pitch	<b>1.00 mm</b>			Insert Screw	<b>SA3T</b> 
Do	<b>40.000 mm</b>			Anvil Screw	<b>SY3T</b> 
Length	<b>50.000 mm</b>				
Profile Height	<b>0.577 mm</b>				
Material	<b>Low alloy steel Hardened HB 275</b>			Torx Key	<b>K3CT</b> 
				Clamp	<b>C3</b> 

Holder		Insert		Machining	
				Infeed method	<b>Radial</b> 
Ordering Code	<b>AVR32-3C</b>	Ordering Code	<b>3IR1.0ISO</b>		
Family	<b>Standard with clamp</b>	Style	<b>Standard</b>		
RH/LH	<b>RH</b>	RH/LH	<b>RH</b>		
Insert Size	<b>3/8</b>	Carbide	<b>VTX</b>		
A	<b>29</b>	Insert Size	<b>3/8</b>		
L	<b>250</b>	L	<b>16</b>		
L1	<b>128</b>	h min	<b>0.58</b>		
D	<b>32</b>	X	<b>0.6</b>		
D1	<b>32</b>	Y	<b>0.7</b>		
F	<b>19.6</b>	Min. Bore Dia. For profile	<b>35.020 mm</b>		
Min. Bore Dia.	<b>36</b>				
Helix	<b>1.5°</b>				
Coolant	<b>x</b>				

Operation	
Cutting Speed Vc	<b>75 m/min</b>
Spindle Speed	<b>597 RPM</b>
Type of passes	<b>Modified Volume Chip</b> 
Number of Passes Requested	<b>8</b>
Super Finish	<b>False</b> 
Machine Extra Depth	<b>False</b>

	
Total Passes	<b>8</b>
Total Depth	<b>0.577 mm</b>
Cutting Time	<b>1 min. 20 sec.</b>

Pass Details				
Pass No.	Depth (mm)	Acc.depth	Accumulated. Z	D
P01	0.120	0.120	0.000	39.157
P02	0.099	0.218	0.000	39.354
P03	0.090	0.309	0.000	39.535
P04	0.069	0.378	0.000	39.673
P05	0.058	0.436	0.000	39.790
P06	0.052	0.488	0.000	39.893
P07	0.047	0.535	0.000	39.987
P08	0.043	0.577	0.000	40.072

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