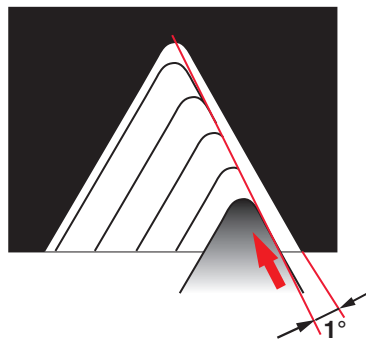


**Threading Tools Troubleshooting**

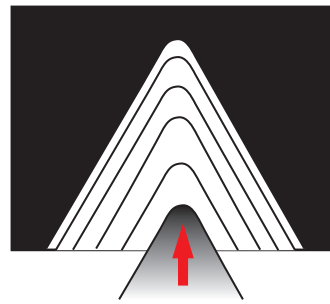
Problems	Causes	Solutions
Built Up Edge	Cutting Forces	Increase the number of passes
	Heat	Use coolant or air blast and a coated tool
	Tool	Use a coated tool
Corner Breakage	Cutting Conditions	Reduce first pass Depth of Cut
	Program	If there is not thread relief, withdraw tool on an angle.
	Part	End in Thread Relief
Chip Wrapping	Tool	The tools should be at least 30% smaller than the hole diameter.
Excessive Flank Wear	Cutting Conditions	Check for excessive speed
	Part	Make sure workhardening did not occur from prior operation
	Tool	Use a coated tool

✓ Recommended



Modified Flank Infeed

⊘ Not Recommended



Radial Infeed

- Notes:
- A radial infeed is not recommended, a modified flank at 1 degree is recommended.
  - For increased length to diameter ratios or difficult to machine materials increase the number of passes by 40%.
  - Depth of cut per pass should not be less than .0003 inch.