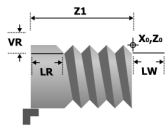


Thread and Tapered Thread

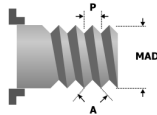
DynaPath WinDelta CNC Lathe · Conversational Programming Quick Guide

The **Thread** event cuts straight or tapered threads on the OD or ID in repeated passes, each one deeper, until the full thread depth is reached. [15.7.1]

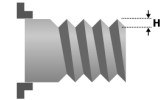
How it runs	Starts at X0, Z0 plus the run-in LW (rounded to a whole number of pitches). First pass at major diameter MAD minus first infeed D1. Feeds to Z1 at one turn per pitch, retracts by VR, returns and goes deeper, until depth H1.
SUGGEST	Calculates thread depth H1 from the tool tip radius and tool angle
Thread repair	Threads always start at 0° spindle orientation. Clamp the part the same way and use the same pitch to pick up an existing thread



Start, run-in LW and retract VR



Major diameter, pitch, angle



Thread depth H1

Parameters Manual 15.7.1

Code	Meaning	Code	Meaning
T	Tool	MAD	Major diameter
P	Pitch	S	Spindle RPM
A	Tool tip angle	NN	Repeat finish (spring) passes
H1	Thread depth (radius value)	SI	OD or ID thread
X0, Z0	Start point	X1	End point X (tapered thread)
Z1	End point Z	LW	Run-in distance
LR	Thread end chamfer	D1	First infeed depth (radius)
D0	Minimum cut depth (radius)	U	Finish allowance (radius)
VR	Retract distance (radius)	CL	Coolant on / off
TIF	Infeed on one flank (G76) or both flanks (G92)		

NOTE H1, D1, D0, U and VR are **radius** values, unlike the X positions, which are diameters.